



# Highland International, Inc.

## Engineered Paint Systems

### 84 Series Phenolic Modified Alkyd Primer

**84 Series** is a single package surface tolerant phenolic modified alkyd primer that is limited to 2.8 lbs. VOC per gallon and features an elaborate system of rust inhibitors to assure outstanding corrosion protection even in rugged climatic environments. It also offers maximum adhesion and corrosion protection in limited surface preparation areas. 84 Series may be topcoated with a wide range of topcoats (silicone alkyds, alkyds, epoxies, urethanes, and acrylics). Its light color allows lead-free orange, yellow and red topcoats to be applied in one coat for proper hiding. This light color scheme is also designed to show shadows in steel surfaces until proper film thickness has been reached to further assure maximum corrosion protection.

<b>Vehicle Type:</b>	Phenolic Modified Alkyd
<b>Pigmentation:</b>	Zinc Phosphate (Lead & Chromate Free)
<b>Reducers for:</b>	
Summer if desired	Highland #100
Winter if desired	Highland #120
<b>Mix Ratio:</b>	Single Package
<b>Pot Life:</b>	Not Applicable
<b>Volume Solids:</b>	61%
<b>Theoretical Coverage:</b>	976 ft <sup>2</sup> /gallon @ 1 mil DFT
<b>VOC:</b>	<335 g/L
<b>Flash Point:</b>	24°F (Lowest Flashing Component)
<b>Recommended DFT:</b>	2-3 mils
<b>Dry-time:</b>	
<b>To Touch</b>	20-30 Minutes
<b>Tack Free:</b>	1 Hour
<b>To Topcoat:</b>	Minimum 1 Hour/Maximum – No Limit
<b>To Handle:</b>	4-6 Hours
<b>Put In Service:</b>	12 Hours
<b>Shelf Life:</b>	1 Year Minimum
<b>Finish:</b>	Flat
<b>Color:</b>	Off-White

#### Surface Preparation

1) Minimum surface preparation should be in accordance with SSPC-SP6 Commercial Blast cleaning. When blast cleaning is not an option, SSPC-SP3 Power Tool or SSPC-SP2 Wire Brushing is acceptable and provides good results. Also, water jetting in accordance with SSPC-SP12 is acceptable.

2) All surfaces to be painted should be dry and free of all foreign contaminants.

#### Application Requirements

1. Stir product thoroughly prior to use.
2. Reduction is not normally required. If desired use Highland #100 in summer or Highland #120 in winter.
3. Apply in 1 coat at a rate of 325 to 488 square feet per gallon to obtain the recommended film thickness in one coat.
4. Topcoat with Highland 865 Series, 840 Series, 150C Series, 65R Series, 36-HF Series or 68R Series.

#### Method of Application

<b>Conventional Gun:</b>	DeVilbiss MBC-510
Fluid Tip:	E
Air Cap:	704
Atomizing Pressure:	60 psi
Pot Pressure:	20 psi
Hose:	½ inch ID
<b>Airless Gun:</b>	Graco 205-591
Pump:	30:1/45:1/60:1, Gas pump acceptable
Tip Range:	3.013 – 4.015
Pump Pressure:	2100 psi minimum
Hose:	3/8 inch ID
<b>Brush or Roller:</b>	Both are acceptable
<b>Clean Up:</b>	Clean all equipment with Lacquer Thinner

#### Safety Precautions

- 1) Use normal precautions such as gloves, facemasks and barrier creams.
- 2) Adequate ventilation must be maintained. In confined areas, workmen must wear constant flow airline respirators.
- 3) If product comes into contact with skin, wash thoroughly with lukewarm water or diluted Boric Acid, and obtain immediate medical attention.
- 4) This product contains **FLAMMABLE** materials. Keep away from sparks and open flames. Observe **NO SMOKING** regulations.
- 5) All electrical equipment and installations should conform to NEC regulations. In areas where explosion hazards exist, workmen should be required to use non-ferrous tools, and to wear conductive, non sparking shoes.
- 6) Observe low flash regulations.
- 7) Refer to Material Safety Data Sheet (MSDS) for complete safety instructions.

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