

335 Series

HiTemp Inorganic Zinc-Rich Primer



335 Series is a self-curing, corrosion-resistant coating with tenacious bonding and abrasion resistance. Its galvanic action resists undercutting. 335 Series exhibits excellent stand-alone performance in high temperature or long-term atmospheric exposures. Finish with specialized Highland Epoxy and/or Urethane topcoats to improve aesthetics, increase long-term performance or protect the primer from attack in aggressive environments.

Tech Specs

Heat Resistance:	750°F Constant w/ Excursions to 950°F
Vehicle Type:	Ethyl Silicate Inorganic Zinc-Rich 88% zinc by weight in dried film
Reducer:	Not Normally Required In summer if desired: Highland #85 Reducer In winter if desired: Highland #75 Reducer
Mix Ratio:	2-Component – Pre-Measured
Pot Life:	12 Hours
Volume Solids:	65%
Theoretical Coverage:	1042ft ² /gal. @ 1 mil DFT
VOC:	<472 g/L
Flash Point:	53°F (Lowest Flashing Component)

Dry Film Thickness:	2-3.5 mils DFT per coat
Wet Film Thickness:	3-4.6 mils WFT per coat
Dry-time in 50% Relative Humidity 75°F:	
To Handle:	1 Hour
To Recoat:	16 Hours
Shelf Life:	2 Years Minimum
Finish:	Flat
Color:	Gray
NOTE:	Color changes from greenish-gray to reddish-gray in temperatures above 450°F
Packaging:	5 gallon pails & 55 gallon drums
Storage Temperature:	20°F - 110°F

Surface Preparation

All surfaces should be clean, dry and free of all foreign contaminants.

A SSPC-SP1 Solvent Cleaning with Highland 901 Cleaning Solvent is recommended before blasting or other cleaning method.

Carbon Steel:

Best: A SSPC-SP 10 Near White Metal Blast to achieve a low blast profile of 1.5-3.0 mils is recommended.

Good: A SSPC-SP6 Commercial Blast will provide good results in most situations.

Galvanized Steel: Contact a Highland representative as recommendation will vary depending on substrate and exposure conditions.

Mixing & Application

Mixing: Highland 335 Series needs to be thoroughly mixed using mechanical agitation. It is ready to spray after proper mixing.

Reduction: Reduction is not required, if desired, reduce by 0% - 10% with Highland 75 or 85 reducer.

Moisture is required to achieve proper cure. Curing time will vary with temperatures and humidity. At relative humidities below 30% it may be necessary to gently spray the coated surface with water to achieve proper cure and to minimize recoat time. Consult your Highland representative for specific recommendations.

Ventilation: When used as a tank lining or in enclosed areas, provide adequate ventilation during application and cure. Reference ventilation guidelines contained in the latest edition of AWWA D 102.

Highland 335 Series is designed for spray application. To ensure optimal performance, apply according to recommendations below.

Conventional Gun:	Binks 62 (1)
Fluid Tip:	E
Air Cap:	67 PD
Atomizing Pressure:	30-40 psi
Pot Pressure:	10-20 psi
Air Hose:	5/16" or 3/8" ID
Material Hose:	3/8" or 1/2" ID

Brush or Roller:	Touch Up Only
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Clean Up:	Highland #901 Cleaning Solvent
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Typical Systems

Highland 335 Series may topcoated with variety of Highland Topcoats:

Contact your Highland Rep. for topcoat recommendation

Safety Information

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

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