



# Highland International, Inc.

## Engineered Paint Systems

### HiTemp 812-LH Black 600°F Silicone Copolymer DTM/Topcoat

HiTemp 812-LH Series is a silicone alkyd high heat coating effective on steel surfaces up to 600°F.

<b>Vehicle Type:</b>	Silicone Alkyd
<b>Pigmentation:</b>	Heat Stable Black Iron Oxide
<b>Reducer:</b>	Not Normally Required
<b>Mix Ratio:</b>	Single Package
<b>Pot Life:</b>	Not Applicable
<b>Volume Solids:</b>	51%
<b>Theoretical Coverage:</b>	816 ft <sup>2</sup> /gal. @ 1 Mil DFT
<b>Flash Point:</b>	19°F (Lowest Flashing Component)
<b>Recommended DFT:</b>	3-5 mils as a DTM 2-3 mils as a Topcoat

#### Dry-time:

<b>To Touch:</b>	30 minutes
<b>Tack Free:</b>	2 Hour
<b>To Recoat:</b>	1 Hours
<b>To Handle</b>	3-4 Hours
<b>Put in Service:</b>	12 Hours

<b>VOC:</b>	<370 g/L
<b>Shelf Life:</b>	1 Year from DOM
<b>Finish:</b>	Flat
<b>Color:</b>	Black

#### Surface Preparation

- 1) All surfaces to be painted should be dry and free of all foreign contaminants.
- 2) Minimum acceptable surface preparation should be in accordance with SSPC-SP6 Commercial Blast.
- 3) A low profile blast (1.5 to no more than 2 mils) is preferred.
- 4) Apply directly to steel in two coats to achieve proper DFT or apply over #830 or #860 HiTemp Primer for temperatures up to 450°F.  
For extra durability and corrosion protection apply over #47 Chem-Temp Hybrid Epoxy Novolac for temperatures up to 500°F.

#### Mixing and Application Requirements

- 1) Stir product thoroughly prior to use
- 2) Apply at a rate of 204-272 square feet per gallon to obtain the recommended film thickness when using as a DTM.
- 3) Apply at a rate of 272-408 square feet per gallon to obtain the recommended film thickness when using as a topcoat.

**SPECIAL NOTES:** When using as a topcoat apply no more than 2-3 mils DFT. To prevent delamination and/or gas bubbles do not exceed a total dry film thickness of 5 mils when applying as a topcoat or DTM.

#### Method of Application

<b>Conventional Gun:</b>	DeVilbiss MBC-510
Fluid Tip:	E
Air Cap:	704
Atomizing Pressure:	60 psi
Pot Pressure:	15-20 psi
Hose:	3/8 inch ID
<b>Airless Gun:</b>	Graco 205-591
Pump:	30:1/45:1/60/1, Gas Pump is Acceptable
Tip Range:	3.011 – 4.013
Pump Pressure:	1800 psi minimum
Hose:	3/8 inch ID
Brush or Roller:	Touch Up Only
Clean Up:	Clean all equipment 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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