

84-DF Series

Spray Safe Dry-Fall Phenolic Modified Alkyd Primer



84-DF Series is a single package surface tolerant phenolic modified alkyd primer that 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-DF Series may be topcoated with a wide range of topcoats (silicone alkyds, alkyds, epoxies, urethanes, and acrylics). Its overspray is designed to dry to a powder within 10-20 feet from point of application. Its light color allows 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. Finally, it features an open topcoat window which allows for flexible application schedules.

Tech Specs

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| Heat Resistance: | For Ambient Services Only |
| Vehicle Type: | Phenolic Modified Alkyd |
| Reducer: | 20% Reduction is required to achieve dry-fall properties |
| In summer (above 80°F): | Highland #30-E Reducer |
| In Winter: (below 80°F): | Highland #32-E Reducer |
| Mix Ratio: | Single Package |
| Pot Life: | N/A |
| Volume Solids: | 61% |
| Theoretical Coverage: | 978ft ² /gal. @ 1 mil DFT |
| VOC: | <335 g/L (2.8 lbs/gallon) |
| Flash Point: | 24°F (Lowest Flashing Component) |
| Dry Film Thickness: | 2-3 mils DFT |

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|-----------------------------|---------------------------------|
| Wet Film Thickness: | 4.1-6.1 mils WFT |
| Dry-time: | Normal |
| To Touch: | 20-30 Minutes |
| Tack Free: | 1 Hour |
| To Recoat: | Minimum 1 Hour/Maximum No Limit |
| To Handle: | 4-6 Hours |
| Put in Service: | 12 Hours |
| Shelf Life: | 2 Years Minimum |
| Finish: | Flat |
| Color: | Off-White |
| Packaging: | 5 Gallon Pails |
| 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-SP6/NACE 3 Commercial Blast Cleaning or better is recommended for maximum coating performance and longevity.

Good: A SSPC-SP3 Power Tool Cleaning, SSPC-SP2 Hand Tool Cleaning, or waterjetting per SSPC-SP 12 to WJ-4 will provide good results.

Galvanized Steel:

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

Mixing & Application

Mixing: Highland 84-DF Series needs to be thoroughly mixed using mechanical agitation. It is ready to spray after proper mixing and reduction.

Reduction: Reduction is required to achieve dry-fall properties reduce by 20% with Highland 30-E reducer in temperatures 80°F and above or 32-E reducer in temperatures 80°F and below.

Highland 84-DF Series is designed for spray application. To ensure optimal performance and dry-fall properties, apply according to the following recommendations.

Airless

Gun: Graco 205-591 (or equivalent)

Pressure: Apply at 1800psi allowing for +/- 25 psi for surges

Tip sizes: 3.011-4.013

Airless Pumps: 30:1, 45:1, 60:1 (Gas Pumps are acceptable)

Hose: 3/8 inch ID

Brush or Roller: Both are acceptable

Clean Up: Clean all equipment with Highland #901 Cleaning Solvent

Typical Systems

Highland 84-DF Series may topcoated with variety of Highland Topcoats:

Apply 1 coat of 84-DF Series at 2-3 mils DFT as a primer then topcoat with one of the following options.

65R Series Topcoat

Dry-Fall gloss acrylic

68R Series Topcoat

Dry-Fall high gloss urethane

840 Series Topcoat

Dry-Fall satin finish silicone alkyd

150BR Series Topcoat

Non Dry-Fall Brush & Roll High gloss single component alkyd

150C Series Topcoat

Non Dry-Fall High gloss single component alkyd

865-LH Series Topcoat

Non Dry-Fall High gloss single component silicone alkyd

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