

# 815 Series HiTemp Dry-Fall Acrylic Silicone Copolymer Topcoat



815 Series Topcoat is a single package acrylic silicone copolymer topcoat designed to provide excellent color stability and corrosion protection for surfaces up to 500°F for all standard and custom colors. 815 Series provides long lasting color retention when used on areas that see temperatures up to 500°F. It will provide corrosion protection to surfaces up to 800°F, and color stability to 800°F for black, aluminum, and a limited number of gray colors. 815 Series is also available in a Dry-Fall formula, and does not require a heat cure.

## Tech Specs

<b>Heat Resistance:</b>	500°F Constant w/ Excursions to 800°F
<b>Color Stability:</b>	500°F for Standard & Custom Colors 800°F for Black, Aluminum, and Select Grays
<b>Vehicle Type:</b>	Acrylic Silicone Copolymer
<b>Reducer - Standard:</b>	Not Normally Required In summer if desired: Highland #100 Reducer In winter if desired: Highland #120 Reducer
<b>Reducer - Dry-Fall:</b>	Required for Dry-Fall Effect In summer (above 80°F): Highland #30-E Reducer In winter: (below 80°F): Highland #32-E Reducer
<b>Mix Ratio:</b>	Single Package
<b>Pot Life:</b>	N/A
<b>Volume Solids:</b>	50% ± 2%
<b>Theoretical Coverage:</b>	802ft <sup>2</sup> /gal. @ 1 mil DFT
<b>VOC:</b>	<418 g/L
<b>Flash Point:</b>	65°F (Lowest Flashing Component)
<b>Dry Film Thickness:</b>	2-3 mils DFT

<b>Wet Film Thickness:</b>	4-6 mils WFT
<b>Dry-time:</b>	<b>Normal</b> To Touch: 15 Minutes Tack Free: 1 Hour To Recoat: 1-2 Hours To Handle: 1-2 Hours Put in Service: 12 Hours No Heat Cure Required
<b>Shelf Life:</b>	2 Years Minimum
<b>Finish:</b>	Eggshell
<b>Color:</b>	Standard & Custom
<b>Packaging:</b>	5 gallon pails
<b>Storage Temperature:</b>	20°F - 110°F
<b>Application Temp:</b>	Ambient: 45°F Minimum Substrate: 40°F - 140°F
<b>Hot Application:</b>	Up to 400°F Using Highland #101a reducer – Contact Highland for application recommendations.

## Surface Preparation

All surfaces should be clean, dry and free of all foreign contaminants. Apply over Highland approved primer. Consult Highland technical data sheet for recoat windows on approved primer before application. See typical systems for primer options.

## Mixing & Application

**Mixing:** Highland 815 Series needs to be thoroughly mixed using mechanical agitation. It is ready to spray after proper mixing.

**Reduction for Standard Applications :** Reduction is not required for standard applications, if desired, reduce by 0% - 10% with Highland 100 or 120 reducer.

**Reduction for Dry-Fall "Spray-Safe" Applications:** Highland 815 Series must be reduced 15%-20% with Highland 30-E or 32-E reducer to achieve the dry-fall effect. Surface temperatures should not exceed 140°F when using 815 Series in a dry-fall application.

**Dry-Fall Application Instructions:** To assure Dry-Fall effect, do not apply in temperatures below 45°F, on surfaces below 40°F, or humidity above 85% Rh. When humidity is above 50%, take caution to observe the dry-fall range as it may extend slightly past the 20 foot mark, up to 50 feet depending on other weather variables. Make sure the equipment being used will give accurate psi readings so the pressure from the pump can be maintained at 1800 psi allowing a maximum +/- 25 psi for surges. Do not apply in temperatures that are 5°F or less from the dew point.

Highland 815 Series is designed for spray application. To ensure optimal performance, apply according to recommendations below.

### Standard Applications (Non-Dry-Fall)

**Airless Gun:** Graco 205-591  
**Pump:** 30:1/45:1/60:1  
**Tip Range:** 3.011 – 4.015  
**Pump Pressure:** 2,100 psi Minimum  
**Hose:** 3/8 inch ID

**Brush or Roller:** Touch Up Only

**Conventional Gun:** DeVilbiss MBC-510  
**Fluid Tip:** E  
**Air Cap:** 704  
**Atomizing Pressure:** 60 psi  
**Pot Pressure:** 20 psi  
**Hose:** 1/2 inch

**Clean Up:** Highland #901 Cleaning Solvent

### Dry-Fall Spray-Safe Applications

**Airless Gun:** Graco 205-591  
**Pump:** 30:1/45:1/60:1  
**Tip Range:** 3.011 – 4.015

**Pump Pressure:** 1800 psi +/- 25 psi for surges  
**Hose:** 3/8 inch ID  
**Clean Up:** Highland #901 Cleaning Solvent

## Typical Systems

Highland 815 Series may be applied over a variety of Highland Primers:

### Standard Application Options:

**860-HF Series Primer** For high temperature areas up to 400°F  
**47-HF Series Primer** For added corrosion resistance in high temperature areas up to 400°F  
**802 Series Primer** For high temperature areas up to 500°F (600°F for black, aluminum, and select grays)  
**827-HB Series Primer** For a high build option in areas up to 500°F (800°F for black, aluminum, and select grays)  
**15-ZN Series Primer** For cathodic protection in areas up to 500°F (800°F for black, aluminum, and select grays)

### Dry-Fall Application Options:

**830 Series Primer** For high temperature areas up to 400°F  
**827-HB Series Primer** For a high build option in areas up to 500°F (800°F for black, aluminum, and select grays)  
**15-ZN Series Primer** For cathodic protection in areas up to 500°F (800°F for black, aluminum, and select grays)

## 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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