84 Series

Phenolic Modified Alkyd Primer

84 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 Series may be topcoated with a wide range of topcoats (silicone alkyds, alkyds, epoxies, urethanes, and acrylics). 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. This versatile coating is perfect for cold feed bins cold conveyors silos, and more. It is also available in a Dry-Fall "Spray Safe" formulation and has an open topcoat window.

Tech Specs

Heat Resistance:	For Ambient Services Only
Vehicle Type:	Phenolic Modified Alkyd
Reducer:	Not Normally Required
In summer if desired:	Highland #100 Reducer
In Winter if desired:	Highland #120 Reducer
Mix Ratio:	Single Package
Pot Life:	N/A
Volume Solids:	61%
Theoretical Coverage:	976ft^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

Wet Film Thickness:	3.5-5 mils WFT
Dry-time:	Normal
To Touch:	20-30 Minutes
Tack Free:	1 Hour
To Recoat:	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 & 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-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 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 100 or 120 reducer.

Highland 84 Series is designed for spray application. To ensure optimal performance, apply according to the following recommendations.

Airless
Gun: Graco 205-591 (or equivalent)
Pressure: Apply at 2100psi to achieve an even fan pattern.
Tip sizes: 3.013-4.015
Airless Pumps: 30:1, 45:1, 60:1 or Gas Pumps are recommended
Hose: 3/8 inch ID

Brush or Roller: Both are acceptable

Conventional
Gun: DeVilbiss MBC-510 (or equivalent)
Fluid Tip: E
Atomizing Pressure: 60 psi
Pot Pressure: 20 psi
Hose: 3/8 inch ID
Clean Up: Clean all equipment with Highland #901 Cleaning Solvent

Typical Systems

Highland 84 Series may topcoated with variety of Highland Topcoats:
Apply 1 coat of 84 Series at 2-3 mils DFT as a primer then topcoat with one of the following options.

150C Series Topcoat	High gloss single component alkyd
865-LH Series Topcoat	High gloss single component silicone alkyd
840 Series Topcoat	Dry-Fall satin finish silicone alkyd
65R Series Topcoat	Dry-Fall gloss acrylic
68R Series Topcoat	Dry-Fall high gloss urethane

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