



# Highland International, Inc.

## Technical Data Sheet



### 325 Series HiZinc Zinc Rich Epoxy Primer

325 Series HiZinc is a High Performance 2-Component zinc rich epoxy primer. It offers outstanding abrasion resistance and protection against undercutting and corrosion by cathodic protection.

<b>Vehicle Type:</b>	Zinc Rich Epoxy Primer	<b>Dry-Time:</b>	<b>Normal Application</b>	<b>Hot Application</b>
<b>Pigmentation:</b>	Zinc Dust	<b>To Recoat</b>	Min 2-3 Hrs (Max 28 Days)	N/A
<b>Reducers:</b>	Not normally required	<b>To Touch</b>	30 Minutes	N/A
<b>If desired (up to 20%):</b>	30-E for 80°F and above	<b>To Handle</b>	3 Hours	N/A
<b>If desired (up to 20%):</b>	32-E for below 80°F	<b>Complete Cure</b>	5-7 Days @ 77°F	N/A
<b>Mixing Ratio:</b>	9:1 Base to Acitvator	<b>Topcoats</b>	Epoxies and/or Urethanes only	
<b>Pot Life:</b>	4 Hours @ 77°F(decreases at higher temps)	<b>V.O.C.:</b>	2.8 lbs per gallon	
<b>Volume Solids:</b>	50% (+/- 1%)	<b>Shelf Life:</b>	1 Year Minimum	
<b>Theoretical Coverage:</b>	800 Sq ft. per mil per gallon	<b>Finish:</b>	Flat	
<b>Flash Point:</b>	lowest flashing component -8°F	<b>Color:</b>	Yellow-Gray	
<b>Recommended DFT:</b>	3-4 mils for very good corrosion protection in moderate conditions			
<b>Recommended WFT:</b>	6-8 mils wet (no reduction) will achieve 3-4 mils DFT			

**Preparation:** For immersion, a SSPC-SP5 White Metal Blast is required. A minimum Commercial Blast, SSPC-SP6 is recommended. Where blast cleaning is not practical, SSPC-SP3 Powertool or SSPC-SP2 Wire Brushing is acceptable and provides excellent results. Also, water jetting to WJ4 in accordance with SSPC-SP12 is acceptable. All surfaces to be painted should be dry and free of all foreign contaminants.

**Application Requirements:** **1)** Mix entire contents of part "A" Activator with Part "B" Base (9 to 1 by volume) **2)** Mixed material is ready for use after a 20 minute induction period. **3) Reduction:** If desired, reduce up to 20% with the proper reducer **after** the 20 minute induction period. **4)** Apply at a rate of 200 to 267 square feet per gallon to obtain the recommended film thickness. **5)** Topcoat with Highland's #185 Series, #64 Series, #36 Series, or #68 Series. **6)** May see normal service after 24 hours.

**The following spray equipment is suitable for applying this coating. \*\*\* It is also necessary to keep the material under mild agitation during the application. If spraying stops for more than 10 minutes, recirculate the material remaining in the spray line. Do not leave mixed primer in the hoses during work stoppages.**

Method of Application:	Conventional Spray	Airless Spray:	
<b>Gun:</b>	DeVilbiss MBC-510	<b>Gun:</b>	Graco 205-591
<b>Fluid Tip:</b>	E	<b>Pump:</b>	30:1
<b>Air Cap:</b>	704	<b>Tip Range:</b>	.015" to .019" @ 1800 psi
<b>Atomizing Pressure:</b>	70 psi	<b>Hose:</b>	3/8 inch ID (Do not use whip lines)
<b>Pot Pressure &amp; Hose:</b>	15-20 psi 1/2" ID		
<b>Brush or Roller:</b>	touch up only	<b>Clean Up:</b>	30-E or 32-E or 1:1 mix of Xylene & MEK

**Safety Precautions:** (a) Use normal precautions such as gloves, facemasks, and barrier creams. (b) Adequate ventilation must be maintained. In confined areas, workmen must wear constant flow airline respirators. (c) If product comes into contact with skin, wash thoroughly with lukewarm water or diluted Boric Acid, and obtain immediate medical attention. (d) This product contains **FLAMMABLE** materials. Keep away from sparks and open flames. Observe **NO SMOKING** regulations. (e) 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. (f) Observe low flash regulations. (g) Refer to Material Safety Data Sheet (MSDS) for complete safety instructions.

The technical data listed herein has been compiled for your convenience and guidelines and is based upon our experience and knowledge. However, since we have no control over the use of this information or this product, no warranty express or implied is intended or given. Highland assumes no responsibility whatsoever for coverage, performance or any other damage, including injuries from use of this information of products recommended herein.

However, when applied according to manufacturers specifications, these products will perform as indicated.

P. O. Box 3564 Boone, NC 28607

800-444-1438

www.highland-international.com

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