ENDURATONE® SERIES 1028

PRODUCT PROFILE

**GENERIC DESCRIPTION**
HDP Acrylic Polymer

**COMMON USAGE**
Water-based, low VOC, High Dispersion Pure acrylic polymer coating providing excellent long term protection in both interior/exterior exposures. May be applied by spray, brush or roller over a variety of solvent and waterborne steel primers. May also be used over many aged coatings. It is mildew resistant and exhibits very good gloss and color stability. Application methods include “dry-fall” under certain conditions (See Application). **Note:** Series 1028’s “dry-fall” characteristics help to reduce the potential for overspray problems on buildings and surrounding property.

**COLORS**
Refer to Tnemec Color Guide. **Note:** Certain colors may require multiple coats depending on method of application and finish coat color. When feasible, the preceding coat should be in the same color family (blue, gray, etc.), but noticeably different.

**FINISH**
Gloss - **Note:** Final gloss level of topcoat can vary depending on number of coats applied. One coat will generally result in a lower sheen than two coats of the material.

**COATING SYSTEM**

**PRIMERS**
Wood: Series 10-99W, V10-99W or 151-1051

Concrete: Self-priming or Series 6, 54, 66, L69F, N69, N69F, V69, V69F, 150, 151, 156, 180, 287, 1254
CMU: Series 54, 150, 1254
Drywall: Series 51, 151-1051, 287

**TOPCOATS**
Series 1029, 1080, 1081

**SURFACE PREPARATION**

**STEEL**
Weather Exposed: SSRC-SP6 Commercial Blast Cleaning. Enclosed, Protected & Mild Environments: SSRC-SP2 Hand Tool or SSRC-SP3 Power Tool Cleaning. Surface preparation recommendations will vary depending on substrate and exposure conditions. Consult the latest version of Tnemec Technical Bulletin 10-78 or contact your Tnemec representative or Tnemec Technical Services.

**GALVANIZED STEEL & ALUMINUM**

**PAINTED SURFACES**
Remove chalk and old paint not tightly bonded to the surface. Clean all visible rust using SSRC-SP3 Power Tool Cleaning (interior dry) or to bare metal using SSRC-SP11 Power Tool Cleaning to Bare Metal (weather exposed).

**PRIMED SURFACES**
Must be clean, dry and free of dust, dirt, oil, grease and other contaminants. Existing water soluble stains in the substrate (interior/exterior) or upon the surface must be removed or sealed. Allow new concrete to cure 28 days.

**TECHNICAL DATA**

**VOLUME SOLIDS**
40.0 ± 2.0% †

**RECOMMENDED DFT**
2.0 to 3.0 mils (50 to 75 microns) per coat.

<table>
<thead>
<tr>
<th>Temperature (°F)</th>
<th>To Touch</th>
<th>To Handle</th>
<th>To Recoat</th>
<th>To Resist Moisture</th>
</tr>
</thead>
<tbody>
<tr>
<td>75°F (24°C)</td>
<td>30 minutes</td>
<td>2 hours</td>
<td>2 hours</td>
<td>6 hours</td>
</tr>
</tbody>
</table>

Curing time varies with surface temperature, air movement, humidity and film thickness.

**YOLETILE ORGANIC COMPOUNDS**
Unthinned: 0.79 lbs/gallon (94 grams/litre)
Thinned 5%: 0.79 lbs/gallon (94 grams/litre) †

**HAPS**
Unthinned: 0.35 lbs/gal solids
Thinned 5%: 0.35 lbs/gal solids

**THEORETICAL COVERAGE**
655 mil sq ft/gal (15.5 m²/L at 25 microns). See APPLICATION for coverage rates. †

**NUMBER OF COMPONENTS**
One

**PACKAGING**
5 gallon (18.9L) pails and 1 gallon (3.79L) cans.

**NET WEIGHT PER GALLON**
10.16 ± 0.25 lbs (4.61 ± .11 kg) †

**STORAGE TEMPERATURE**
(Dry) Continuous 170°F (77°C) – Intermittent 200°F (93°C)

**TEMPERATURE RESISTANCE**
12 months at recommended storage temperature.

**SHELF LIFE**
N/A

**FLASH POINT - SETA**
Paint products contain chemical ingredients which are considered hazardous. Read container label warning and Material Safety Data Sheet for important health and safety information prior to the use of this product. **Keep out of the reach of children.**
APPLICATION

**COVERAGE RATES**

<table>
<thead>
<tr>
<th></th>
<th>Dry Mils (Microns)</th>
<th>Wet Mils (Microns)</th>
<th>Sq Ft/Gal (m²/Gal)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Suggested</td>
<td>2.5 (65)</td>
<td>6.5 (165)</td>
<td>257 (25.9)</td>
</tr>
<tr>
<td>Minimum</td>
<td>2.0 (50)</td>
<td>5.0 (125)</td>
<td>521 (29.8)</td>
</tr>
<tr>
<td>Maximum</td>
<td>3.0 (75)</td>
<td>7.5 (190)</td>
<td>214 (19.9)</td>
</tr>
</tbody>
</table>

Allow for overspray and surface irregularities. Wet film thickness is rounded to the nearest 0.5 mil or 5 microns. Application of coating below minimum or above maximum recommended dry film thicknesses may adversely affect coating performance. †

**MIXING**

Stir to uniform consistency without creating air bubbles or foam. Avoid vigorous agitation, boxing or shaking.

**THINNING**

Thinning is not normally required, but when needed, thin up to 5% or 1/4 pint (190 mL) per gallon with clean tap water.

**APPLICATION EQUIPMENT**

**Air Spray**

<table>
<thead>
<tr>
<th>Gun</th>
<th>Fluid Tip</th>
<th>Air Cap</th>
<th>Air Hose ID</th>
<th>Mat'l Hose ID</th>
<th>Atomizing Pressure</th>
<th>Pot Pressure</th>
</tr>
</thead>
<tbody>
<tr>
<td>DeVilbiss JGA</td>
<td>E</td>
<td>765 or 704</td>
<td>5/16&quot; or 3/8&quot; (7.9 or 9.5 mm)</td>
<td>3/8&quot; or 1/2&quot; (9.5 or 12.7 mm)</td>
<td>65-75 psi (4.5-5.2 bar)</td>
<td>15-25 psi (1.0-1.7 bar)</td>
</tr>
</tbody>
</table>

Low temperatures or longer hoses require higher pot pressure.

**Airless Spray**

<table>
<thead>
<tr>
<th>Tip Orifice</th>
<th>Atomizing Pressure</th>
<th>Mat'l Hose ID</th>
<th>Manifold Filter</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.015&quot;-0.017&quot; (330-430 microns)</td>
<td>2200-3000 psi (152-207 bar)</td>
<td>1/4&quot; or 3/8&quot; (6.4 or 9.5 mm)</td>
<td>60 mesh (250 microns)</td>
</tr>
</tbody>
</table>

Use appropriate tip/atomizing pressure for equipment, applicator technique and weather conditions.

**Surface Temperature**

Minimum 40°F (4°C)  Maximum 120°F (49°C)

The surface should be dry and at least 5°F (3°C) above the dew point.

**Cleanup**

Flush and clean all equipment immediately after use with water, then use alcohol or Methyl Ethyl Ketone (MEK) on any dried portions.

**CAUTION**

Dry overspray can be wiped or washed from most surfaces. Satisfactory dry-fall performance depends upon height of work, weather conditions and equipment adjustment. Low temperature and high humidity are of particular concern. Test for each application as follows: Spray from 15 to 25 feet towards paint container. The material then should readily wipe off. **Note:** Heat can fuse-dry overspray to surfaces. Always clean dry overspray from hot surfaces before fusing occurs. Be aware that exterior surface temperatures can be higher than air temperature.

† Values may vary with color.