



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. Contains hollow ceramic spheres for enhanced thermal stability. May be applied by spray, brush or roller over Series 971 Aerolon Acrylic. It is mildew resistant and exhibits very good gloss and color stability.

COLORS Refer to Tnemec Color Guide. **Note:** Certain colors may require multiple coats depending on method of application and finish coat color.

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

INTERMEDIATE Series 971

SURFACE PREPARATION

PRIMED SURFACES Must be clean, dry and free of dust, dirt, oil, grease and other contaminants.

TECHNICAL DATA

VOLUME SOLIDS 46.0 ± 2.0% †

RECOMMENDED DFT 2.0 to 3.0 mils (50 to 75 microns) per coat. **Important:** Do not exceed 3 mils DFT when topcoating Series 971 Aerolon for personnel protection.

CURING TIME	Temperature	To Touch	To Handle	To Recoat	To Resist Moisture
	75°F (24°C)	30 minutes	2 hours	2 hours	6 hours

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

VOLATILE ORGANIC COMPOUNDS **Unthinned:** 0.61 lbs/gallon (73 grams/litre)
Thinned 5%: 0.61 lbs/gallon (73 grams/litre) †

HAPS **Unthinned:** 0.27 lbs/gal solids
Thinned 5%: 0.27 lbs/gal solids

THEORETICAL COVERAGE 738 mil sq ft/gal (18.1 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 11.25 ± 0.25 lbs (5.10 ± .11 kg) †

STORAGE TEMPERATURE Minimum 35°F (2°C) Maximum 120°F (49°C)
Protect from freezing.

TEMPERATURE RESISTANCE (Dry) Continuous 170°F (77°C) Intermittent 200°F (93°C)
Note: The surface temperature of Aerolon will be less than the original substrate temperature due to the product's insulative qualities.

SHELF LIFE 12 months at recommended storage temperature.

FLASH POINT - SETA >230°F (110°C)

HEALTH & SAFETY 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	Dry MILS (Microns)	Wet MILS (Microns)	Sq Ft/Gal (m ² /Gal)
Suggested	2.5 (65)	6.5 (165)	295 (27.4)
Minimum	2.0 (50)	5.0 (125)	369 (34.3)
Maximum	3.0 (75)	7.5 (190)	246 (23.0)

Important: Do not exceed 3 mils DFT when topcoating Series 971 Aerolon for personnel protection.
Note: Due to the textured surface of Aerolon, coverage rates can range from 100-200 sq ft/gal (2.5-5.0 m²/gal). 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.

ENDURATONE® | SERIES 1028T

APPLICATION EQUIPMENT

Air Spray

Gun	Fluid Tip	Air Cap	Air Hose ID	Mat'l Hose ID	Atomizing Pressure	Pot Pressure
DeVilbiss JGA	E	765 or 704	5/16" or 3/8" (7.9 or 9.5 mm)	3/8" or 1/2" (9.5 or 12.7 mm)	65-75 psi (4.5-5.2 bar)	15-25 psi (1.0-1.7 bar)

Low temperatures or longer hoses require higher pot pressure.

Airless Spray

Tip Orifice	Atomizing Pressure	Mat'l Hose ID
0.013"-0.017" (330-430 microns)	2200-3000 psi (152-207 bar)	1/4" or 3/8" (6.4 or 9.5 mm)

Use appropriate tip/atomizing pressure for equipment, applicator technique and weather conditions. **Note:** Due to the textured surface of Series 971, Series 1028T must be back-rolled after spray application to achieve proper coverage.

Note: On projects involving spray equipment being used over consecutive days, follow Cleanup Instructions below and then leave xylol in the system overnight, flushing thoroughly with clean water before each start-up.

Roller: Use 3/8" (9.5 mm) synthetic woven nap roller cover.

Brush: Use high quality nylon or synthetic bristle brushes.

Note: Floetrol may be used at up to 32 ounces per gallon for improved application properties. Dry-fall and cure properties may be affected. For more information, contact Tnemec Technical Service.

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. **Note:** The surface temperature of Aerolon will be less than the original substrate temperature due to the product's insulative qualities.

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.

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