



PRODUCT PROFILE

GENERIC DESCRIPTION Aliphatic Acrylic Polyurethane

COMMON USAGE An acrylic polyurethane finish coat that contains a sparkle aluminum pigment creating a metallic aesthetic finish. It is a highly durable coating that is resistant to abrasion, wet conditions and exterior weathering. This high performance finish contains UV absorbers for extended color and gloss retention. NOT FOR IMMERSION SERVICE.

COLORS Available in 42 standard colors. Refer to Tnemec Metallic Color Guide. Certain colors may require a clear topcoat for optimum performance. **Note:** Variations in appearance between product samples, color cards, color sheets and actual field applications should be expected due to differences in environmental conditions, color of underlying coats, gloss level, orientation of metallic pigment, equipment and applicator technique. Reference Technical Bulletin No. 07-65 for more information.

FINISH Semi-gloss

SPECIAL QUALIFICATIONS Standard Series 1077 colors will meet the requirements of the Metallic Pigmented coatings category for use in air districts with more restrictive VOC regulations.

PERFORMANCE CRITERIA Contact your Tnemec representative for specific test results.

COATING SYSTEM

PRIMERS **Steel:** Series 1, 20, 27, 66, L69, N69, 84, 90-97, 91-H₂O, 104, 135, L140, N140, 161, 394, 530
Galvanized Steel and Non-Ferrous Metal: Series 27, 66, L69, N69, 161
Note: Series 530 exterior exposed more than 24 hours, Series 104 or 135 exterior exposed more than two months, or Series L69, N69, 84, L140 or N140 exterior exposed more than three months must first be scarified or reprimed with themselves. Brush blasting with fine abrasive is the preferred method of scarification.

TOPCOATS Series 1079, optional when extended weatherability is desired.

SURFACE PREPARATION

ALL SURFACES Must be clean, dry and free of oil, grease and other contaminants.

TECHNICAL DATA

VOLUME SOLIDS 56.0 ± 2.0% (mixed) †

RECOMMENDED DFT 2.0 to 3.0 mils (50 to 75 microns) per coat. **Note:** Number of coats and thickness requirements will vary with substrate, application method and exposure. Contact your Tnemec representative.

CURING TIME	Temperature	To Touch	To Handle	To Recoat
	75°F (24°C)	1 hour	5-8 hours	12 hours

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

VOLATILE ORGANIC COMPOUNDS **Unthinned:** 3.34 lbs/gallon (400 grams/litre)
Thinned 14% (No. 42 Thinner): 3.75 lbs/gallon (449 grams/litre)
Thinned 15% (No. 39 Thinner): 3.72 lbs/gallon (445 grams/litre) †

HAPS 1.42 lbs/gal solids

THEORETICAL COVERAGE 898 mil sq ft/gal (22.0 m²/L at 25 microns). †

NUMBER OF COMPONENTS Two: Part A and Part B

MIXING RATIO By volume: Five (Part A) to one (Part B)

PACKAGING	PART A	PART B	Yield (mixed)
Large Kit	6 gallon pail partially filled	1 gallon can	6 gallons (22.7L)
Small Kit	1 gallon can partially filled	1 quart can partially filled	1 gallon (3.79L)

NET WEIGHT PER GALLON 9.05 ± 0.25 lbs (4.40 ± .11 kg) †

STORAGE TEMPERATURE Minimum 20°F (-7°C) Maximum 110°F (43°C)

TEMPERATURE RESISTANCE (Dry) Continuous 250°F (121°C) Intermittent 275°F (135°C)

SHELF LIFE 12 months at recommended storage temperature.

FLASH POINT - SETA Part A: 55°F (13°C) Part B: >200°F (>93°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.

ENDURALUME® | SERIES 1077

APPLICATION

COVERAGE RATES

	Dry MILS (Microns)	Wet MILS (Microns)	Sq Ft/Gal (m ² /Gal)
Suggested	2.5 (65)	4.5 (115)	359 (33.4)
Minimum	2.0 (50)	3.5 (90)	449 (41.7)
Maximum	3.0 (75)	5.5 (140)	299 (27.8)

Allow for overspray and surface irregularities. 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 contents of the container marked Part A, making sure no pigment remains on the bottom. Add the contents of the can marked Part B to Part A while under agitation. Continue agitation until the two components are thoroughly mixed. Do not use mixed material beyond pot life limits. **Caution: Part B is moisture-sensitive and will react with atmospheric moisture. Keep unused material tightly closed at all times.**

THINNING

For air spray, thin up to 14% or 18 ounces (530 mL) per gallon by volume with No. 42 Thinner if temperatures are below 80°F (27°C), use No. 39 Thinner for temperatures above 80°F (27°C). **Caution: Do not add thinner if more than thirty (30) minutes have elapsed after mixing.**

POT LIFE

8 hours at 40°F (4°C) 4 hours at 77°F (25°C) 2 hours at 100°F (38°C)

APPLICATION EQUIPMENT

Air Spray

Gun	Fluid Tip	Air Cap	Air Hose ID	Mat'l Hose ID	Atomizing Pressure	Pot Pressure
DeVilbiss JGA	E	704	5/16" or 3/8" (7.9 or 9.5 mm)	3/8" or 1/2" (9.5 or 12.7 mm)	85-90 psi (5.7-6.2 bar)	12-15 psi (0.8-1.0 bar)

Low temperatures or longer hoses require higher pot pressure.

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

Contact Tnemec Company for additional information on application methods.

Note: Brush and roller application is not recommended as it could adversely affect the appearance.

Note: The finished appearance of 1077 can be affected by applicator technique, equipment and environmental conditions. A jobsite mock-up is recommended prior to full-scale application. Reference Technical Bulletin No. 07-65 for more information.

SURFACE TEMPERATURE

Minimum 35°F (2°C) Maximum 120°F (49°C)

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

Cure time necessary to resist direct contact with moisture at surface temperature:

40°F (4°C): 24 to 40 hours	50°F (10°C): 18 to 26 hours	60°F (16°C): 12 to 16 hours
70°F (21°C): 4 to 8 hours	90°F (32°C): 2 to 4 hours	100°F (38°C): 2 to 3 hours

If the coating is exposed to moisture before the preceding cure parameters are met, dull, flat or spotty-appearing areas may develop. Actual times will vary with air movement, film thickness and humidity.

CLEANUP

Flush and clean all equipment immediately after use with the recommended thinner or MEK.

† Values may vary with color.

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