



ENDURA-HEAT™ PRIMER

PRODUCT DATA SHEET

SERIES 1501

PRODUCT PROFILE

GENERIC DESCRIPTION Silicone Alkyd

COMMON USAGE A heat-resistant, corrosion-inhibitive, silicone alkyd primer that protects steel in service environments up to 600°F (315°C). Fast, ambient cure allows topcoats to be quickly applied so equipment and structures can be painted and returned to service. Hot application option up to 400°F (204°C).

COLORS Gray. **Important:** Due to the product's high heat exposure, sheen and color variations may occur. However, these changes are aesthetic only and will not affect performance. Contact your Tnemec representative for more information.

FINISH Flat

COATING SYSTEM

PRIMERS Self-priming

TOPCOATS Series 1552

SURFACE PREPARATION

STEEL SSPC-SP6/NACE 3 Commercial Blast Cleaning or ISO Sa 2 Thorough Blast Cleaning with a minimum angular anchor profile of 1.5 mils and maximum angular anchor profile of 2.0 mils.

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

TECHNICAL DATA

VOLUME SOLIDS 51%

RECOMMENDED DFT 2.0 to 3.0 mils (50 to 75 microns). **Note:** Application of coating below minimum or above maximum recommended dry film thicknesses may adversely affect coating performance.

CURING TIME

Temperature	To Touch	To Handle	To Topcoat	To Place in Service
75°F (24°C)	2 hours	3 to 4 hours	1 hour	12 hours

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

VOLATILE ORGANIC COMPOUNDS

TBAC Exempt:
Unthinned: 2.99 lbs/gallon (358 grams/litre)
Thinned 10% (No. 80 Thinner): 3.37 lbs/gallon (404 grams/litre)
Thinned 10% (No. 81 Thinner): 3.42 lbs/gallon (409 grams/litre)
Thinned 10% (No. 82 Thinner): 3.49 lbs/gallon (419 grams/litre)
Thinned 20% (No. 83 Thinner): 4.09 lbs/gallon (490 grams/litre)
Note: This product is not compliant in air districts that do not allow TBAC exemption.

THEORETICAL COVERAGE 818 mil sq ft/gal (76 m²/L at 25 microns). See APPLICATION for coverage rates. †

NUMBER OF COMPONENTS One

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

NET WEIGHT PER GALLON 11.40 ± 0.25 lbs (5.17 ± .11 kg)

STORAGE TEMPERATURE Minimum 30°F (-1°C) Maximum 110°F (43°C)

TEMPERATURE RESISTANCE (Dry) Continuous 500°F (260°C) Intermittent 600°F (315°F)

SHelf LIFE 24 months at recommended storage temperatures.

FLASH POINT - SETA 55°F (13°C)

HEALTH & SAFETY Paint products contain chemical ingredients which are considered hazardous. Read container label warning and 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)
Minimum	2.0 (50)	4.0 (100)	409 (38.0)
Maximum	3.0 (75)	6.0 (150)	273 (25.3)

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 thoroughly, making sure no pigment remains on the bottom of the can.

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THINNING Thinning is not normally required. If thinning is desired, reference thinning options below. **Note:** Do not combine thinners; only one thinner should be used during each application. Reference the charts below for application recommendations.

Air Spray or Airless Spray

Ambient Temperature	Standard Application	Hot Application
Below 80°F	No. 80 Thinner up to 10%	N/A
Above 80°F	No. 81 Thinner up to 10%	N/A

Note: For Brush or Roller application, thin 5% to 10% with No. 82 thinner.

Air Spray, Airless Spray, Brush or Roller

Substrate Temperature	Standard Application	Hot Application
200°F	N/A	No. 83 Thinner at 10%
300°F	N/A	No. 83 Thinner at 15%
400°F	N/A	No. 83 Thinner at 20%

Note: For applications above 200°F (93°C), contact Tnemec Technical Services for specific application parameters.

APPLICATION EQUIPMENT

Air Spray

Gun	Fluid Tip	Air Cap	Air Hose ID	Mat'l Hose ID	Atomizing Pressure	Pot Pressure
DeVilbiss MBC or JGA	E	765 or 78	5/16" or 3/8" (7.9 or 9.5 mm)	3/8" or 1/2" (9.5 or 12.7 mm)	60-80 psi (4.1-5.5 bar)	15-20 psi (1.0-1.4 bar)

Airless Spray

Pump	Tip Orifice	Pump Pressure (Min.)	Mat'l Hose ID
30:1, 45:1, 60:1	0.011"-0.015" (279-381 microns)	1800 psi (124 bar)	3/8" (9.5 mm)

Roller: Recommended for small areas only. Use 1/4" or 3/8" (6.3 mm to 9.5 mm) high quality synthetic woven nap covers.

Brush: Recommended for small areas only. Use high quality natural or synthetic bristle brushes.

SURFACE TEMPERATURE

Minimum 45°F (7°C) Maximum 200°F (93°C)

Note: For surface temperatures exceeding 200°F (93°C), reference the hot application thinning recommendations and contact Tnemec Technical Services for specific application parameters.

CLEANUP

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

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