**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

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**COATING SYSTEM**

**PRIMERS**
Self-priming

**TOPCOATS**
Series 1552

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**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.

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**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**

<table>
<thead>
<tr>
<th>Temperature (°F)</th>
<th>To Touch</th>
<th>To Handle</th>
<th>To Topcoat</th>
<th>To Place in Service</th>
</tr>
</thead>
<tbody>
<tr>
<td>75°F (24°C)</td>
<td>2 hours</td>
<td>3 to 4 hours</td>
<td>1 hour</td>
<td>12 hours</td>
</tr>
</tbody>
</table>

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 (415 grams/litre)
- Thinned 20% (No. 83 Thinner): 3.49 lbs/gallon (419 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.*

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**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>Minimum</td>
<td>2.0 (50)</td>
<td>4.0 (100)</td>
<td>409 (38.0)</td>
</tr>
<tr>
<td>Maximum</td>
<td>3.0 (75)</td>
<td>6.0 (150)</td>
<td>273 (25.3)</td>
</tr>
</tbody>
</table>

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.
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**

<table>
<thead>
<tr>
<th>Ambient Temperature</th>
<th>Standard Application</th>
<th>Hot Application</th>
</tr>
</thead>
<tbody>
<tr>
<td>Below 80°F</td>
<td>No. 80 Thinner up to 10%</td>
<td>N/A</td>
</tr>
<tr>
<td>Above 80°F</td>
<td>No. 81 Thinner up to 10%</td>
<td>N/A</td>
</tr>
</tbody>
</table>

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

**Substrate Temperature**

<table>
<thead>
<tr>
<th>Substrate Temperature</th>
<th>Standard Application</th>
<th>Hot Application</th>
</tr>
</thead>
<tbody>
<tr>
<td>200°F</td>
<td>N/A</td>
<td>No. 83 Thinner at 10%</td>
</tr>
<tr>
<td>300°F</td>
<td>N/A</td>
<td>No. 83 Thinner at 15%</td>
</tr>
<tr>
<td>400°F</td>
<td>N/A</td>
<td>No. 83 Thinner at 20%</td>
</tr>
</tbody>
</table>

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

APPLICATION EQUIPMENT

**Air Spray**

- **Gun:** DeVilbiss MBC or JGA
- **Fluid Tip:** E
- **Air Cap:** 765 or 78
- **Air Hose ID:** 5/16" or 3/8" (0.031 or 0.037"
- **Mat’l Hose ID:** 5/8" or 1/2" (0.062 or 0.050"
- **Atomizing Pressure:** 60-80 psi (4.1-5.5 bar)
- **Pot Pressure:** 15-20 psi (1.0-1.4 bar)

**Airless Spray**

- **Pump:** 30:1, 45:1, 60:1
- **Tip Orifice:** 0.011"-0.015" (279-381 microns)
- **Pump Pressure (Min.):** 1800 psi (12.4 bar)
- **Mat’l Hose ID:** 3/8" (0.95 mm)

**Roller:** Recommended for small areas only. Use 1/4" or 5/8" (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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