



# ENDURA-HEAT™ ZR SERIES 1505

## PRODUCT PROFILE

<b>GENERIC DESCRIPTION</b>	Silicone Zinc Copolymer
<b>COMMON USAGE</b>	A high-performance, two-component, zinc-rich, silicone copolymer that offers galvanic protection to steel substrates for extended corrosion protection up to 1000°F (538°C). An excellent primer for use with selected topcoats as part of a corrosion- and heat-resistant coating system. Requires an exceptionally low minimum 250°F (121°C) heat cure prior to placing in service.
<b>COLORS</b>	Greenish-Gray
<b>ZINC PIGMENT</b>	84% by weight in dried film
<b>FINISH</b>	Flat
<b>SPECIAL QUALIFICATIONS</b>	Series 1505 uses a zinc pigment which meets the requirements of <b>ASTM D 520 Type III</b> and contains less than .002% lead.

## COATING SYSTEM

**TOPCOATS** Series 1552, 1556, 1558

## SURFACE PREPARATION

<b>STEEL</b>	SSPC-SP6/NACE 3 Commercial Blast Cleaning or ISO Sa 2 Thorough Blast Cleaning with a minimum angular anchor profile of 1.0 mil and maximum angular anchor profile of 2.0 mils.
<b>ALL SURFACES</b>	Must be clean, dry and free of oil, grease and other contaminants.

## TECHNICAL DATA

<b>VOLUME SOLIDS</b>	41% (mixed)
<b>RECOMMENDED DFT</b>	2.0 to 3.0 mils (50 to 75 microns) per coat.
<b>CURING TIME</b>	

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

**Important:** Allow Series 1505 to ambient cure for 12 hours prior to heat cure. Reference the heat cure table below. Curing time varies with surface temperature, air movement, humidity and film thickness.

### HEAT CURE

Cure Time	Minimum Temperature	Maximum Temperature
4 hours	250°F (121°C)	500°F (260°C)
1 hour	475°F (246°C)	500°F (260°C)

### VOLATILE ORGANIC COMPOUNDS

TBAC Exempt:  
**Unthinned:** 3.30 lbs/gallon (396 grams/litre)  
**Thinned 10% (No. 80 Thinner):** 3.71 lbs/gallon (445 grams/litre)  
**Thinned 10% (No. 81 Thinner):** 3.76 lbs/gallon (451 grams/litre)  
**Thinned 10% (No. 82 Thinner):** 3.86 lbs/gallon (462 grams/litre)  
**Note:** This product is not compliant in air districts that do not allow TBAC exemption.

**THEORETICAL COVERAGE** 658 mil sq ft/gal (61.1 m<sup>2</sup>/L at 25 microns). See APPLICATION for coverage rates.

### NUMBER OF COMPONENTS PACKAGING

Two: Part A and Part B

	Part A (partially filled)	Part B (partially filled)	Yield (mixed)
Small Kit	1 gal can	1 gal can	1 gallon (3.79 L)

**NET WEIGHT PER GALLON** 19.58 ± 0.25 lbs (78.88 ± .11 kg) (mixed)

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

**TEMPERATURE RESISTANCE** (Dry) Continuous 1000°F (538°C) Intermittent 1200°F (649°C)

**SHELF LIFE** 24 months at recommended storage temperature.

**FLASH POINT - SETA** 60°F (16°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**

	Dry Mils (Microns)	Wet Mils (Microns)	Sq Ft/Gal (m <sup>2</sup> /Gal)
Minimum	2.0 (50)	5.0 (120)	329 (30.6)
Maximum	3.0 (75)	7.0 (185)	219 (20.4)

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

**MIXING**

Always use the entire contents of A and B components. Use an air-driven power mixer and keep material under constant agitation while mixing. Slowly sift Part B powder in to Part A liquid. **Do not reverse this procedure.** For spray application, keep under low RPM agitation to prevent settling. For brush and roller application, stir frequently to prevent settling.

**THINNING**

Not normally required. For air spray or airless spray applications below 80°F (26°C), thin up to 10% with No. 80 Thinner. For applications exceeding 80°F (26°C), thin up to 10% with No. 81 Thinner. For brush or roller applications, thin 5% to 10% with No. 82 Thinner.

**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	Mat'l Hose ID
30:1, 45:1, 60:1	0.021"-0.025" (533-635 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 125°F (52°C)

**CLEANUP**

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

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