ENDURA-HEAT™ DTM

SERIES 1525

PRODUCT PROFILE

GENERIC DESCRIPTION
Silicone Copolymer

COMMON USAGE
A specialized, direct-to-metal (DTM), corrosion inhibitive, aluminum silicone copolymer for steel substrates that reach elevated temperatures up to 1200°F (648°C). Its fast-cure capabilities allow for quick multi-coat application and return to service. Requires an exceptionally low 250°F (121°C) heat cure prior to placing in service.

COLORS
Aluminum

FINISH
Flat

COATING SYSTEM
PRIMERS
Self-priming

SURFACE PREPARATION
STEEL
SSPC-SP10/NACE 2 Near White Metal Blast or ISO Sa 3 Blast Cleaning to Visually Clean Steel with a minimum angular anchor profile of 1.0 mil and maximum angular anchor profile of 1.5 mils.

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

TECHNICAL DATA

VOLUME SOLIDS
36%

RECOMMENDED DFT
5.0 to 5.0 mils (75 to 125 microns). May be achieved in one or two coats. Note: Application of the coating below minimum or above maximum recommended dry film thickness may adversely affect coating performance.

CURING TIME

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

Important: Allow Series 1525 to ambient cure for 12 hours prior to heat cure. Do not heat cure between coats. Reference the heat cure table below. Curing time varies with surface temperature, air movement, humidity and film thickness.

HEAT CURE

<table>
<thead>
<tr>
<th>Cure Time</th>
<th>Minimum Temperature</th>
<th>Maximum Temperature</th>
</tr>
</thead>
<tbody>
<tr>
<td>4 hours</td>
<td>250°F (121°C)</td>
<td>500°F (260°C)</td>
</tr>
<tr>
<td>1 hour</td>
<td>475°F (246°C)</td>
<td>500°F (260°C)</td>
</tr>
</tbody>
</table>

VOLATILE ORGANIC COMPOUNDS

TBAC Exempt:
Unthinned: 3.47 lbs/gallon (415 grams/litre)
Thinned 10% (No. 80 Thinner): 3.89 lbs/gallon (466 grams/litre)
Thinned 10% (No. 81 Thinner): 3.95 lbs/gallon (473 grams/litre)
Thinned 10% (No. 82 Thinner): 4.04 lbs/gallon (485 grams/litre)
Thinned 20% (No. 83 Thinner): 4.72 lbs/gallon (565 grams/litre)

Note: This product is not compliant in air districts that do not allow TBAC exemption.

THEORETICAL COVERAGE

577 mil sq ft/gal (53.7 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
10.23 ± 0.25 lbs (4.64 ± .11 kg)

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

TEMPERATURE RESISTANCE
(Dry) Continuous 1200°F (649°C)

SHELF LIFE
24 months at recommended storage temperature.

FLASH POINT - SETA
53°F (12°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

<table>
<thead>
<tr>
<th>Minimum</th>
<th>Dry Mils (Microns)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>3.0 (75)</td>
</tr>
<tr>
<td>Maximum</td>
<td>5.0 (125)</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Minimum</th>
<th>Wet Mils (Microns)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>8.0 (210)</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Minimum</th>
<th>Sq Ft/Gal (m²/Gal)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>192 (17.9)</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Maximum</th>
<th>Sq Ft/Gal (m²/Gal)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>115 (10.7)</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 the coating below minimum or above maximum recommended dry film thickness may adversely affect coating performance.

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

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.

Published technical data and instructions are subject to change without notice. The online catalog at www.tnemec.com should be referenced for the most current technical data and instructions or you may contact your Tnemec representative for current technical data and instructions.
### Application Equipment

#### Air Spray

<table>
<thead>
<tr>
<th>Gun</th>
<th>Fluid Tip</th>
<th>Air Cap</th>
<th>Air Hose ID</th>
<th>Mat'l Hose ID</th>
<th>Atomizing Pressure</th>
<th>Pot Pressure</th>
</tr>
</thead>
<tbody>
<tr>
<td>DeVilbiss</td>
<td>E</td>
<td>765 or 78</td>
<td>5/16” or 3/8” (7.9 or 9.5 mm)</td>
<td>3/8” or 1/2” (9.5 or 12.7 mm)</td>
<td>60-80 psi (4.1-5.5 bar)</td>
<td>15-20 psi (1.0-1.4 bar)</td>
</tr>
</tbody>
</table>

#### Airless Spray

<table>
<thead>
<tr>
<th>Pump</th>
<th>Tip Orifice</th>
<th>Pump Pressure</th>
<th>Mat'l Hose ID</th>
</tr>
</thead>
<tbody>
<tr>
<td>30:1, 45:1, 60:1</td>
<td>0.011”-0.015” (279-384 microns)</td>
<td>1800 Psi (minimum) (124 bar)</td>
<td>3/8” (9.5 mm)</td>
</tr>
</tbody>
</table>

**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 bristle brushes.

### Surface Temperature

<table>
<thead>
<tr>
<th>Minimum</th>
<th>Maximum</th>
</tr>
</thead>
<tbody>
<tr>
<td>45°F (7°C)</td>
<td>125°F (52°C)</td>
</tr>
</tbody>
</table>

### Cleanup

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