



# 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** 3.0 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

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

**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

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:** 3.47 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 m<sup>2</sup>/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

	Dry Mils (Microns)	Wet Mils (Microns)	Sq Ft/Gal (m <sup>2</sup> /Gal)
Minimum	3.0 (75)	8.0 (210)	192 (17.9)
Maximum	5.0 (125)	13.5 (340)	115 (10.7)

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.

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**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	0.011"-0.015" (279-384 microns)	1800 Psi (minimum) (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 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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