PRODUCT PROFILE

GENERIC DESCRIPTION
Inert Multipolymeric Matrix

COMMON USAGE
An advanced, inert multipolymeric chemistry that provides high-performance direct-to-metal (DTM) coating protection to steel and stainless steel substrates in elevated temperatures up to 1200°F (648°C). Exceptional adhesion properties allow the coating to withstand severe thermal cycling (-300 to 1200°F), and its tolerance to marginally prepared substrates make it a viable alternative when abrasive blasting is not permitted. Its high-build feature and resistance to cyclic conditions make it an excellent coating system on pitted steel and for protecting against corrosion under insulation (CUI). Dry-fall spray characteristic provides fast, labor-saving coating application when used with appropriate thinner.

COLORS
Black, Gray, Aluminum. Note: Aluminum should not be topcoated except with itself.

FINISH
Flat

SPECIAL QUALIFICATIONS
Meets NACE SP0198-10 requirements SS-4, SS-5, CS-6 and CS-8.

COATING SYSTEM

PRIMERS
Series 1552, 1558. Note: Series 1552 may be used as a topcoat over Series 1528 for applications up to 500°F (260°C); Series 1558 may be used as a topcoat over Series 1528 for applications up to 1000°F (538°C).

TOPCOATS
Note:
Series 1542, 1552, 1558.
Series 1552 may be used as a topcoat over Series 1528 for applications up to 500°F (260°C);
Series 1558 may be used as a topcoat over Series 1528 for applications up to 1000°F (538°C).

SURFACE PREPARATION

STEEL
Exterior Exposure: 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 a maximum angular anchor profile of 3.0 mils. Note: Abrasive blast cleaning generally produces the best coating performance. If conditions will not permit this, Series 1528 may be applied to SSPC-SP2 or SSPC-SP5 Hand or Power Tool Cleaned surfaces in maintenance situations where mill scale has previously been removed.

Under Insulation: SSPC-SP10/NACE 2 Near-White Blast Cleaning or ISO Sa 2 1/2 Very Thorough Blast Cleaning is required.

STAINLESS STEEL
For specific instructions contact Tnemec Technical Services.

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

TECHNICAL DATA

VOLUME SOLIDS
65%

RECOMMENDED DFT
Standard Direct to Metal Service: 4.0 to 8.0 mils (100 to 200 microns) per coat. Two coats may be required for severe conditions.

Under Insulation Service: 6.0 to 8.0 mils (150 to 200 microns) per coat, two coats required.

CURING TIME

<table>
<thead>
<tr>
<th>Temperature</th>
<th>To Handle</th>
<th>To Recoat</th>
<th>To Topcoat</th>
<th>To Place in Service</th>
</tr>
</thead>
<tbody>
<tr>
<td>75°F (24°C)</td>
<td>12 hours</td>
<td>6 hours</td>
<td>24 hours</td>
<td>24 hours</td>
</tr>
</tbody>
</table>

Important: Allow Series 1528 to ambient cure for 24 hours prior to placing in service. Curing time varies with surface temperature, air movement, humidity and film thickness.

VOLATILE ORGANIC COMPOUNDS

DMC Exempt.

Unthinned: 5.33 lbs/gallon (309 grams/litre)

Thinned 4% (No. 80 Thinner): 5.47 lbs/gallon (416 grams/litre)

Thinned 10% (No. 80 Thinner): 3.67 lbs/gallon (439 grams/litre)

Thinned 4% (No. 81 Thinner): 5.49 lbs/gallon (418 grams/litre)

Thinned 10% (No. 81 Thinner): 3.71 lbs/gallon (444 grams/litre)

Thinned 10% (No. 82 Thinner): 3.78 lbs/gallon (455 grams/litre)

Thinned 15% (No. 85 Thinner): 3.33 lbs/gallon (399 grams/litre)

Thinned 15% (No. 86 Thinner): 3.33 lbs/gallon (399 grams/litre)

Thinned 15% (No. 84 Thinner): 3.15 lbs/gallon (618 grams/litre)

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

THEORETICAL COVERAGE
1,043 mil sq ft/gal (96.9 m²/L at 25 microns). See APPLICATION for coverage rates.

NUMBER OF COMPONENTS
One

PACKAGING
5 gallon pail yielding 3 gallons (11.35 L) and 1 gallon can yielding 1 gallon (3.79 L)

NET WEIGHT PER GALLON
16.69 ± 0.25 lbs (7.57 ± .11 kg)

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

TEMPERATURE RESISTANCE
(Dry) Continuous: Minimum -300°F (-184°C) Maximum 1200°F (649°C)

SHELF LIFE
24 months at recommended storage temperature.

FLASH POINT - SETA
105°F (41°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

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**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>4.0 (100)</td>
<td>6.0 (155)</td>
<td>261 (24.2)</td>
</tr>
<tr>
<td>Maximum</td>
<td>8.0 (200)</td>
<td>12.0 (310)</td>
<td>150 (12.1)</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 & Thinning**

Power mix the contents of the container, making sure no pigment remains at the bottom.

Thinning is not normally required. If thinning is desired, reference thinning options below. Note: Do not combine thiners; 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>Dry-Fall Application</th>
</tr>
</thead>
<tbody>
<tr>
<td>Below 80°F (27°C)</td>
<td>No. 80 Thinner up to 10%</td>
<td>No. 85 Thinner 10% to 15%</td>
</tr>
<tr>
<td>Above 80°F (27°C)</td>
<td>No. 81 Thinner up to 10%</td>
<td>No. 86 Thinner 10% to 15%</td>
</tr>
</tbody>
</table>

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

**Air Spray, Airless Spray, Brush or Roller**

<table>
<thead>
<tr>
<th>Substrate Temperature</th>
<th>Standard Application</th>
<th>Hot Application</th>
</tr>
</thead>
<tbody>
<tr>
<td>200°F (93°C)</td>
<td>No. 82 Thinner at 10% to 25%</td>
<td></td>
</tr>
<tr>
<td>300°F (149°C)</td>
<td>No. 82 Thinner at 15% to 30%</td>
<td></td>
</tr>
<tr>
<td>400°F (204°C)</td>
<td>No. 82 Thinner at 20% to 35%</td>
<td></td>
</tr>
<tr>
<td>500°F (260°C)</td>
<td>No. 82 Thinner at 25% to 40%</td>
<td></td>
</tr>
<tr>
<td>600°F (315°C)</td>
<td>No. 82 Thinner at 30% to 50%</td>
<td></td>
</tr>
<tr>
<td>750°F (399°C)</td>
<td>No. 82 Thinner at 50% to 75%</td>
<td></td>
</tr>
</tbody>
</table>

**Application Equipment**

**Air Spray**

- **Gun:** DeVilbiss MBC-510
- **Fluid Tip:** E
- **Air Cap:** 704
- **Mat'l Hose ID:** 3/8" (9.5 mm)
- **Pot Pressure:** 60 psi (4.1 bar)
- **Atomizing Pressure:** 70 psi (4.8 bar)

**Airless Spray (Standard Applications)**

- **Gun:** Graco 205-591
- **Pump:** 30:1, 45:1, 60:1
- **Mat'l Hose ID:** 3/8" (9.5 mm)
- **Pump Pressure:** 3000 Psi (206 bar)
- **Tip Orifice:** 0.015"-0.021" (381-533 microns)

**Airless Spray (Dry Fall Applications)**

- **Gun:** Graco 205-591
- **Pump:** 30:1, 45:1, 60:1
- **Mat'l Hose ID:** 3/8" (9.5 mm)
- **Pump Pressure:** 1800-2100 Psi (124-145 bar)
- **Tip Orifice:** 0.017" (452 microns)

**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.

**Clean-Up & Caution**

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

Dry overspray can be wiped or washed from most surfaces. Satisfactory dry-fall performance depends upon height of work, weather conditions and equipment adjustment. Low temperature and high humidity are of particular concern. Test for each application as follows: Spray from 15 to 25 feet towards paint container. The material then should readily wipe off.

Note: Heat can fuse-dry overspray to surfaces. Always clean dry overspray from hot surfaces before fusing occurs. Be aware that exterior surface temperatures can be higher than air temperature.

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ENDURA-HEAT™ DTM | SERIES 1528

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