



PRODUCT PROFILE

GENERIC DESCRIPTION Modified Silicone Copolymer

COMMON USAGE A modified silicone copolymer topcoat formulated for color stability and substrate protection in elevated temperatures up to 1000°F (538°C). Outperforms conventional high-temperature topcoats with exceptional color stability, resistance to thermal cycling, and cure requirements. An excellent choice for topcoating high-temperature coating systems in refineries, power plants, petrochemical facilities, and treatment plants. Requires heat cure prior to placing in service.

COLORS Endura-Heat Standard and Custom Colors Available. Additional lead time will be required for custom colors. **Note:** 10HT White must be heat cured at 500°F (260°C). **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

COATING SYSTEM

PRIMERS Series 1505

SURFACE PREPARATION

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

TECHNICAL DATA

VOLUME SOLIDS 45% ± 2%

RECOMMENDED DFT 2.0 to 3.0 mils (50 to 75 microns).

CURING TIME

Temperature	To Touch	To Handle	To Recoat	To Place in Service
75°F (24°C)	15 minutes	1 to 2 hours	1 to 2 hours	24 hours

Important: Allow Series 1556 to ambient cure for 24 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: 3.49 lbs/gallon (419 grams/litre)
Thinned 10% (No. 80 Thinner): 3.81 lbs/gallon (457 grams/litre)
Thinned 10% (No. 81 Thinner): 3.86 lbs/gallon (462 grams/litre)
Thinned 10% (No. 82 Thinner): 3.93 lbs/gallon (471 grams/litre)
Thinned 40% (No. 83 Thinner): 5.15 lbs/gallon (617 grams/litre)
Note: This product is not compliant in air districts that do not allow TBAC exemption.

THEORETICAL COVERAGE 722 mil sq ft/gal (67.1 m²/L at 25 microns.) See APPLICATION for coverage rates.

NUMBER OF COMPONENTS One

PACKAGING 5 gallon (18.9 L) pails and 1 gallon (3.79 L) cans.

NET WEIGHT PER GALLON 13.24 ± 0.25 lbs (6.0 ± .11 kg)

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

TEMPERATURE RESISTANCE (Dry) Continuous 1,000°F (538°C)

SHELF LIFE 12 months at recommended storage temperatures.

FLASH POINT - SETA 85°F (29°C)

HEALTH & SAFETY This product contains 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 ² /Gal)
Minimum	2.0 (50)	4.0 (110)	361 (33.5)
Maximum	3.0 (75)	6.5 (170)	241 (22.4)

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

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

ENDURA-HEAT™ | SERIES 1556

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

Ambient Temperature	Standard Application	Hot Application
Below 80°F (27°C)	No. 80 Thinner up to 10%	N/A
Above 80°F (27°C)	No. 81 Thinner up to 10%	NA

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

Air Spray, Airless Spray, Brush or Roller

Substrate Temperature	Standard Application	Hot Application
200°F (93°C)	N/A	No. 83 Thinner at 10% to 25%
300°F (149°C)	N/A	No. 83 Thinner at 15% to 30%
400°F (204°C)	N/A	No. 83 Thinner at 20% to 35%
500°F (260°C)	N/A	No. 83 Thinner at 25% to 40%

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

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"-0.013" (279-330 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 bristle brushes.

SURFACE TEMPERATURE

Minimum 43°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.

CAUTION

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

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