**PRODUCT PROFILE**

**GENERIC DESCRIPTION**
Acrylic Silicone Copolymer

**COMMON USAGE**
A heat-resistant, acrylic silicone topcoat available in a wide range of colors using thermally stable pigments for temperatures up to 500°F (260°C), and black, aluminum, or limited gray colors up to 800°F (426°C). This topcoat is used as the finish to high-temperature coating systems, imparting excellent resistance to weathering and UV-light degradation. Ambient, air-dried cure.

**COLORS**
Endura-Heat Standard and Custom Colors Available. Additional lead time will be required for custom colors. **Note:** Standard and custom colors may be used for protection up to 500°F (260°C). Black, Aluminum or Gray may be used for protection up to 800°F (426°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**
Matte

**COATING SYSTEM**

**PRIMERS**
Series 1501, 1505, 1528. **Note:** For service conditions up to 500°F (260°C), use Series 1501. For service conditions up to 800°F (426°C), use Series 1505 or 1528.

**SURFACE PREPARATION**

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

**TECHNICAL DATA**

**VOLUME SOLIDS**
50%

**RECOMMENDED DFT**
2.0 to 3.0 mls (50 to 75 microns).

**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>15 minutes</td>
<td>1 to 2 hours</td>
<td>1 to 2 hours</td>
<td>12 hours</td>
</tr>
</tbody>
</table>

Curing time varies with surface temperature, air movement, humidity and film thickness.

**VOLATILE ORGANIC COMPOUNDS**

**TBAC Exempt:**
- Unthinned: 3.32 lbs/gallon (398 grams/litre)
- Thinned 10% (No. 80 Thinner): 3.67 lbs/gallon (440 grams/litre)
- Thinned 10% (No. 81 Thinner): 3.71 lbs/gallon (445 grams/litre)
- Thinned 10% (No. 82 Thinner): 3.79 lbs/gallon (454 grams/litre)
- Thinned 20% (No. 83 Thinner): 4.36 lbs/gallon (522 grams/litre)

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

**THEORETICAL COVERAGE**
802 mil sq ft/gal (74.5 m²/L at 25 microns).

**NUMBER OF COMPONENTS**
One

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

**NET WEIGHT PER GALLON**
11.04 ± 0.25 lbs (5.27 ± .11 kg) (mixed)

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

**TEMPERATURE RESISTANCE**
(Dry) Continuous 500°F (260°C) or 800°F (426°C) depending on color.

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

**FLASH POINT - SETA**
65°F (18°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>Dry Mils (Microns)</th>
<th>Wet Mils (Microns)</th>
<th>Sq Ft/Gal (m²/Gal)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Minimum</td>
<td>2.0 (50)</td>
<td>4.0 (100)</td>
</tr>
<tr>
<td>Maximum</td>
<td>3.0 (75)</td>
<td>6.0 (150)</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 at the bottom.
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

<table>
<thead>
<tr>
<th>Ambient Temperature</th>
<th>Standard Application</th>
<th>Hot Application</th>
</tr>
</thead>
<tbody>
<tr>
<td>Below 80°F</td>
<td>No. 80 Thinner up to 10%</td>
<td>N/A</td>
</tr>
<tr>
<td>Above 80°F</td>
<td>No. 81 Thinner up to 10%</td>
<td>N/A</td>
</tr>
</tbody>
</table>

**Note:** For Brush or Roller application, 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</td>
<td>N/A</td>
<td>No. 83 Thinner at 10%</td>
</tr>
<tr>
<td>300°F</td>
<td>N/A</td>
<td>No. 83 Thinner at 15%</td>
</tr>
<tr>
<td>400°F</td>
<td>N/A</td>
<td>No. 83 Thinner at 20%</td>
</tr>
</tbody>
</table>

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

### 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 MBC or JGA</td>
<td>E</td>
<td>765 or 78</td>
<td>5/16&quot; or 5/8&quot; (7.9 or 9.5 mm)</td>
<td>3/8&quot; or 1/2&quot; (9.5 or 12.7 mm)</td>
<td>60-80 psi (4.1-5.5 bar)</td>
<td>20 psi (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&quot;-0.015&quot; (279-381 microns)</td>
<td>2100 Psi (144 bar)</td>
<td>3/8&quot; (9.5 mm)</td>
</tr>
</tbody>
</table>

#### Roller

Recommended for small areas only. Use 1/4" or 5/8" (6.2 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 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.

### CLEANUP

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

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Technical and application information herein is provided for the purpose of establishing a general profile of the coating and proper coating application procedures. Test performance results were obtained in a controlled environment and Tnemec Company makes no claim that these tests or any other tests, accurately represent all environments. As application, environmental and design factors can vary significantly, due care should be exercised in the selection and use of the coating.