



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 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	12 hours

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 11.64 ± 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

	Dry MILS (Microns)	Wet MILS (Microns)	Sq Ft/Gal (m ² /Gal)
Minimum	2.0 (50)	4.0 (100)	401 (37.3)
Maximum	3.0 (75)	6.0 (150)	267 (24.8)

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.

ENDURA-HEAT™ | SERIES 1552

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	No. 80 Thinner up to 10%	N/A
Above 80°F	No. 81 Thinner up to 10%	N/A

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

Air Spray, Airless Spray, Brush or Roller

Substrate Temperature	Standard Application	Hot Application
200°F	N/A	No. 83 Thinner at 10%
300°F	N/A	No. 83 Thinner at 15%
400°F	N/A	No. 83 Thinner at 20%

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

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)	20 psi (1.4 bar)

Airless Spray

Pump	Tip Orifice	Pump Pressure	Mat'l Hose ID
30:1, 45:1, 60:1	0.011"-0.015" (279-381 microns)	2100 Psi (144 bar)	3/8" (9.5 mm)

Roller: Recommended for small areas only. Use 1/4" or 3/8" (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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