TNEMEC

PRODUCT DATA SHEET

ENDURATONE® SERIES 1028

PRODUCT PROFILE

GENERIC DESCRIPTION HDP Acrylic Polymer

COMMON USAGE Water-based, low VOC, High Dispersion Pure acrylic polymer coating providing excellent long term protection in both interior/exterior exposures. May be applied by spray, brush or roller over a variety of solvent and waterborne steel primers. May also be used over many aged coatings. It is mildew resistant and exhibits very good gloss and color stability. Application methods include "dry-fall" under certain conditions (See Application). **Note:** Series 1028's "dry-fall" characteristics help to reduce the potential for overspray problems on buildings and surrounding property.

COLORS Refer to Tnemec Color Guide. **Note:** Certain colors may require multiple coats depending on method of application and finish coat color. When feasible, the preceding coat should be in the same color family (blue, gray, etc.), but noticeably different.

FINISH Gloss - **Note:** Final gloss level of topcoat can vary depending on number of coats applied. One coat will generally result in a lower sheen than two coats of the material.

SPECIAL QUALIFICATIONS Series 1028 was tested in accordance with, and passed, the California Dept. of Public Health (CDPH) Standard Method v1.2 and meets the requirements of LEED v4.1 Low-Emitting Materials, Collaborative for High Performance Schools-Paints & Coatings, Living Building Challenge Materials Petal 10, and WELL Building Standard v2 X06 VOC Restrictions.

COATING SYSTEM

PRIMERS
Wood: Series V10-99W or 151-1051
Steel: Series 1, V10, 22, 30, 37H, 66, L69, L69F, N69, N69F, V69, V69F, 90-97, 90G-1K97, 91-H_2O, 94-H_2O, 113, 115, V115, 118, 135, L140, L140F, N140, N140F, V140, V140F, 141, 161, 287, 394. **Note:** Allow Series V10 and 37H to cure three days before topcoating. Additionally, Series 1, 90-97, 90G-1K97, 91-H_2O, 94-H_2O and 394 must be exterior exposed for three days prior to topcoating. **Note:** This product exhibits direct-to-metal capabilities for dry interior environments. Contact Tnemec Technical Service for more information.
Aluminum & Galvanized: Series 66, L69, N69, V69, 115, V115, 135, 1224. **Note:** For special galvanized surface preparation instructions, consult the latest version of Tnemec Technical Bulletin 10-78.
Concrete: Self-priming or Series 6, 54, 66, L69, L69F, N69, N69F, V69, V69F, 130, 151, 156, 180, 287, 1254
CMU: Series 54, 130, 1254
Drywall: Series 51, 151-1051, 287

TOPCOATS Series 1029

SURFACE PREPARATION

STEEL
Weather Exposed: SSPC-SP6 Commercial Blast Cleaning.
Enclosed, Protected & Mild Environments: SSPC-SP2 Hand Tool or SSPC-SP3 Power Tool Cleaning.

GALVANIZED STEEL & ALUMINUM Surface preparation recommendations will vary depending on substrate and exposure conditions. Consult the latest version of Tnemec Technical Bulletin 10-78 or contact your Tnemec representative or Tnemec Technical Services.

PAINTED SURFACES Remove chalk and old paint not tightly bonded to the surface. Clean all visible rust using SSPC-SP3 Power Tool Cleaning (interior dry) or to bare metal using SSPC-SP11 Power Tool Cleaning to Bare Metal (weather exposed).

PRIMED SURFACES Must be clean, dry and free of dust, dirt, oil, grease and other contaminants. Existing water soluble stains in the substrate or upon the surface must be removed or sealed. Allow new concrete to cure 28 days.

TECHNICAL DATA

VOLUME SOLIDS 40.0 ± 2.0% †

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

CURING TIME

Temperature	To Touch	To Handle	To Recoat	To Resist Moisture
75°F (24°C)	30 minutes	2 hours	2 hours	6 hours

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

VOLATILE ORGANIC COMPOUNDS
Unthinned: 0.79 lbs/gallon (94 grams/litre)
Thinned 5%: 0.79 lbs/gallon (94 grams/litre) †

HAPS
Unthinned: 0.35 lbs/gal solids
Thinned 5%: 0.35 lbs/gal solids

THEORETICAL COVERAGE 633 mil sq ft/gal (15.5 m²/L at 25 microns). See APPLICATION for coverage rates. †

NUMBER OF COMPONENTS One

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

NET WEIGHT PER GALLON 10.16 ± 0.25 lbs (4.61 ± 0.11 kg) †

STORAGE TEMPERATURE Minimum 35°F (2°C) Maximum 120°F (49°C)
Protect from freezing.

TEMPERATURE RESISTANCE (Dry) Continuous 300°F (149°C)
Note: Coating will yellow at continuous temperatures greater than 170°F (77°C). Due to this, light colors are not recommended for high temperature service.

SHELF LIFE 12 months at recommended storage temperature.

FLASH POINT - SETA N/A

HEALTH & SAFETY Paint products contain chemical ingredients which are considered hazardous. Read container label warning and Material 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 (m²/Gal)
Suggested	2.5 (65)	6.5 (165)	257 (23.9)
Minimum	2.0 (50)	5.0 (125)	321 (29.8)
Maximum	3.0 (75)	7.5 (190)	214 (19.9)

Allow for overspray and surface irregularities. Wet film thickness is rounded to the nearest 0.5 mil or 5 microns. Application of coating below minimum or above maximum recommended dry film thicknesses may adversely affect coating performance. †

MIXING

Stir to uniform consistency without creating air bubbles or foam. Avoid vigorous agitation, boxing or shaking.

THINNING

Thinning is not normally required, but when needed, thin up to 5% or 1/4 pint (190 mL) per gallon with clean tap water.

APPLICATION EQUIPMENT

Air Spray

Gun	Fluid Tip	Air Cap	Air Hose ID	Mat'l Hose ID	Atomizing Pressure	Pot Pressure
DeVilbiss JGA	E	765 or 704	5/16" or 3/8" (7.9 or 9.5 mm)	3/8" or 1/2" (9.5 or 12.7 mm)	65-75 psi (4.5-5.2 bar)	15-25 psi (1.0-1.7 bar)

Low temperatures or longer hoses require higher pot pressure.

Airless Spray

Tip Orifice	Atomizing Pressure	Mat'l Hose ID	Manifold Filter
0.013"-0.017" (330-430 microns)	2200-3000 psi (152-207 bar)	1/4" or 3/8" (6.4 or 9.5 mm)	60 mesh (250 microns)

Use appropriate tip/atomizing pressure for equipment, applicator technique and weather conditions.

Note: On projects involving spray equipment being used over consecutive days, follow Cleanup Instructions below and then leave xylol in the system overnight, flushing thoroughly with clean water before each start-up.
Roller: Use 3/8" (9.5 mm) synthetic woven nap roller cover.
Brush: Use high quality nylon or synthetic bristle brushes.
Note: Floetrol may be used at up to 32 ounces per gallon for improved application properties. Dry-fall and cure properties may be affected. For more information, contact Tnemec Technical Service.

SURFACE TEMPERATURE

Minimum 40°F (4°C) Maximum 120°F (49°C)
The surface should be dry and at least 5°F (3°C) above the dew point.

CLEANUP

Flush and clean all equipment immediately after use with water, then use alcohol or Methyl Ethyl Ketone (MEK) on any dried portions.

CAUTION

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.

† Values may vary with color.