

Endura UltraGrip Primer is a surface tolerant, reinforced inorganic zinc primer. It provides superior adhesion and cathodic corrosion protection.

### Product Features

- ◆ Gives cathodic corrosion protection
- ◆ Formulated for use where high impact resistance is required
- ◆ High solids formulation
- ◆ No induction time required

### Theoretical Solids Content:

Volume: 63%

### Shelf Life\*

Component A: (3) years  
Component B: (1) year

\*For unopened product.

### Pot Life of Mixed Product:

10 Hours @ 77°F (25°C)  
and 50% RH



### Suitability

Endura UltraGrip Primer provides superior adhesion, impact resistance and cathodic corrosion protection over a wide variety of ferrous surfaces. It is specially formulated to fill a sandblast profile in one coat.



### Surface Preparation

Commercial sandblasting or machine sanding with 40 grit sandpaper is acceptable for most applications. Sandblast media, mesh size 16/30 or 30/50 or LG 50 steel shot.



### Mixing Ratio

5 parts by volume of component A [FEA0003]  
1 part by volume of component B [FEB0003]

The recommended temperature when mixed is 20-25°C (68-77°F).

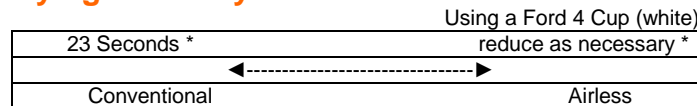
### Environmental Conditions

For optimum coating performance product, substrate and ambient temperature should be between 20°C-25°C\* (68°F-77°F). To prevent condensation during application the surface temperature must be 3°C (5°F) or more above the dew point at all times.

\*for use outside this range please contact your Endura representative.



### Spraying Viscosity\*

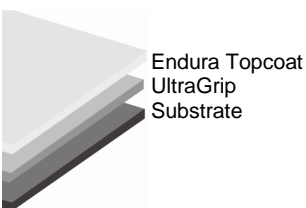


\* Spraying viscosity and thinning will depend on ambient conditions, spray equipment used, and on the desired surface finish.



### Spray Gun Setup

Feed Type	Fluid Tip	Application Pressures ( heel of gun )	Fluid Delivery
Siphon Feed	1.6-1.8 mm	40-50 psi	
Gravity Feed	1.6-1.8 mm	30-40 psi	
Pressure Feed	1.4-1.8 mm	50-60 psi	12-16 oz/min
Air Assist Airless	<b>15-17 Thou</b>	1,000-1,800 psi	
Airless	<b>15-17 Thou</b>	1,700-3,000 psi	



### UltraGrip

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#### Application Method

Endura UltraGrip Primer can be applied using most spray painting systems, although electrostatic sprayers are not recommended. Under normal conditions, it has a topcoat window of 3-72 hours. Contact your Endura rep for details on an indefinite window.

#### Recommended Film Build Thickness and Cover Rate

Endura UltraGrip Primer has a recommended film build thickness of:

Wet (unreduced): 4.0 – 8.0 mils wet (100 – 200 microns)

**Dry: 2.5 - 5.0 mils dry (62.5 - 125 microns)**

Theoretical coverage at 1.0 mil (25 microns) DFT: 1008 ft<sup>2</sup> per gallon @ 100% transfer efficiency.



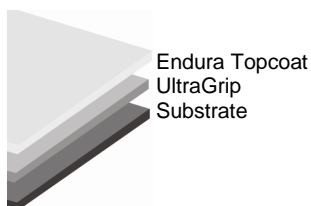
#### Drying Time\*

	20°C (68°F)	30°C (86°F)	40°C (104°F)
Topcoat	3 Hours	2 hours	1-2 Hours
Full Cure	7-9 Days	5-6 Days	3-4 Days

\* Subject to ambient conditions (temperature and humidity) film build and good airflow. For improved scheduling please contact your Endura representative.

#### Specifications

Solvent resistance	ASTM D4752	50 MEK rubs; NO failure
Impact resistance	ASTM D2794	40 in. lbs; NO failure
Flexibility	ASTM D522	3/8 mandrel bend; NO failure
VOC	For VOC amounts please refer to the product MSDS	



#### Clean Up

Endura high strength gun wash, Endura epoxy reducer or Endura EX-2C thinner.