

UltraPrime 1020

Endura UltraPrime1020 is a two-component reinforced inorganic zinc primer providing excellent adhesion, hardness, and flexibility with proven cathodic protection of steel structures.

Can be used under cementitious fireproofing.

Product Features

- ◆ Economical zinc coating
- ◆ Provides cathodic protection
- ◆ No mud cracking
- ◆ High solids formulation fills a sandblast profile in one coat
- ◆ Fast dry to handle and recoat
- ◆ No induction required

Theoretical Solids Content:

Volume: 53%

Shelf Life*

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

*For unopened product.

Pot Life of Mixed Product:

6-10 Hours @ 77°F (25°C) and 50% RH



Suitability

Endura UltraPrime 1020 provides superior adhesion, impact resistance and cathodic corrosion protection over a wide variety of ferrous surfaces. It is specially formulated for **Slip Critical Joints**, and meets **Class B slip and creep** for faying surfaces.

NOTE: Slip resistance cannot be maintained if a topcoat is applied between the bolted surfaces. Overspray is not recommended on connecting surfaces.



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 LG50 Steel shot.



Mixing Ratio

9 parts by volume of component A [FEA0044]
1 part by volume of component B [FEB0043]

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*

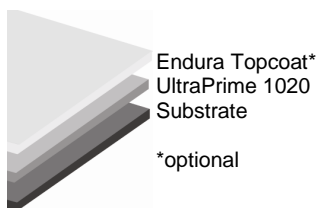
Using a Ford 4 Cup (white)	
22-23 Seconds *	reduce as necessary *
Conventional	Airless

* 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	1.6-2.0 mm	40-50 psi	
Gravity Feed	1.3-1.4 mm	30-40 psi	
Pressure Feed	1.0-1.8 mm	50-60 psi	10-14 oz/min
Air Assist Airless	9-17 Thou	1,000-1,800 psi	
Airless	11-13 Thou	1,700-3,000 psi	



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Recommended Film Build Thickness and Cover Rate

Endura UltraPrime 1020 has a recommended film build thickness of:

Wet (unreduced): 3.5 – 5.5 mils wet (87.5 – 137.5 microns)
Dry: 2.0 – 3.0 mils dry (50 – 75 microns)

Theoretical coverage at 1.0 mil (25 microns) DFT: 832 ft² per gallon @ 100% transfer efficiency.

Maximum dried film thickness to meet class B requirements for slip coefficient and creep resistance is 2 mils.



Drying Time*

Drying time will vary depending upon temperature, humidity, airflow, and other environmental factors. The following table is based on 50% relative humidity.

	20°C (68°F)	30°C (86°F)	40°C (104°F)
Topcoat	2 Hours	1 Hours	30 Minutes
Full Cure	9 Days	6 Days	4 Days

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

Specifications

Impact resistance (direct)	ASTM D2794	40 in.lbs: NO Failure
Humidity resistance	ASTM D4585	Excellent
Water immersion	ASTM D1308	Excellent
Service temperature limits		400°F (204°C)
Salt spray resistance (1000 hours)	ASTM B117	No blistering, cracking or delamination of film. No more than 3/16 inch rust
VOC	For VOC amounts please refer to the product MSDS	



Endura Topcoat*
UltraPrime 1020
Substrate

*optional



Clean Up

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