



Technical Data Sheet (TDS)

Product Description

Endura Caliber Primer is a low VOC, surface tolerant, epoxy zinc primer. It provides superior adhesion and corrosion protection. This high solids primer provides impact resistance, requires no induction time and fills a sandblast profile in one coat.

Product features:

- Provides corrosion protection
- High solids formulation fills a sandblast profile in one coat
- No induction required
- **VOC Compliant**

Recommended Uses

Endura Caliber Epoxy Zinc Primer (grey) provides superior adhesion, impact resistance and corrosion protection over a wide variety of ferrous surfaces. It is specially formulated to fill a sandblast profile in one coat.

It may be applied to many surfaces such as:

- Properly sanded or blasted Steel (or other ferrous metals)
- Properly prepared or sanded Galvanized and zinc-coated steel

Industries:

- Oilfield & Energy Services
 - Well Service vehicles
 - Drilling
- Cranes and Construction Equipment
- Waste and Recycling Industry
 - Garbage Trucks

Mix Ratio

5 parts by volume of component A [FEA0061]
1 part by volume of component B [FEB0041]

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

Product Characteristics

Finish: low gloss (*light grey*)

Volume Solids: 60% by volume

Pot Life: 10 Hours @ 77°F (25°C) and 50% RH

VOC (EPA Method 24): 248 grams/litre (2.07 lbs/gallon)

Shelf Life*:

Component A: 1 year
Component B: 2 years

*For unopened product

Surface Prep

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.

Application Method

Endura Caliber Primer can be applied using most spray systems, although electrostatic sprayers are not recommended. Under normal conditions, it has a topcoat window of 3-72 hours.

(no agitation required while spraying...zinc is fully suspended in the coating)

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	13-15 Thou	1,000-1,800 psi	
Airless	13-15 Thou	1,700-3,000 psi	



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Spray 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.

To maintain VOC compliance thin Caliber with Endura Low VOC Epoxy Reducer.

[FTH0016] Low VOC Epoxy Reducer – Regular
(VOC=0 g/L, 0 lbs/gal)
[FTH0027] Low VOC Epoxy Reducer - Slow
(VOC=0 g/L, 0 lbs/gal)

Film Build

Endura Caliber Primer has a recommended film build thickness of:

Wet (unreduced): 4.0 – 8.5 mils wet
(100 – 212.5 microns)

Dry: 2.5 – 5.0 mils DFT (62.5 – 125 microns)

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

Dry Times*

Drying time will vary depending upon temperature and film thickness.

	@ 20°C (68°F)	@ 30°C (86°F)	@ 40°C (104°F)
Topcoat	3-72 Hours	2-3 Hours	1-2 Hours
Full Cure	7-9 Days	5-6 Days	3-4 Days

*Subject to ambient conditions (temperature and humidity) and good airflow.

For improved scheduling please contact your Endura Representative.

Topcoating Information

Endura Caliber Primer can be topcoated with Endura EX-2C or UltraFlex.

Clean Up

Clean up spills, and equipment with Endura high strength gun wash, Endura epoxy reducer or Endura EX-2C thinner.

Follow manufacturer's safety recommendations when using any solvent.

Ordering Information (sizing)

Available in Gallon and Pail kits.

Other Custom sizes may be available.

Gallon Kit Comp A FEA0061-035 (3.15L)
 Comp B FEB0041-022 (0.63L)

Pail Kit Comp A FEA0061-055 (15.75L)
 Comp B FEB0041-035 (3.15L)

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.

Specifications

Solvent Resistance	ASTM D4752	50 MEK Rubs; No Failure
Impact resistance	ASTM D2794	40 in. lbs; NO failure
Salt spray resistance (1000 Hrs)	ASTM B117	NO blistering, cracking or delamination of film. No more than 3/16 inch rust
Service Temp	-40°C to +121°C -40°F to 250°F	
Percentage of zinc in the dry film	40%	

Safety Precautions

Please refer to all Safety Data Sheets (SDS) before using this product. SDS sheets can be found on our website at www.endura.ca.