



Endura Caliber Primer (grey) 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**

Theoretical Solids Content:

Volume: 60%

Shelf Life*

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

*For unopened product.

Pot Life of Mixed

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



Suitability

Endura Caliber 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.

Endura Caliber Low VOC is formulated to exceed the Canadian Automotive refinishing guidelines for VOC levels in primers.



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

5 parts by volume of part A [FEA0061] (Light Grey)
1 part by volume of part B [FEB0041]

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.

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

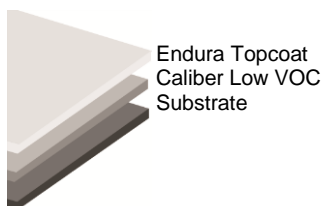
[FTH0016] Low VOC Epoxy Reducer- Regular (VOC = 0 g/L, 0 lbs/gal)

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



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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Application Method

Endura Caliber Primer (grey) 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.



Recommended Film Build Thickness and Cover Rate

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 dry (62.5 – 125 microns).

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

Drying Time*

	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) 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
Salt spray resistance (1000 hours)	ASTM B117	NO blistering, cracking or delamination of film. No more than 3/16 inch rust
service temperature range**	-40°C to +121°C	-40°F to 250°F
Percentage of zinc in the dry film		40%
VOC	248 grams/liter (2.07 lbs/gallon)	



Clean Up

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

Notes

DO NOT apply over solvent-sensitive paints. Blistering will result.

