



Technical Data Sheet (TDS)

Product Description

Endura Caliber Primer is a high solid, low VOC, surface tolerant, epoxy zinc primer. It provides superior adhesion, cathodic corrosion protection and impact resistance.

Product features:

- Provides superior corrosion protection
- Ability to fill sandblast profile in one coat
- Excellent impact resistance
- No induction required
- **VOC Compliant**

Recommended Uses

Endura Caliber Primer is intended for industrial applications; either new build or maintenance. Caliber Primer is suitable for application on properly sanded or sandblasted steel. Caliber primer is also suitable for properly prepared galvanized or zinc coated substrates. This primer must be topcoated to achieve the best results.

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
[Part Number varies with color]

1 part by volume of component B [FEB0041]

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

Product Characteristics

Finish: Low Gloss

Volume Solids Mixed: 55% +/- 2%

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

VOC Mixed (Unreduced) (EPA Method 24):

Grey: 250 g/l (2.089 lb/gal)

Note: All colors are below 250g/l.
VOC levels will vary per color.

Shelf Life:

Component A: 3 years at 77°F (25°C)

Component B: 2 years at 77°F (25°C)

Note: For unopened product

Surface Prep

Surface must be free of all contaminants such as dust, oil, grease and salt. It is recommended that all steel and other ferrous surfaces be sandblasted a minimum of SSPC- SP6; Optimally for the best corrosion protection it should be SSPC- SP5 SSPC- SP10 (White or Near White Blast) or mechanically sanded with 80 grit sand paper.

All other substrates refer to the Endura recommended surface preparation instruction sheets or contact your Endura representative.

Application Method

Caliber Primer can be applied using most spray painting systems, although electrostatic sprayers are not recommended.

Apply 1 -2 coats as required to achieve the desired film thickness. Allow sufficient flash time between coats especially with higher film builds applied (20-30mins)

Note: Agitation is not required while spraying; the zinc is fully suspended in the coating.



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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 | |

Spray Viscosity

Using a Ford 4 Cup (White)

| | |
|----------------|----------------------|
| 22-23 Seconds* | Reduce as necessary* |
| Conventional | Airless |

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

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

VOC content of the following Reducers: (0g/l, 0 lbs/gal)

[FTH0016] Low VOC Epoxy Reducer – Regular

[FTH00027] Low VOC Epoxy Reducer - Slow

Film Build

Caliber Primer has a recommended film build thickness of:

**Wet (unreduced): 5.5 – 9.0 mils wet
(140 – 230 microns)**

Dry: 3.0 – 5.0 mils DFT (76 – 127 microns)

Note: The recommended dry film thickness is above the blast/ sanding profile.

Theoretical coverage at 1.0 mil (25 microns)
DFT: 883 ft² per gallon at 100% transfer efficiency.

Dry Times

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

Note: Dry Times are subject to ambient conditions (temperature and humidity) and good airflow and film build of primer.

For best results surface temperature must be 86°F (30°C) or less before topcoating.

Maximum re-coat window without sanding is 3 Days at 68°F (20°C)

Recommended Sanding 180 – 220 grit after the topcoat window has been exceeded.

For improved scheduling please contact your Endura Representative.

Topcoating Information

Caliber Primer can be topcoated with the entire range of Endura topcoat products.

Clean Up

Clean all equipment immediately after use with Endura high strength gun wash, Endura epoxy reducer or Endura EX-2C thinner.

Follow manufacturer's safety recommendations when using any solvents



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Ordering Information (sizing)

Available in Gallons and Pails.
Other Custom sizes may be available.

| 1 Gallon Kits: | | |
|----------------|-------------|--------|
| Comp A - Grey | FEA0061-035 | 3.15 L |
| Comp A - Black | FEA0060-035 | 3.15 L |
| Comp B | FEB0041-022 | 0.63L |

| 5 Gallon Kits: | | |
|----------------|-------------|---------|
| Comp A - Grey | FEA0061-055 | 15.75 L |
| Comp A - Black | FEA0060-055 | 15.75 L |
| Comp B | FEB0041-035 | 3.15 L |

Environmental Conditions

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

Note: 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.