

## Corline Urethane Primer

### Technical Data Sheet (TDS)

#### Product Description

**Endura Corline Urethane Primer** is a medium solids two-component urethane primer. It provides excellent corrosion resistance and superior adhesion to a wide variety of substrates.

#### Product features:

- Fine grind sprays like topcoat
- Wet on wet application
- Suitable in thin film applications
- Quick dry time
- No induction time required

#### Recommended Uses

Endura Corline Urethane Primer is intended for industrial applications; either new build or maintenance. Corline Urethane Primer is suitable for application on steel, aluminum, fiberglass, reinforced plastics, wood, existing finishes, polyester fillers and other ferrous metals. This primer must be topcoated to achieve the best results.

#### Mix Ratio

4 parts by volume of component A [FUPA0001]  
1 part by volume of component B [FUPB0001]

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

#### Product Characteristics

**Finish:** low gloss

**Volume Solids Mixed:** 41% +/- 2%

**Pot Life:** 8 Hours at 77°F (25°C) and 50% RH

**VOC Mixed (Unreduced)**(EPA Method 24):

Yellow: 519 g/l (4.331lbs/gallon)

**Note: VOC varies with 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 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

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

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

#### 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	10-14 oz/min
Air assist Airless	9-17 thou	500-1,500 psi	
Airless	9-13 thou	1,500-3,000 psi	

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#### Spraying Viscosity

Using a Ford 4 Cup (White)

16 Seconds*	Reduce as necessary*
Conventional	Airless

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

**NOTE: Thinning not typically required.**

#### Film Build

Corline Urethane Primer has a recommended film build thickness of:

**Wet (unreduced): 5.0 – 8.5 mils wet  
(125 – 215 microns)**

**Dry: 2.0 – 3.5 mil dry (45–90 microns)**

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

**Note: Loss of topcoat adhesion may result if recommended film build parameters are not followed.**

#### Dry Times

	68°F (20°C)	86°F (30°C)	104°F (40°C)
<b>Dust Free</b>	1 Hour	30 Minutes	15 Minutes
<b>Topcoat</b>	1 Hour	30 Minutes	15 Minutes
<b>Full Cure</b>	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  
24 Hours at 68°F (20°C)

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

Note: For improved scheduling please contact your Endura representative

#### Topcoating Information

Corline Urethane 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 solvent.

#### Ordering Information (sizing)

Available in: Gallons, Drums

Other custom sizes may be available.

5 Quarts		
Comp A - Yellow	FUPA0001-030	1 Gal
Comp B	FUPB0001-020	1 Qt.

Drum Kits:		
Comp A - Yellow	FUPA0001-084	190L
Comp B	FUPB0001-085	205L

#### 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.**

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#### Specifications

Impact resistance	ASTM D2794	40 in. lbs; no failure
Flexibility	ASTM D522	1/8" mandrel bend: no failure
Water Immersion	ASTM D1308	Excellent
Solvent Resistance	ASTM D4752	100 MEK rubs; no failure
Service Temp Limits	-40°C to +204°C -40°F to 400°F	

#### 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](http://www.endura.ca).