Endura Manufacturing Co. Ltd
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www.endurapaint.com

Impact 321 (Neutral)

Technical Data Sheet (TDS)

Product Description

Impact 321 (Neutral) is polyurethane, liquid rubber hybrid coating that provides a tough, durable, abrasion resistant finish for a wide variety of DIY applications. Impact 321(Neutral) can be tinted with EX-2C to provide a large selection of colors.

Product features:

- Ability to build up to 100 mils in one coat.
- Surface texture can be easily modified
- High degree of flexibility
- Can be used as an Anti-Skid Coating
- Can be tinted with EX-2C Topcoat
- VOC compliant.

Recommended Uses

Impact 321 (Neutral) is intended for industrial applications, either new build or maintenance.

Impact 321 (Neutral) is a heavy wear product for multiple service applications such as an impact absorber for high maintenance zones on equipment and vehicles.

Impact 321 (Neutral) may also be used as a rubberized coating for marine applications.

Industries:

- Oilfield & Energy Services
  - Well Service Vehicles
  - VAC Trucks
- Waste and Recycling Industry
  - Garbage Trucks
- Trailers and Rolling Stock
- Logging Industry
- Marine (above the water line)
- Vehicle floors, fenders, and more

Mix Ratio

Step 1: Mix 1 Gallon of Impact 321 (Neutral)

3 parts by volume of component A **[FUA1250]**
1 part by volume of component B **[FUB1200]**

Step 2: Mix 2 pints of EX-2C Color

1 part by volume of component A **[CLRXXXXX] (Part Number varies with color)**
1 part by volume of component B **[FUB0100]**

Step 3:

Mix the 1 gallon of mixed Impact 321 (Neutral) with the 2 pints of mixed EX-2C color.

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

Product Characteristics

Volume Solids Mixed: (Unreduced) **Based on White 120 - FUA0120 mixed per mix ratio indicated**	64% ± 2%
Volume solids will vary by color	
Pot Life: (77°F (25°C) and 50% RH)	30 Minutes
VOC Mixed (Unreduced): EPA Method 24 **Based on White 120 - FUA0120 mixed per mix ratio indicated**	210 g/l 1.754 lb /gal
VOC content will vary with each color **Note: All colors are below 430 g/l (3.588 lb/gal)**	
Shelf Life:	
Component A	1 year
Component B	1 year
For unopened product (77°F (25°C))	

Surface Preparation

Steel Substrates:
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 to a minimum of SSPC-SP6 or mechanically sanded with 80 grit sandpaper and primed with an appropriate Endura Primer.

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Impact 321 (Neutral) must be applied over a primer. Apply the Impact 321 (Neutral) over the Endura primer sealers and surfacers within 24 hours.

If the primer has been allowed to dry for more than 24 hours, it is recommended to apply a thin film tie coat of either Epoxy Primer Sealer or Delta Sealer prior to the application of Impact 321 (Neutral) to ensure good adhesion.

Previously painted surfaces:
Scuff sand the surface with 240-280 grit sandpaper and apply a tie coat primer such as EP Sealer or other approved Endura primers.

Contact your Endura Representative for further information.

Application Method

Impact 321 (Neutral) is sprayed with a pneumatic Shutz or undercoat gun. Impact 321 (Neutral) cannot be sprayed with a standard paint gun.

If you wish to retain a high gloss finish or long term UV stability, topcoating with EX-2C polyurethane is recommended.

Spray Gun Setup

Feed Type	Fluid Tip	Application Pressures (heel of gun)	Fluid Delivery
Shutz Gun		40-50 psi	

Spray Viscosity

Important Information

Spraying viscosity and thinning will manipulate and affect the desired surface finish.

To achieve a desired spraying viscosity and desired surface finish, Impact 321 (Neutral) may be thinned with Xylol up to 30% to achieve a smoother textured finish.

FTH0022 – Xylol

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

Film Build

Impact 321 has a recommended film build thickness as a topcoat over primer of:

Wet: WFT Unreduced	**29.0 – 147 mils**	**725 – 3675 microns**
Dry: DFT	**20.0 – 100.0 mils**	**500 – 2500 microns**

Theoretical coverage at 1.0 mil (25 microns) DFT: 1026 ft² per gallon at 100% transfer efficiency.

Dry Times

Drying time will vary depending upon temperature and film thickness.

	68-77°F (20-25°C)
Dry to Touch	3-4 Hours
Dry to Topcoat	4 Hours Optimal 8-12 Hours
Dry to Handle	1 Day
Full Cure	5-7 Days

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

For questions about scheduling please contact your Endura Representative.

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Topcoating Information

Impact 321 (Neutral) can be topcoated with Endura EX-2C or UltraFlex.

Topcoating is recommended for long term UV stability.

Clean Up

Clean all equipment immediately after use with Endura High Strength Gun Wash, or Endura EX-2C thinner or Xylol.

Follow manufacturer's safety recommendations when using any solvents

Ordering Information (sizing)

Available in Shutz Cans and Gallons.
Other custom sizes may be available.

1 mixed gallon Impact Neutral (3.78l)		
Comp A Impact 3:1 Neutral	**FUA1250-033**	**3 quarts (2.84l)**
Comp B	**FUB1200-020**	**1 quart (946 ml)**

2 mixed pints EX-2C Topcoat		
Comp A Part numbers vary by color	**CLRXXXXX-010**	**1 pint (473ml)**
Comp B	**FUB0100-010**	**1 pint (473ml)**

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.

For use outside this range please contact your Endura Representative.

Specifications

Hardness	ASTM D2240	70±5 Shore A
Solvent Resistance	ASTM D4752	50 MEK Rubs; No Failure
Adhesion Cross Cut	ASTM D3002	5 (100/100)
Impact Resistance	ASTM D2794	100 in. lbs; NO failure
Taber Abrasion (1000 cycles CS-17)	ASTM D4060	<10 mg loss
Service Temp	<300°F	<148°C

Safety Precautions

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