Endura Manufacturing Co. Ltd
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Impact 321

Technical Data Sheet (TDS)

Product Description

Impact 321 is polyurethane, liquid rubber hybrid coating that provides a tough, durable, abrasion resistant finish for a wide variety of DIY applications.

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.
- Available in multiple colors.
- VOC Compliant.

Recommended Uses

Impact 321 is intended for industrial applications, either new build or maintenance. It is a heavy wear product for multiple service applications such as an impact absorber for high maintenance zones on equipment and vehicles. Impact 321 may also be used as a rubberized coating for marine applications.

Industries:
- Oilfield & Energy Services
- Waste and Recycling Industry
- Trailers and Rolling Stock
- Logging Industry
- Marine (above the water line)
- Vehicle floors, fenders, and more

Product Characteristics

Volume Solids Mixed: (Unreduced) FUA1200: FUB1200 (3:1)	70% ± 2%
Pot Life: (77°F (25°C) and 50% RH)	30 Minutes
VOC Mixed (Unreduced):EPA Method 24 **FUA1200: FUB1200 (3:1)**	193 g/l 1.614 lb /gal
VOC content will vary with each color All colors are below 430 g/l (3.588 lb/gal)	
Shelf Life: For unopened product (77°F (25°C))	
Component A	1 year
Component B	1 year

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.

Impact 321 must be applied over a primer. Apply the Impact 321 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 to ensure good adhesion.

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

Contact your Endura Representative for further information.

Mix Ratio

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

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

Application Method

Impact 321 is sprayed with a pneumatic Schutz or undercoat gun. Impact 321 cannot be sprayed with a standard paint gun.

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**
Schutz Gun		50-100 psi	

Spray Viscosity: Important Information

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

To achieve a desired spraying viscosity and desired surface finish reducing with Xylol up to 30% to achieve a smoother textured finish.

FTH0022 – Xylol

Film Build

Impact 321 recommended film build thickness:

Wet: WFT Unreduced	29 – 147 mils	725 – 3675 microns
Dry: DFT	20 – 100 mils	500 – 2500 microns

Theoretical coverage at 1.0 mil (25 microns)
DFT: 1122 ft² per gallon at 100% transfer efficiency.

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Dry Times

	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

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.

Topcoating Information

Impact 321 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)

Product lead times may apply.
Please contact your Endura Representative for further information regarding stock availability and lead times.

Impact 321		**1 mixed gallon (3.78l)**
Comp A - White	**FUA1200-033**	**3 quarts (2.84l)**
Comp A - Black	**FUA1201-033**	**3 quarts (2.84l)**
Comp A – Red 150	**FUA1207-033**	**3 quarts (2.84l)**
Comp B	**FUB1200-020**	**1 quart (946 ml)**

Other custom sizes may be available.

Contact your Endura Representative for information on other colors.

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 (1Kg.;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.

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