



## 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

<b>Volume Solids Mixed: (Unreduced)</b> <b>Component A: FUB1200 (3:1)</b> <b>Based on White 120 FUA0120</b>	64% ± 2%
<b>Volume solids will vary by color</b>	
<b>Pot Life:</b> (77°F (25°C) and 50% RH)	30 Minutes
<b>VOC Mixed (Unreduced):</b> EPA Method 24 <b>Component A: FUB1200 (3:1)</b> <b>Based on White 120 FUA0120</b>	210 g/l 1.754 lb /gal
<b>VOC content will vary with each color</b> <b>Note: All colors are below 430 g/l (3.588 lb/gal)</b>	
<b>Shelf Life:</b>	
<b>Component A</b>	1 year
<b>Component B</b>	1 year
<b>For unopened product (77°F (25°C))</b>	



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#### 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(Neutral) must be applied over a primer.

Impact 321(Neutral) should be applied over the Endura primer sealers and surfacers when they are wet and still solvent sensitive. In most cases this is within 30 - 60 minutes of application of the primer. If using a high build primer this time may be extended.

If the primer has been allowed to dry for more than 12 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

**Contact your Endura Representative for further information.**

##### 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.

#### 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.

**Note: 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:

<b>Wet: WFT Unreduced</b>	<b>29.0 – 147 mils</b>	<b>725 – 3675 microns</b>
<b>Dry: DFT</b>	<b>20.0 – 100.0 mils</b>	<b>500 – 2500 microns</b>

Theoretical coverage at 1.0 mil (25 microns) DFT: 1026 ft<sup>2</sup> per gallon at 100% transfer efficiency.

#### Dry Times

Drying time will vary depending upon temperature and film thickness.

	<b>68-77°F (20-25°C)</b>
<b>Dry to Touch</b>	3-4 Hours
<b>Dry to Topcoat</b>	4 Hours Optimal 8-12 Hours
<b>Dry to Handle</b>	1 Day
<b>Full Cure</b>	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.

**Note: 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.

<b>1 Mixed Gallon Impact Neutral</b>		
<b>Comp A Impact 3:1 Neutral</b>	<b>FUA1250-033</b>	<b>3 Qts.</b>
<b>Comp B</b>	<b>FUB1200-020</b>	<b>1 Qt.</b>

<b>2 Mixed Pints EX-2C Topcoat</b>		
<b>Comp A Part numbers vary by color</b>	<b>CLRXXXXX-010</b>	<b>1 Pt.</b>
<b>Comp B</b>	<b>FUB0100-010</b>	<b>1 Pt.</b>

#### 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

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](http://www.endurapaint.com).