



UltraFlex Primer

Technical Data Sheet (TDS)

Product Description

UltraFlex Primer is a two-component Direct to Metal polyurethane primer. UltraFlex Primer offers good build characteristics along with good flexibility.

Product features:

- DTM
- High Solids
- Self-leveling
- 3 day topcoat window
- Excellent flexibility
- Can be topcoated in 60 minutes
- VOC Compliant

Recommended Uses

UltraFlex Primer is intended for industrial applications; either new build or maintenance. UltraFlex Primer is suitable for application on properly degreased and prepared steel surfaces in a DTM application. UltraFlex Primer can also be applied on sanded or sandblasted steel, and properly prepared aluminum, fiberglass, reinforced plastics, existing finishes, and polyester fillers. This must be topcoated to achieve the best results.

Industries:

- Oilfield & Energy Services
 - Well Service vehicles
 - Well Services Equipment
- Cranes and Construction Equipment
- Trailers
- Waste and Recycling Industry
 - Garbage Trucks
- Marine (above the water line)

Mix Ratio

3 part by volume of component A **[FUPA0100]**
1 part by volume of component B **[FUPB0100]**
1 part by volume of Thinner **[FTHXXXX]**

Low VOC: Low VOC Topcoat Reducer **[FTH0021]**
Non VOC: Medium Topcoat reducer **[FTH0014]**

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

Product Characteristics

Volume Solids Mixed: FUPA0100:FUPB0100: FTH0021 (3:1:1)	57% ± 1%
Pot Life: (77°F (25°C) and 50% RH)	8 Hours
VOC Mixed (Unreduced): EPA Method 24 FUPA0100:FUPB0100: FTH0021 (3:1:1)	143 g/l 1.193 lb /gal
Shelf Life:	
Component A	3 years
Component B	2 years
For unopened product (77°F (25°C))	

Surface Preparation

Surface must be free of all contaminants such as dust, oil, grease and salt.

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

Application Method

UltraFlex Primer can be applied using most spray systems.

Apply a single coat. If a second coat is required to achieve the desired film build, allow sufficient flash time between coats (20-30mins)

Spray Gun Setup

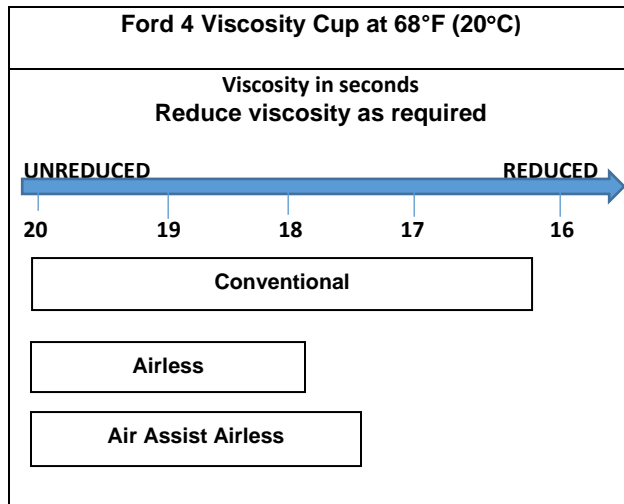
Feed Type	Fluid Tip	Application Pressures (heel of gun)	Fluid Delivery
Siphon Feed	1.4-2.0 mm	40-50 psi	
Gravity Feed	1.4-2.0 mm	30-40 psi	
Pressure Feed	1.0-1.8 mm	50-60 psi	12-16 oz/min
Air Assist Airless	9-13 Thou	1,000-1,800 psi	
Airless	9-13 Thou	1,700-3,000 psi	



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Spraying Viscosity



Note: Spraying viscosity and thinning will depend on ambient conditions, spray equipment used, and the desired surface finish. If additional thinning is required, the following are the recommended thinners.

Medium Topcoat Reducer-Regular [FTH0014] – Per mixing Ratio

To maintain VOC compliance, UltraFlex Primer may be thinned with Endura Low VOC Topcoat Reducers. VOC content of the following Reducers: (0g/l, 0lbs/gal)

Low VOC Topcoat Reducer-Regular [FTH0021] – Per mixing Ratio

Film Build

UltraFlex Primer has a recommended film build thickness of:

Wet: WFT Unreduced	5.5 – 9.0 mils	140 – 230 microns
Dry: DFT	3.0 – 5.0 mils	76 – 127 microns

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

Theoretical coverage at 1.0 mil (25 microns)
DFT: 915 ft² per gallon at 100% transfer efficiency.

Dry Times

	68°F (20°C)
Topcoat	1 hour
Dry to Touch	8 hours
Dry to Handle	24 hours
Full Cure	7-9 Days

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

Important note: The use of Supercatalyst I and II will accelerate drying times and reduce the recoat window.

Refer to the Supercatalyst I and II Technical Data Sheets for product use instructions.

For best results surface temperature must be 86°F (30°C) or less before topcoating. Maximum re-coat window without sanding is 72 hours at 68°F (20°C) Recommended Sanding 220 - 320 grit after the topcoat window has been exceeded.

For improved scheduling please contact your Endura Representative

Topcoating Information

UltraFlex 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, or Endura EX-2C thinner.

Follow manufacturer's safety recommendations when using any solvent.



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Ordering Information (sizing)

Available in Gallons and 5 Gallon Pails
Other custom sizes may be available.

5 Quart		
Comp A - Grey	FUPA0100-033	3 Qts.
Comp B -	FUPB0100-020	1 Qt.
Thinner Low VOC Topcoat Reducer	FTH0021-020	1 Qt.
OR		
Thinner Medium Topcoat Reducer	FTH0014-020	1 Qt.

5 Gallons		
Comp A - Grey	FUPA0100-053	3 Gals.
Comp B -	FUPB0100-030	1 Gal.
Thinner Low VOC Topcoat Reducer	FTH0021-030	1 Gal.
OR		
Thinner Medium Topcoat Reducer	FTH0014-030	1 Gal.

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

Solvent Resistance	ASTM D4752	100 MEK Rubs; NO Failure
Impact resistance (direct)	ASTM D2794	100 in. lbs; NO failure
Flexibility	ASTM D522	1/8 mandrel bend; NO failure
Service Temp	-40°F to 360°F	-40°C to 182°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.