

ENDURA PAINT

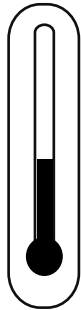
QUICK START GUIDE



Primer > HFE3080

STEP 01

Temperature



20-25 °C*
68-77 °F*

- ✓ Air,
- ✓ Product &
- ✓ Substrate

* Consult your Endura Representative for use outside these ranges.

STEP 02

Product Preparation

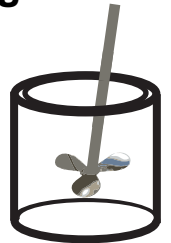


5 Part Component A
1 Part Component B

STEP 03

Mixing

2
Minutes*



Paint must be thoroughly mixed.

* Additional mixing time is required in cooler temperatures.

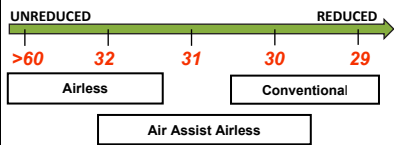
STEP 04

Spraying Viscosity



Ford 4 Viscosity Cup at 68°F (20°C)

Viscosity in seconds
Reduce viscosity as required



STEP 05

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 | 40-50 psi | 10-14 oz/min |
| Air Assist Airless | 11-17 Thou | 1,000-1,800 psi | |
| Airless | 11-17 Thou | 1,700-3,000 psi | |

STEP 06

Application



5.5 - 9.0
mils wet



3.0 - 5.0
mils DFT

Current TDS revision 1.7

Want to learn more?

www.endurapaint.com

Consult the Technical Data Sheet for complete instructions.

For technical assistance call: **1-800-661-9930**