

ENDURA PAINT

QUICK START GUIDE

Primer > HFE3080*

*Please ensure that the A and B are from the new batches.
The New HFE 3080 is NOT compatible with the older version.
Please DO NOT MIX version.
 Older batches of HFE3080 can be used if both the A and B are from batches prior to those listed below.
 FEA0056 - B123645
 FEB0056 - B123649
 If you are unsure, please contact Endura to confirm.

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

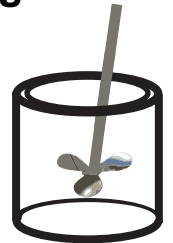


5 Part Component A
1 Part Component B

STEP 03

Mixing

2
Minutes*

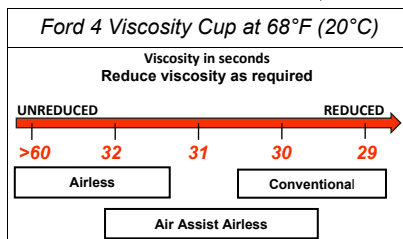


Paint must be thoroughly mixed.

* Additional mixing time is required in cooler temperatures.

STEP 04

Spraying Viscosity



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	13-17 Thou	1,000-1,800 psi	
Airless	13-17 Thou	1,700-3,000 psi	

STEP 06

Application



5.5 - 9.0
mils wet



3.0 - 5.0
mils DFT

Current TDS revision 1.8

Want to learn more?

www.endurapaint.com

Consult the Technical Data Sheet for complete instructions.

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