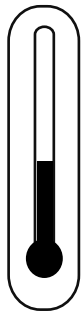


### Primer > HS-421 Surfacer

#### 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



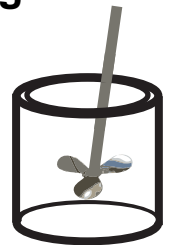
**4 Part Component A**  
**1 Part Component B\***

\* FUB0100 - Regular Component B, or  
FUB0112 - low VOC Component B

#### STEP 03

##### Mixing

**2**  
**Minutes\***



Paint must be thoroughly mixed.

\* Additional mixing time is required in cooler temperatures.

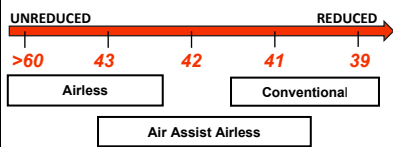
#### STEP 04

##### 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	1.6-2.0 mm	40-50 psi	
Gravity Feed	1.6-2.0 mm	30-40 psi	
Pressure Feed	1.4-2.0 mm	50-60 psi	10-14 oz/min
Air Assist Airless	9-17 Thou	1,000-1,800 psi	
Airless	11-15 Thou	1,700-3,000 psi	

#### STEP 06

##### Application



**6.0 - 11.0**  
**mils wet**



**3.0 - 5.0**  
**mils DFT**

Current TDS revision 1.6

Want to learn more?

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

Consult the Technical Data Sheet for complete instructions.

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