ENDURA PAINT

QUICK START GUIDE

Primer > MetalTek

STEP 01

Temperature

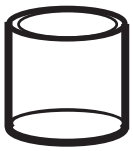
20-25 °C*
68-77 °F*

- Air,
- Product &
- Substrate

** Consult your Endura Representative for use outside these ranges.*

STEP 02

Product Preparation

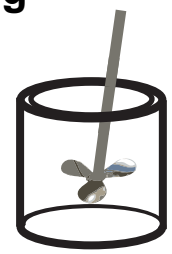


SINGLE Component

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

UNREDUCED — REDUCED

>60	34	33	32	30

Airless | Conventional

Air Assist Airless

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	1.4-2.0 mm	50-60 psi	10-14 oz/min
Air Assist Airless	9-17 Thou	1,000-1,800 psi	
Airless	13-17 Thou	1,700-3,000 psi	

STEP 06

Application

9.5 - 11.0 mils wet

6.0 - 7.0 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**