Always read the product’s technical data sheet for full instructions. For technical assistance please call 1-800-661-9930 or visit www.endura.ca

Quick Start Application Guide
EP-Hi Build Primer

1. **Product & Substrate Temperature**
   - 25°C (77°F)
   - 20°C (68°F)
   - 20-25°C (68-77°F)*

2. **Product Preparation**
   - 4 Part Component A
   - 1 Part Component B

3. **Mixing**
   - Paint must be thoroughly mixed.

4. **Spraying Viscosity**
   - 18 seconds
   - 40 seconds
   - Viscosity: 20-60 seconds using a Lemmer DIN 4 cup (blue)

5. **Spray Gun Setup**

<table>
<thead>
<tr>
<th>Feed Type</th>
<th>Fluid Tip</th>
<th>Application Pressure</th>
<th>Fluid Delivery</th>
</tr>
</thead>
<tbody>
<tr>
<td>Siphon Feed</td>
<td>1.6-1.8 mm</td>
<td>40-50 psi</td>
<td>10-14 oz/min</td>
</tr>
<tr>
<td>Gravity Feed</td>
<td>1.6-1.8 mm</td>
<td>30-40 psi</td>
<td></td>
</tr>
<tr>
<td>Pressure Feed</td>
<td>1.4-1.8 mm</td>
<td>50-60 psi</td>
<td>1700-3000 psi</td>
</tr>
<tr>
<td>Air Assist Airless</td>
<td>9-17 Thou</td>
<td>1000-1800 psi</td>
<td></td>
</tr>
<tr>
<td>Airless</td>
<td>13-17 Thou</td>
<td>1700-3000 psi</td>
<td></td>
</tr>
</tbody>
</table>

6. **Application**
   - Recommended Film Thickness
     - 4.0 - 7.5 mils wet
     - 3.0 - 6.0 mils DFT

* For use outside these ranges please consult your Endura paint representative.