Endura Manufacturing Co. Ltd.
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Roll Coat Polyurethane Topcoat

Technical Data Sheet (TDS)

Product Description

Roll Coat Polyurethane Topcoat is a high performance, chemically resistance polyurethane coating for interior or exterior service. It is formulated for brush and rolling and can be applied to areas that require long term, low maintenance life cycles.

Product features:

- High gloss and color retention
- Superior DOI – Depth of Image
- Outstanding resistance to chemicals and impact
- Standard solid colors

Not for use below the waterline.

Recommended Uses

Roll Coat is suitable for all types of watercrafts, metal components and machinery where a high-performance polyurethane coating is required. This product is intended for professional use.

Mix Ratio

2 parts by volume of component A [MBAXXXXX]
1 part by volume of component B [MBB0100]

The optimal finish is obtained when RH is 80% or less.
Thin as required using Endura EX-2C Slo Thinner **[FTH0090]** or Medium Topcoat Reducer **[FTH0014].**

Product Characteristics

Gloss: ASTM D2457	High: 90+ GU at 60°
Slight gloss variations will occur depending on color.	
Volume Solids Mixed:(Unreduced) : Standard White [MBA41271]	56% ± 2%
Volume solids will vary by color	
Pot Life: (77°F (25°C) and 50% RH)	8-10 Hours
Pot life is reduced when using Supercatalyst II [ITB0800]	
VOC Mixed (Unreduced): EPA Method 24: Typical	407 g/l (3.4 lb/gal)
Contact your Endura representative for exact VOC of each individual color	
Shelf Life:	2 years unopened
Available Sizes:	Gallons, 5 Gallon pails

Surface Preparation

Roll Coat can be applied over all recommended Endura Marine Epoxy and Urethane primers and sealers.

If the primer topcoat window has been surpassed, the primer should be sanded with 240 – 280 grit sandpaper or 3M™ red abrasive pads to achieve inter-coat adhesion. All sanding dust must be blown off prior to application of the topcoat.

Application

Roll Coat can be applied by brush, roller or spray using most spray-painting systems.
Ensure that any solvent absorbent primer surfacers are properly sealed with a primer sealer prior to application of the topcoat.

Spraying: Apply two single wet coats. It is recommended that a thinner first coat be applied at 1.5 – 2.0 mils wet, followed by a second wet coat of 2.0 - 3.5 mils wet. Recommended 30 – 40 minutes between coats.

Brushing or Rolling: For brushing use a natural hair bristle brush or for rolling a short (1/8") pile solvent resistant roller. Apply 1-2 coats as required to achieve the desired film build. Allow sufficient flash time between coats (20-30 minutes).

Be aware when more than three coats of paint are applied in any given 12-hour shift (including primer, topcoats, and clear coat). If more than 3 coats have been applied, wait 10-12 hours is recommended to allow for proper solvent evaporation.

After 16 hours Roll Coat must be sanded prior to applying another coat to achieve inter-coat adhesion. Mechanical sanding with 220-320 grit is recommended before reapplication.

All recommendations, statements, and technical data contained herein are based on tests Endura Manufacturing Co. Ltd. believe to be reliable and correct, but accuracy and completeness of said tests are not guaranteed and are not to be construed as a warranty, either expressed or implied. User shall rely on his own information and tests to determine suitability of the product for the intended use and assumes all risks and liability resulting from his use of the product. Seller's and manufacturer's sole responsibility shall be to replace that portion of the product of this manufacturer which proves to be defective. Neither seller nor manufacturer shall be liable to the buyer of any third person for any injury, loss, or damage directly or indirectly resulting from use of, or inability to use, the product. Recommendations or statements other than those contained in a written agreement signed by an officer of the manufacturer shall not be binding upon the manufacturer or seller.

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Dry Times

Roll Coat			
	68°F (20°C)	**86°F (30°C)**	**104°F (40°C)**
Dust Free	2 Hours	1 Hour	30 Minutes
Full Cure	7 Days	5-6 Days	3-4 Days

Note: Dry Times are subject to ambient conditions (temperature and humidity), good airflow and film build of the topcoat.

Film Build

Roll Coat has a recommended film build thickness of:

Wet: WFT Unreduced	**3.5 – 7.0 mils**	**89 – 178 microns**
Dry: DFT	**2.0 – 4.0 mils**	**51 – 102 microns**

Theoretical coverage at 1.0 mil (25 microns) average DFT: 898 ft² per gallon at 100% transfer efficiency.

Clean Up

Clean all equipment immediately after use with a High Strength Gun Wash, Endura epoxy reducers or Endura topcoat thinners/ reducers. Follow manufacturer's safety recommendations when using any solvent.

Environmental Conditions

For optimum coating performance product, substrate and ambient temperature should be between 68°F-77°F (20°C-25°C). To prevent condensation during application the surface temperature must be 5°F (5°F) or more above the dew point at all times. For use outside this range contact your Endura Representative.

Safety Precautions

Please refer to all Safety Data Sheets (SDS) before using this product. SDS sheets can be found on our website at www.enduramarinepaint.com

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