



Technical Data Sheet (TDS)

Product Description

CeraMaxx is a two-component spray-able ceramic novalac epoxy primer.

Product features:

- Excellent impact resistance
- Excellent abrasion resistance
- Excellent adhesion strength
- High build
- Excellent chemical resistance
- Excellent corrosion resistance
- Available in white, black & grey
- VOC Compliant

Recommended Uses

CeraMaxx is intended for industrial applications, either new build or maintenance. CeraMaxx is suitable for application on properly prepared steel, concrete, masonry, or other substrates where mechanical, chemical, and thermal protection is required. CeraMaxx must be topcoated to achieve the best results.

Industries:

- Oilfield & Energy Services
- Chemical Facilities
- Power Plants
- Water Treatment Facilities
- Waste and Recycling Industry

It is recommended that you contact your Endura Representative prior to application to discuss the preferred method and adaptations that best suit your needs.

Mix Ratio

4 parts by volume of component A [**FEAXXXX**]
(Part number varies with color)
1 part by volume of component B [**FEB2500**]

The recommended temperature when mixed is 68-77°F (20-25°C).

Product Characteristics

Finish:	Lo Gloss
Volume Solids Mixed: (Unreduced) FEA2500: FEB2500 (4:1)	82% ± 2%
Volume solids will vary by color	
Pot Life: (77°F (25°C) and 50% RH)	3 -5 Hours
VOC Mixed (Unreduced): EPA Method 24 FEA2500: FEB2500 (4:1)	156.5 g/l 1.307 lb /gal
VOC Content will vary by color Note: All colors are below 250g/l	
Shelf Life:	
Component A	3 years
Component B	2 years
For unopened product (77°F (25°C))	

Surface Preparation

Surface must be free of all contaminants such as dust, oil, grease and salt. It is recommended that all steel and other ferrous surfaces be sandblasted a minimum of SSPC- SP6 or mechanically sanded with 80 grit sandpaper.

CeraMaxx uses surface tolerant resins allowing for application over marginally prepared steel.

For all other substrates refer to the Endura recommended surface preparation instruction sheets or contact your Endura Representative.

Application Method

CeraMaxx can be applied using most spray painting systems.

Apply one to two single wet coats. Allow 30 minutes to a maximum of 4 hours flash time between coats depending on film build. Apply CeraMaxx in a crosshatch pattern.

For questions regarding application method, please contact your Endura Representative.

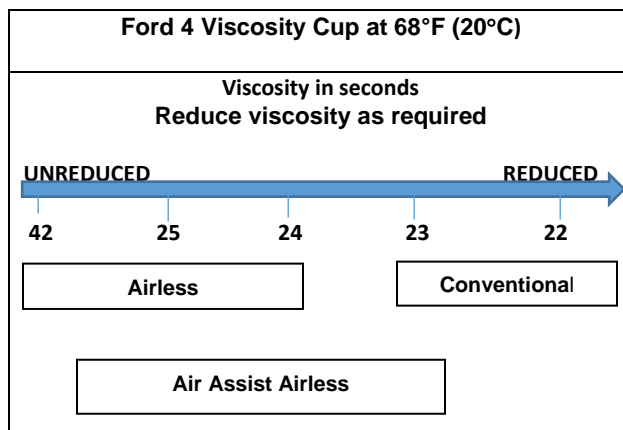


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Spray Gun Setup

Feed Type	Fluid Tip	Application Pressures (heel of gun)	Fluid Delivery
Siphon Feed	1.6-1.8 mm	40-50 psi	
Gravity Feed	1.3-1.6 mm	30-50 psi	
Pressure Feed	1.0-1.4 mm	55-65 psi	12-14 oz/min
Air Assist Airless	9-13 Thou	1,000-1,800 psi	
Airless	9-13 Thou	1,700-3,000 psi	

Spray Viscosity



Note: Spraying viscosity and thinning will depend on ambient conditions, spray equipment used, and the desired surface finish.

If required, thin CeraMaxx with a maximum of 18% Xylol to achieve the desired recommended spraying viscosity.

Film Build

CeraMaxx has a recommended film build thickness per coat of:

Wet: WFT Unreduced	Up to 10.5 mils	Up to 267 microns
Dry: DFT	Up to 8.0 mils	Up to 229 microns

Theoretical coverage at 1.0 mil (25 microns) DFT:
1214 ft² per gallon at 100% transfer efficiency.

Dry Times

	68-77°F (20-25°C)
Dry to Touch	4 - 6 Hours
Recoat Time	8 - 12 Hours
Dry to Handle	1 Day
Full Cure	5 - 7 Days

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

For best results surface temperature must be 86°F (30°C) or less before topcoating. Maximum re-coat window without sanding is 12 hours at 68°F (20°C). After the topcoat window has been exceeded CeraMaxx must be sanded to achieve inter-coat adhesion. Recommended 320-400 grit mechanical sanding before topcoating.

For improved scheduling please contact your Endura representative.

Topcoating Information

Ceramaxx can be topcoated with the entire range of Endura topcoat products.

Clean Up

Clean all equipment immediately after use with Endura High Strength Gun Wash, Endura epoxy reducer or Endura EX-2C thinner.

Follow manufacturer's safety recommendations when using any solvent.



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Ordering Information (sizing)

Available in Gallons and 5 Gallon Pails
Other custom sizes may be available.

Product lead times may apply.
Please contact your Endura Representative for further information regarding stock availability and lead times.

1 ¹ / ₄ mixed gallons (4.73l)		
Comp A - White	FEA2500-030	1 Gal. (3.78l)
Comp A - Grey	FEA2525-030	1 Gal. (3.78l)
Comp A - Black	FEA2550-030	1 Gal. (3.78l)
Comp B	FEB2500-020	1 Qt. (946ml)

5 mixed gallons (18.9l)		
Comp A - White	FEA2500-054	4 Gals. (15.1 l)
Comp A - Grey	FEA2525-054	4 Gals. (15.1 l)
Comp A - Black	FEA2550-054	4 Gals. (15.1 l)
Comp B	FEB2500-030	1 Gal. (3.78l)

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 (3°C) or more above the dew point at all times.

For use outside this range please contact your Endura Representative.

Specifications

Hardness	ASTM D3363	2H
Hardness	ASTM D2240	Shore D 90 Plus
Solvent Resistance	ASTM D4752	100 MEK Rubs; No Failure
Abrasion resistance (1000 cycles CS-17)	ASTM D4060	< 15mg loss
Impact resistance	ASTM D2794	100 in. lbs; NO failure
Adhesion Strength	ASTM D4541	Pull up; No failure between Substrate and CERAMAXX 3500psi plus
Adhesion Strength	ASTM D3002	Cross Cut 5 (100/100)
Sag	ASTM D4400	14 mils plus
Heat Resistance	ASTM D2485	
Dry Conditions	300-400 °F	149 - 205 °C
Wet Conditions	250-300 °F	121 - 149 °C
Chemical Resistance	ASTMD6943	
Immersion in NaOH 30%	1 Month: No Failure	
Immersion in Conc. HCL	1 Month: No Failure (color change)	
Immersion in Methanol 100%	1 Month: No Failure	
Immersion in Skydrol #5	1 Month: No Failure	

Safety Precautions

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