



### Technical Data Sheet (TDS)

#### Product Description

Endura CERAMAXX is a two-component sprayable ceramic novolac epoxy primer.

##### Product features:

- Very good impact resistance
- Very high abrasion resistance
- Very high 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 a ceramic novolac epoxy primer used to coat 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

**Note: It is recommend that you contact Endura prior to application to discuss the preferred method and adaptations that best suit your needs.**

#### Mix Ratio

4 parts by volume of component A [FEAXXX]  
1 part by volume of component B [FEB2500]

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

#### Product Characteristics

**Finish:** Low Gloss

**Volume Solids Mixed:** 76% +/- 1%

**Pot Life:** 3-5 Hours at 75°F (25°C) and 50% RH

**VOC Mixed (Unreduced):** (EPA Method 24):

**White FEA2500:** 212 g/l (1.772 lb /gal)

**Note: All colors are below 250g/l. VOC levels will vary per color.**

##### Shelf Life:

Component A: 3 years at 77°F (25°C)

Component B: 2 years at 77°F (25°C)

**Note: For unopened product**

#### Surface Prep

Surface must be free of all contaminants such as dust, oil, grease and salt. CERAMAXX can be applied to all metal surfaces that have been sand blasted with minimum SSPC SP-6 or mechanically sanded with 80 grit sand paper.

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

**Note: For questions regarding surface preparation, please contact your Endura Representative.**

#### Application Method

CERAMAXX can be applied using most spray painting systems.

Apply one or two single wet coats allowing 30 mins up to 4 hours between coats depending on film build.

Apply CERAMAXX in a cross hatch pattern

**Note: 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	1.3-1.4 mm	30-40 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	1,000-3,000 psi	

#### Spray Viscosity

Using a Ford 4 Cup (White)	
20-22 Seconds	Reduce as necessary*
Conventional	Airless

**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: (unreduced): up to 10.0 mils (255 microns)**

**Dry: up to 8.0 mils DFT (200 microns)**

Theoretical coverage at 1.0 mil (25 microns)

**Average DFT is: 1214 ft<sup>2</sup> 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 hrs at 68°F (20°C). After 12 hours CERAMAXX must be sanded to achieve inter-coat adhesion.

Sanding with 320-400 grit sandpaper before recoating is recommended.

**Note: 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.

Other custom sizes may be available.

<b>5 Quarts</b>		
<b>Comp A - White</b>	<b>FEA2500-030</b>	<b>1 Gal</b>
<b>Comp A - Grey</b>	<b>FEA2525-030</b>	<b>1 Gal</b>
<b>Comp A - Black</b>	<b>FEA2550-030</b>	<b>1 Gal</b>
<b>Comp B</b>	<b>FEB2500-020</b>	<b>1 Qt</b>

#### 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.

**Note: 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
Chemical Resistance	ASTMD6943	Immersion in NaOH 30% ; 1 Month <b>No Failure</b>
Chemical Resistance	ASTMD6943	Immersion in Conc. HCL; 1 Month <b>No Failure</b> ( only color change)
Chemical Resistance	ASTMD6943	Immersion in Metahnol 100% ; 1 Month <b>No Failure</b>
Chemical Resistance	ASTMD6943	Immersion in Skydrol #5 ; 1 Month <b>No Failure</b>
Heat Resistance	ASTMD2485	300-350 degrees F Dry Conditions 250-300 Degrees F Wet Conditions

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