



### 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

**Note: 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 [**FEAXXX**]  
(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

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

#### Surface Preparation

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 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 cross hatch pattern

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

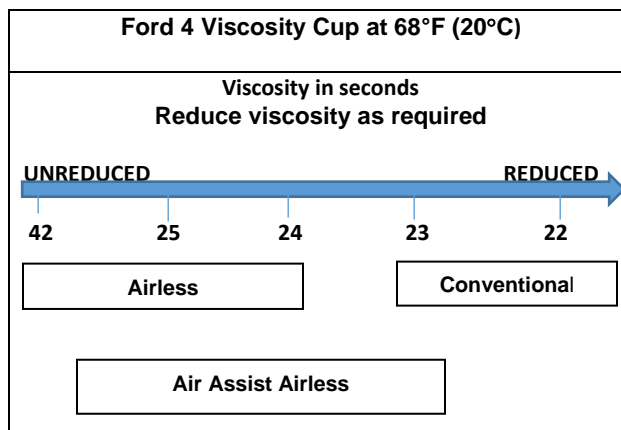


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#### Spray Gun Setup

| Feed Type          | Fluid Tip  | Application Pressures (heel of gun) | Fluid Delivery |
|--------------------|------------|-------------------------------------|----------------|
| Siphon Feed        | 1.6-1.8 mm | 40-50 psi                           |                |
| Gravity Feed       | 1.3-1.6 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:

|                           |                        |                          |
|---------------------------|------------------------|--------------------------|
| <b>Wet: WFT Unreduced</b> | <b>Up to 10.5 mils</b> | <b>Up to 267 microns</b> |
| <b>Dry: DFT</b>           | <b>Up to 8.0 mils</b>  | <b>Up to 229 microns</b> |

Theoretical coverage at 1.0 mil (25 microns)

**Average DFT is:** 1214 ft<sup>2</sup> per gallon at 100% transfer efficiency.

#### Dry Times

|                      | <b>68-77°F<br/>(20-25°C)</b> |
|----------------------|------------------------------|
| <b>Dry to Touch</b>  | 4 - 6 Hours                  |
| <b>Recoat Time</b>   | 8 - 12 Hours                 |
| <b>Dry to Handle</b> | 1 Day                        |
| <b>Full Cure</b>     | 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 12 hours, CERAMAXX must be sanded to achieve inter-coat adhesion.

Recommended sanding 320-400 grit after the topcoat window has been exceeded.

**Note: for improved scheduling please contact your Endura Representative.**

#### Topcoating Information

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



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#### 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.

#### Ordering Information (sizing)

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

| 5 Mixed Quarts |             |        |
|----------------|-------------|--------|
| Comp A - White | FEA2500-030 | 1 Gal. |
| Comp A - Grey  | FEA2525-030 | 1 Gal. |
| Comp A - Black | FEA2550-030 | 1 Gal. |
| Comp B         | FEB2500-020 | 1 Qt.  |

| 5 Mixed Gallons |             |         |
|-----------------|-------------|---------|
| Comp A - White  | FEA2500-054 | 4 Gals. |
| Comp A - Grey   | FEA2525-054 | 4 Gals. |
| Comp A - Black  | FEA2550-054 | 4 Gals. |
| Comp B          | FEB2500-030 | 1 Gal.  |

#### 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 No Failure                           |
| Chemical Resistance                     | ASTMD6943  | Immersion in Conc. HCL; 1 Month No Failure ( only color change)      |
| Chemical Resistance                     | ASTMD6943  | Immersion in Metahnol 100% ; 1 Month No Failure                      |
| Chemical Resistance                     | ASTMD6943  | Immersion in Skydrol #5 ; 1 Month No Failure                         |
| Heat Resistance                         | ASTMD2485  | 300-350 degrees F Dry Conditions<br>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).