



Epoxy Primer-Sealer

Technical Data Sheet (TDS)

Product Description

Endura Epoxy Primer Sealer is a two-component chrome free epoxy primer sealer designed for use on a variety of substrates. It provides good adhesion, hardness and corrosion resistance.

Product features:

- Ultra Smooth Finish
- Thin film coating
- Superior primer for aluminum
- Available in White
- VOC Compliant
- **Chrome Free**

Recommended Uses

Endura Epoxy primer sealer is intended for industrial applications; either new build or maintenance.

Epoxy Primer Sealer is suitable for application on properly sanded or sandblasted steel, and properly prepared aluminum, fiberglass, reinforced plastics, wood, existing finishes and polyester fillers. It is formulated for use on aluminum above the waterline in Marine applications. This primer must be topcoated to achieve the best results.

Industries:

- Marine (above the water line)
- Trailers
- Automotive refinishing

Mix Ratio

1 parts by volume of component A [FEA0082] White
1 part by volume of component B [FEB0081]

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

Product Characteristics

Finish: Low Gloss

Volume Solids Mixed: 29% +/- 2%

Pot Life: 10 Hours at 77°F (25°C) and 50% RH

VOC Mixed (Unreduced) (EPA Method 24):
White: 339 g/l (2.834 lb/gal)

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. It is recommended that all steel and other ferrous surfaces be cleaned to a minimum of SSPC- SP6 or mechanically sanded with 180 grit sand paper.

All other substrates refer to the Endura recommended surface preparation instruction sheets or contact your Endura representative.

Application Method

Epoxy primer sealer can be applied using most spray systems, although airless application is not recommended.

Apply 2 light coats. Allow sufficient flash time between coats (20-30mins).



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Spray Gun Setup

Feed Type	Fluid Tip	Application Pressures (heel of gun)	Fluid Delivery
Siphon Feed	1.3-1.4 mm	40-50 psi	
Gravity Feed	1.3-1.4 mm	40-50 psi	
Pressure Feed	1.0-1.2 mm	30-40 psi	7-10 oz/min
Air Assist Airless	9-11 Thou	1,000-1,800 psi	
Airless			

Spray Viscosity

Using a Ford 4 Cup (White)	
13 Seconds*	N/A*
Conventional	Airless

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

To maintain VOC compliance, thin Epoxy Primer Sealer with Endura Low VOC Epoxy Reducers.
VOC content of the following Reducers: (0g/l, 0 lbs/gal)

[FTH0016] Low VOC Epoxy Reducer – Regular
[FTH0027] Low VOC Epoxy Reducer - Slow

Film Build

The recommended film build thickness for the Epoxy Primer Sealer is:

**Wet (unreduced): 3.0 – 5.0 mils
(75 – 100 microns)**

Dry: 1.0 – 1.5 mils DFT (25 – 38 microns)

Note: The recommended dry film thickness is above the blast/ sanding profile.

Theoretical coverage at 1.0 mil (25 microns)
DFT: 462 ft² per gallon at 100% transfer efficiency.

Dry Times

	68°F (20°C)	86°F (30°C)	104°F (40°C)
Topcoat	1 Hour	45 Minutes	30 Minutes
Dry Hard	3-5 Hours		
Full Cure	7-9 Days	5-6 Days	3-4 Days

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

For best results surface temperature must be 86°F (30°C) or less before topcoating.

Maximum re-coat window without sanding is 24hrs at 68°F (20°C)

Recommended Sanding 220 – 320 grit after the topcoat window has been exceeded.

For questions about scheduling please contact your Endura representative.

Topcoating Information

Epoxy Primer Sealer 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 Quarts and Gallons

Other custom sizes may be available.

2 Quarts		
Comp A - White	FEA0082-020	1Qt
Comp B	FEB0081-020	1Qt

2 Gallons		
Comp A - White	FEA0082-030	1Gal
Comp B	FEB0081-030	1Gal

Specifications

Impact resistance	ASTM D2794	40 in. lbs; NO failure
Flexibility	ASTM D522	1/8 mandrel bend: NO failure
Service Temp	-40°C to +121°C -40°F to 250°F	

Safety Precautions

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

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.