



## Epoxy Primer Sealer

### Technical Data Sheet (TDS)

#### Product Description

**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

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

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> <b>FEA0082: FEB0081 (1:1)</b>	29% ± 2%
<b>Pot Life:</b> (77°F (25°C) and 50% RH)	10 Hours
<b>VOC Mixed (Unreduced):</b> EPA Method 24 <b>FEA0082: FEB0081 (1:1)</b>	339 g/l 2.834 lb /gal
<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. It is recommended that all steel and other ferrous surfaces be cleaned to a minimum of SSPC-SP6 or mechanically sanded with 180 grit sandpaper.

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 (20-30 minutes).



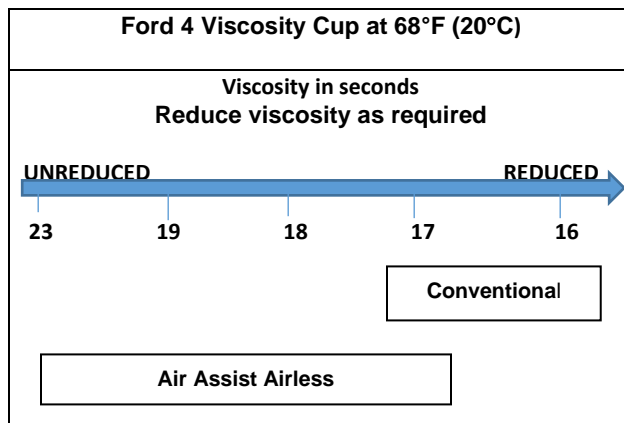
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### Technical Data Sheet (TDS)

#### 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	40-40 psi	
Pressure Feed	1.0-1.8 mm	30-40 psi	7 -10 oz/min
Air Assist Airless	9-11 Thou	1,000-1,800 psi	
Airless	N/A		

#### Spray Viscosity



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

If required, recommended spraying viscosity is achieved by reducing with one of the following Endura Low VOC Epoxy Reducers. These will maintain VOC compliance of Epoxy Primer Sealer.

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:

<b>Wet: WFT Unreduced</b>	<b>3.5 – 5.0 mils</b>	<b>89 – 127 microns</b>
<b>Dry: DFT</b>	<b>1.0 – 1.5 mils</b>	<b>25 – 38 microns</b>

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

Theoretical coverage at 1.0 mil (25 microns)  
DFT: 462 ft<sup>2</sup> per gallon at 100% transfer efficiency.

#### Dry Times

	68°F (20°C)	86°F (30°C)	104°F (40°C)
<b>Topcoat</b>	1 Hour	45 Minutes	30 Minutes
<b>Dry Hard</b>	3-5 Hours		
<b>Full Cure</b>	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

24hours at 68°F (20°C)

Recommended 220 – 320 grit sanding 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.



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### Technical Data Sheet (TDS)

#### 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 Quarts and Gallons  
Other custom sizes may be available.

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

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

Solvent Resistance	ASTM D4752	100 MEK Rubs; NO Failure
Impact resistance	ASTM D2794	65 in. lbs; NO Failure
Flexibility	ASTM D522	1/4 in. mandrel bend: NO failure
Service Temp Range	-40°F to 250°F	-40°C to 121°C

#### 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).