

EP-2C Sealer FC CF

Technical Data Sheet (TDS)

Product Description

EP-2C Sealer FC CF is a flexible two-component, epoxy urethane primer sealer containing corrosion inhibiting additives designed to be used to on a variety of substrates including fabric aircraft.

Product features:

- Superior adhesion and Flexibility
- Temperature service up to 200°C
- Non-sanding sealer
- Excellent adhesion to a wide variety of substrates
- Inter-coat adhesion greater than 2000 psi

Recommended Uses

EP-2C Sealer FC CF is intended for industrial applications; either new build or maintenance. In addition to use on polyester aircraft fabric, EP-2C Sealer FC CF can be used to protect metal and composite airplane parts (sandblasted steel and other non-ferrous metals after appropriate pre-treatment).

EP-2C Sealer FC CF can also be used as a sealer (tie coat) over existing cellulose Butyrate Dopes. This primer must be topcoated to achieve the best results.

Mix Ratio

1 part by volume of component A [**FUA0950**]
1 part by volume of component B [**FUB0820**]

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

Product Characteristics

Finish:	Lo Gloss
Volume Solids Mixed: (Unreduced) FUA0950: FUB0820 (1:1)	45% ± 1%
Pot Life: (77°F (25°C) and 50% RH)	6 Hours
VOC Mixed (Unreduced): EPA Method 24 FUA0950: FUB0820 (1:1)	478 g/l 3.991 lb /gal
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 cleaned to a minimum of SSPC-SP6 or mechanically sanded with 180 grit sandpaper.

Clean new fabric surfaces with methyl ethyl ketone (MEK) or isopropanol. Wipe with tack rag to remove any lint or dust.

For information on application over previously coated fabric please see the Endura Coating Fabric Covered Aircraft Guide.

Application Method

EP-2C Sealer FC CF can be applied using most spray painting systems. Air Assisted airless and Airless systems are not recommended

As a primer sealer for new Fabric:

New fabric must be coated with 2 coats of EP-2C Sealer FC CF. Apply one coat, brushing it into and through the weave of the material. While the brush coat is still wet, apply a second coat by spray application.

As a sealer for existing surfaces:

Apply a single coat, allow 1 hour drying time before applying Endura EX-2C SFC Topcoat.

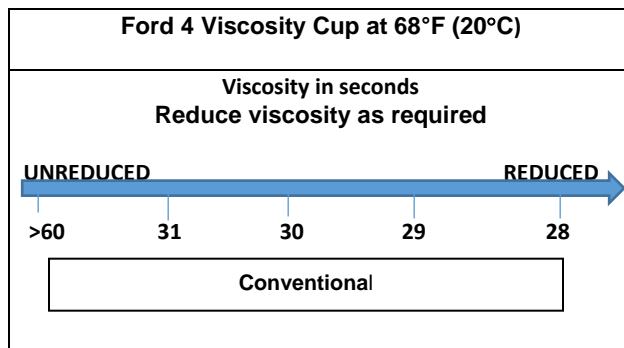
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Spray Gun Setup

Feed Type	Fluid Tip	Application Pressures (heel of gun)	Fluid Delivery
Siphon Feed	1.6-1.8 mm	40-50 psi	
Gravity Feed	1.6-1.8 mm	30-40 psi	
Pressure Feed	1.4-1.8 mm	50-60 psi	10-14 oz/min
Air Assist		N/A	
Airless		N/A	

Spraying 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 desired Endura topcoat thinner/reducer.

FTH0086 – EX-2C Thinner / Reducer
FTH0090 – Slo EX-2C Thinner /Reducer
FTH0014 – Medium Topcoat Reducer

Film Build

EP-2C FC CF has a recommended film build:

As a Primer/Sealer on new Fabric:

Wet: WFT Unreduced	3.0 – 5.5 mils	75 – 138 microns
Dry: DFT	1.5 – 2.5 mils	38 – 63 microns

As a Sealer:

Wet: WFT Unreduced	2.0 – 3.0 mils	50– 75 microns
Dry: DFT	1.0 – 1.5 mils	25 – 38 microns

Theoretical coverage at 1.0 mil (25 microns)
DFT: 721 ft² per gallon at 100% transfer efficiency.

Note: Loss of topcoat adhesion may result if recommended film build parameters are not followed.

Dry Times

	68°F (20°C)	86°F (30°C)	104°F (40°C)
Topcoat	60 Minutes	20 Minutes	10 Minutes
To Sand	6 Hours	3 Hours	1-2 Hours
Full Cure	7-9 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. Wet sandpaper is recommended.

For improved scheduling please contact your Endura Representative

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Topcoating Information

EP-2C Sealer FC CF 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.

Ordering Information (sizing)

Available in Pints, Quarts, Gallons and 5 Gallon Pails.

Other custom sizes may be available.

1 mixed quart (946ml)		
Comp A - Green	FUA0950-010	1 pint (473ml)
Comp B	FUB0820-010	1 pint (473ml)

2 mixed quarts (1.89l)		
Comp A - Green	FUA0950-020	1 quart (946ml)
Comp B	FUB0820-020	1 quart (946ml)

2 mixed gallons (7.56l)		
Comp A - Green	FUA0950-030	1 gallon (3.78l)
Comp B	FUB0820-030	1 gallon (3.78l)

10 mixed gallons (37.8l)		
Comp A - Green	FUA0950-050	5 gallons (18.9l)
Comp B	FUB0820-050	5 gallons (18.9l)

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

Solvent Resistance	ASTM D4752	100 MEK Rubs; NO Failure
Impact resistance	ASTM D2794	100in. lbs; NO Failure
Flexibility	ASTM D522	1/8 in. mandrel bend: NO failure
Service Temp Range	-40°F to 400°F	-40°C to 204°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.