



### Technical Data Sheet (TDS)

#### Product Description

**EP HiBuild Primer** is a high solid, high build, two-component epoxy primer. EP HiBuild Primer is ideally suited for heavy industrial uses and/or waterproofing requirements.

#### Product features:

- Proven for heavy industrial applications
- Waterproof capability at 10 mils dry film thickness
- High solids provide quick film build
- Excellent alkali and salt spray resistance
- VOC compliant

#### Recommended Uses

EP HiBuild Primer is intended for industrial applications; either new build or maintenance. EP HiBuild Primer is suitable for application on steel, aluminum, stainless steel, fiberglass, other ferrous metals and fiberglass reinforced plastics. This primer must be topcoated to achieve the best results.

#### Industrial Applications:

- Offshore Drilling Rigs
- Pulp Mills
- Chemical Plants
- Boats
- Bridges
- Marine

**This primer is not suitable for automotive applications.**

#### Mix Ratio

4 parts by volume of component A [**FEAXXXX**]  
(Part Number varies with color)

1 part by volume of component B [**FEB0275**]

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

#### Product Characteristics

|  |                          |
|--|--------------------------|
| <b>Finish:</b>   | Medium Gloss             |
| <b>Volume Solids Mixed: (Unreduced)</b><br><b>FEA0274: FEB0275 (4:1)</b>           | 73% ± 2%                 |
| Volume solids will vary by color   |                          |
| <b>Pot Life:</b><br>(77°F (25°C) and 50% RH)                                       | 6 Hours                  |
| <b>VOC Mixed (Unreduced):</b><br>EPA Method 24<br><b>FEA0274: FEB0275 (4:1)</b>    | 245 g/l<br>2.048 lb /gal |
| VOC content will vary with each color<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. It is recommended that all steel and other ferrous surfaces be sandblasted a minimum of SSPC-SP6 or mechanically sanded with 40 grit sandpaper.

**Note: For use on fiberglass or wood boat hulls, machine sand with 80 grit sandpaper. A minimum of 10 mils (250 microns) dry film thickness is required for waterproofing. Endura EX-2C Topcoat is not recommended below the waterline.**

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

#### Application Method

EP HiBuild Primer can be applied using most spray systems, although electrostatic sprayers are not recommended.

Apply 2-3 coats as required to achieve the desired film thickness. Allow sufficient flash time between coats especially with higher film builds applied (20-30minutes).

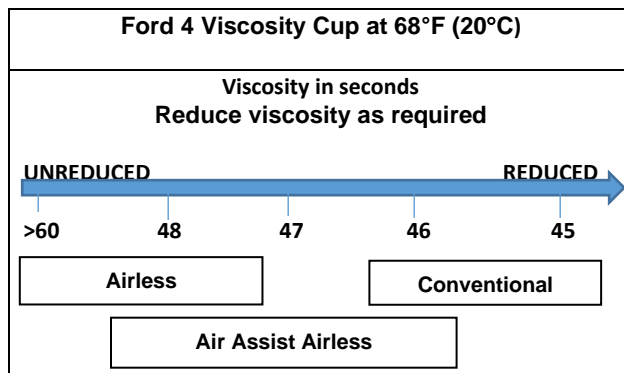


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#### Spray Gun Setup

| 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                           | 12-16 oz/min   |
| Air Assist Airless | 13-15 Thou | 1,000-1,800 psi                     |                |
| Airless            | 13-15 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, recommended spraying viscosity is achieved by reducing with one of the following Endura Low VOC Epoxy reducers. These will maintain VOC compliance of EP HiBuild Primer.

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

Endura EP HiBuild Primer has a recommended film build thickness of:

|                           |                       |                          |
|---------------------------|-----------------------|--------------------------|
| <b>Wet: WFT Unreduced</b> | <b>5.5 – 8.0 mils</b> | <b>140 – 203 microns</b> |
| <b>Dry: DFT</b>           | <b>4.0 – 6.0 mils</b> | <b>102 – 152 microns</b> |

**For waterproofing:**

|                           |                    |                      |
|---------------------------|--------------------|----------------------|
| <b>Wet: WFT Unreduced</b> | <b>13.6 mils +</b> | <b>345 microns +</b> |
| <b>Dry: DFT</b>           | <b>10 mils +</b>   | <b>254 microns +</b> |

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

Theoretical coverage at 1.0 mil (25 microns)  
DFT: 1173 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>   |             |             |              |
| <b>4 mils</b>    | 3 Hours     | 2 Hours     | 1 Hour       |
| <b>8 mils</b>    | 6 Hours     | 4 Hours     | 2 Hours      |
| <b>12 mils</b>   | 12 Hours    | 8 Hours     | 4 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 24 Hrs. at 68°F (20°C).

Recommended 180 – 220 grit sanding after the topcoat window has been exceeded.

For questions about scheduling please contact your Endura Representative.



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#### Topcoating Information

EP HiBuild Primer 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 Gallons and Pails.  
Other custom sizes may be available.

| 5 Mixed Quarts     |             |        |
|--------------------|-------------|--------|
| Comp A – Std White | FEA0270-030 | 1 Gal. |
| Comp A – Warm Grey | FEA0274-030 | 1 Gal. |
| Comp A - Std Black | FEA0273-030 | 1 Gal. |
| Comp B             | FEB0275-020 | 1 Qt.  |

| 5 Mixed Gallons    |             |         |
|--------------------|-------------|---------|
| Comp A – Std White | FEA0270-054 | 4 Gals. |
| Comp A – Warm Grey | FEA0274-054 | 4 Gals. |
| Comp A - Std Black | FEA0273-054 | 4 Gals. |
| Comp B             | FEB0275-020 | 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.

For use outside this range please contact your Endura Representative.

#### Specifications

|                    |                |                                   |
|--------------------|----------------|-----------------------------------|
| Solvent Resistance | ASTM D4752     | 100 MEK Rubs; NO Failure          |
| Impact resistance  | ASTM D2794     | 20 in. lbs; NO Failure            |
| Flexibility        | ASTM D522      | 7/16 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).