



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 [**FEAXXX**]
(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

Finish:	Medium Gloss
Volume Solids Mixed: (Unreduced) FEA0274: FEB0275 (4:1)	73% ± 2%
Volume solids will vary by color	
Pot Life: (77°F (25°C) and 50% RH)	6 Hours
VOC Mixed (Unreduced): EPA Method 24 FEA0274: FEB0275 (4:1)	245 g/l 2.048 lb /gal
VOC content will vary with each color Note: All colors are below 250g/l.	
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 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).

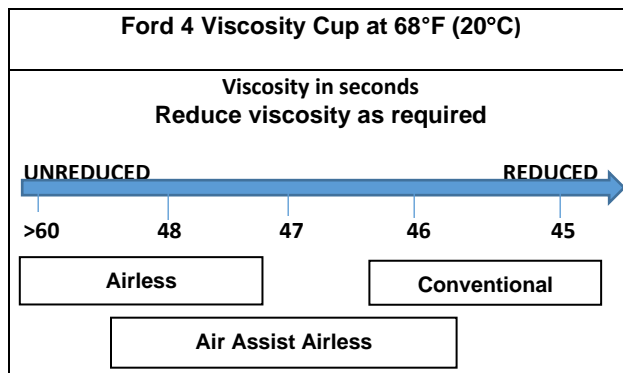


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Spray Gun Setup

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

EP HiBuild Primer has a recommended film build thickness of:

Wet: WFT Unreduced	5.5 – 8.0 mils	140 – 203 microns
Dry: DFT	4.0 – 6.0 mils	102 – 152 microns

For waterproofing:

Wet: WFT Unreduced	13.6 mils +	345 microns +
Dry: DFT	10 mils +	254 microns +

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

Theoretical coverage at 1.0 mil (25 microns)
DFT: 1173 ft² per gallon at 100% transfer efficiency.

Dry Times

	68°F (20°C)	86°F (30°C)	104°F (40°C)
Topcoat			
4 mils	3 Hours	2 Hours	1 Hour
8 mils	6 Hours	4 Hours	2 Hours
12 mils	12 Hours	8 Hours	4 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 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	FEB0275-030	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.

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.