



Technical Data Sheet (TDS)

Film Build

EP-PA Low VOC Chrome Free Primer has a recommended film build thickness of:

**Wet (unreduced): 3.5 – 5.5 mils wet
(89 – 140 microns)**

Dry: 1.0 - 1.5 mils dry (25 – 38 microns)

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

Theoretical coverage at 1.0 mil (25 microns)
DFT: 429 ft² per gallon at 100% transfer efficiency.

Note: Loss of topcoat adhesion may result if recommended film build parameters are not followed. At the recommended film thickness the primer may appear semi-transparent.

Dry Times

	68°F (20°C)	86°F (30°C)	104°F (40°C)
Topcoat	1 Hour	30 Minutes	15 Minutes
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 scuff sanding 220 – 320 grit after the topcoat window has been exceeded.

For improved scheduling please contact your Endura Representative

Topcoating Information

EP-PA Low VOC Chrome Free 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 Quarts and Gallons:

Other custom sizes may be available.

2 Quarts		
Comp A - Green	FEA0066-020	1Qt
Comp B	FEB0066-020	1Qt.

2 Gallons		
Comp A - Green	FEA0066-030	1 Gal.
Comp B	FEB0066-030	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.



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Specifications

Impact resistance	ASTM D2794	40 in. lbs; NO failure
Flexibility	ASTM D522	1/8 mandrel bend: NO failure

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.