



## EP-PA Low VOC Chrome Free Primer

### Technical Data Sheet (TDS)

#### Product Description

**EP-PA Low VOC Chrome Free Primer** is a two-component, low VOC, chrome-free, epoxy primer sealer designed for use on a variety of substrates. It provides an excellent blend of adhesion and corrosion resistance.

#### Product features:

- Ultra-smooth finish
- Thin film coating
- Superior primer for aluminum
- Excellent corrosion resistance
- Chrome-free
- VOC Compliant

#### Recommended Uses

EP-PA Low VOC Chrome Free Primer is intended for industrial applications, either new build or maintenance. It is formulated for use on thin aluminum and is suitable for application on properly sanded or sandblasted steel or properly prepared zinc coated steel and other ferrous and non-ferrous metals. This primer must be topcoated to achieve the best results.

#### Industries:

- Oilfield & Energy Services
- Cranes and Construction Equipment
- Trailers & Rolling Stock
- Waste and Recycling Industry

#### Product Characteristics

<b>Finish:</b> Lo Gloss	
<b>Volume Solids Mixed: (Unreduced)</b> <b>FEA0066: FEB0066 (1:1)</b>	27% ± 1%
<b>Pot Life:</b> (77°F (25°C) and 50% RH)	10 Hours
<b>VOC Mixed (Unreduced):</b> EPA Method 24 <b>FEA0066: FEB0066 (1:1)</b>	334 g/l 2.792 lb /gal
<b>Shelf Life: For unopened product (77°F (25°C))</b>	
<b>Component A</b>	3 years
<b>Component B</b>	2 years

#### 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.

For all other substrates refer to the Endura recommended surface preparation instruction sheets or contact your Endura Representative.

#### Mix Ratio

1 part by volume of component A **[FEA0066]**  
1 part by volume of component B **[FEB0066]**

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

#### Application

EP-PA Low VOC Chrome Free Primer can be applied using most spray-painting systems. Apply a single coat. If a second coat is required allow sufficient flash time between coats (20-30 minutes).

Spray Gun Setup			
Feed Type	Fluid Tip	Application Pressures (heel of gun)	Fluid Delivery
<b>Siphon Feed</b>	1.6-1.8 mm	40-50 psi	
<b>Gravity Feed</b>	1.6-1.8 mm	30-40 psi	
<b>Pressure Feed</b>	1.4-1.8 mm	50-60 psi	8 -12 oz/min
<b>Air Assist Airless</b>	9-11 Thou	1,000-1,800 psi	
<b>Airless</b>	N/A		

Suggested Viscosity Ranges Ford 4 Viscosity Cup at 68°F (20°C)	
<b>Air Assist Airless</b>	15 - 16 secs
<b>Conventional</b>	15 - 16 secs

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

Thinning is not typically required.

#### Film Build

EP-PA Low VOC Chrome Free Primer recommended film thickness:

<b>Wet: WFT Unreduced</b>	3.5 – 5.5 mils	89 – 140 microns
<b>Dry: DFT</b>	1.0 – 1.5 mils	25 – 38 microns

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

Theoretical coverage at 1.0 mil (25 microns) DFT: 429 ft<sup>2</sup> per gallon at 100% transfer efficiency.

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.



## EP-PA Low VOC Chrome Free Primer

### Technical Data Sheet (TDS)

#### Dry Times

	68°F(20°C)	86°F(30°C)	104°F(40°C)
<b>Topcoat</b>	1 Hour	30 Minutes	15 Minutes
<b>Full Cure</b>	7-9 Days	5-6 Days	3-4 Days

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). Scuff sanding with 220 – 320 grit is recommended after the topcoat window has been exceeded.

For questions about 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)

EP-PA LVOC CF Primer		2 mixed quarts (1.89l)
Comp A - Green	FEA0066-020	1 quart (946 ml)
Comp B	FEB0066-020	1 quart (946 ml)

EP-PA LVOC CF Primer		2 mixed gallons (7.56l)
Comp A - Green	FEA0066-030	1 gallon (3.78l)
Comp B	FEB0066-030	1 gallon (3.78l)

Other custom sizes may be available.

#### 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

<b>Solvent Resistance</b>	ASTM D4752	100 MEK Rubs; NO Failure
<b>Impact resistance</b>	ASTM D2794	100 in. lbs; NO Failure
<b>Flexibility</b>	ASTM D522	1/4 in. mandrel bend: NO failure
<b>Service Temp Range</b>	-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).