

## EP Sandable Low VOC Primer

### Technical Data Sheet (TDS)

#### Product Description

**EP Sandable Low VOC Primer** is a medium solids, medium build, two-component, epoxy primer providing excellent adhesion, hardness, and corrosion resistance.

##### Product features:

- Can be topcoated in 1-2 hours
- No induction required
- Next shift sandability (min. 4 hours)
- VOC Compliant

#### Recommended Uses

EP Sandable Low VOC Primer is intended for industrial applications, either new build or maintenance. It is suitable for application on steel, aluminum, and fiberglass substrates. This primer must be topcoated to achieve the best results.

##### Industries:

- Oilfield & Energy Services
- Cranes and Construction Equipment
- Trailers
- Waste and Recycling Industry
- Marine (above the water line)

#### Product Characteristics

|  |                          |
|--|--------------------------|
| <b>Finish:</b> Lo Gloss  |                          |
| <b>Volume Solids Mixed: (Unreduced)</b><br><b>FEA0380: FEB0380 (3:1)</b>     | 51% ± 1%                 |
| <b>Pot Life:</b> (77°F (25°C) and 50% RH)                                    | 10 Hours                 |
| <b>VOC Mixed (Unreduced):</b> EPA Method 24<br><b>FEA0380: FEB0380 (3:1)</b> | 241 g/l<br>2.017 lb /gal |
| <b>Use recommended Low VOC reducers to maintain compliance</b>               |                          |
| <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 sandblasted to a minimum of SSPC-SP6 or mechanically sanded with 80 grit sandpaper.

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

#### Mix Ratio

3 parts by volume of component A **[FEA0380]**  
1 part by volume of component B **[FEB0380]**

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

#### Application Method

EP Sandable Low VOC Primer can be applied using most spray systems, although electrostatic sprayers are not recommended. Apply 1-2 coats as required to achieve the desired film thickness. Allow sufficient flash time between coats especially with higher film builds applied (20-30 minutes).

| Spray Gun Setup           |            |                                     |                |
|---------------------------|------------|-------------------------------------|----------------|
| Feed Type                 | Fluid Tip  | Application Pressures (heel of gun) | Fluid Delivery |
| <b>Siphon Feed</b>        | 1.6-2.0 mm | 40-50 psi                           |                |
| <b>Gravity Feed</b>       | 1.6-2.0 mm | 30-40 psi                           |                |
| <b>Pressure Feed</b>      | 1.4-2.0 mm | 50-60 psi                           | 10-14 oz/min   |
| <b>Air Assist Airless</b> | 9-17 Thou  | 1000-1800 psi                       |                |
| <b>Airless</b>            | 11-15 Thou | 1700-3000 psi                       |                |

| Suggested Viscosity Ranges<br>Ford 4 Viscosity Cup at 68°F (20°C) |              |
|---|--------------|
| <b>Air Assist Airless</b>   | 45 - 50 secs |
| <b>Conventional</b>   | 44 - 46 secs |
| <b>Airless</b>  | 47 - 60 secs |

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

Recommended spraying viscosity is achieved by reducing with one of the following Endura Low VOC Epoxy reducers up to 20% by volume.

The following reducers will maintain VOC compliance.

[FTH0016] Low VOC Epoxy Reducer - Regular  
[FTH0027] Low VOC Epoxy Reducer - Slow

#### Film Build

EP Sandable Low VOC Primer recommended film thickness:

|                           |                 |                   |
|---------------------------|-----------------|-------------------|
| <b>Wet: WFT Unreduced</b> | 6.0 – 10.0 mils | 152 – 254 microns |
| <b>Dry: DFT</b>           | 3.0 – 5.0 mils  | 76 – 127 microns  |

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

Theoretical coverage at 1.0 mil (25 microns)  
DFT: 820 ft<sup>2</sup> per gallon at 100% transfer efficiency.

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|                | 20°C (68°F)                       | 30°C (86°F) | 40°C (104°F) |
|----------------|-----------------------------------|-------------|--------------|
| <b>Topcoat</b> | 1-2 Hours                         | 1 Hour      | 45 Minutes   |
| <b>To Sand</b> | Optimal: 8 Hours Minimum: 4 Hours |             |              |

**Dry Times are subject to ambient conditions (temperature and humidity) and 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 7 days at 68°F (20°C). Mechanical sanding with 180 – 220 grit sandpaper is recommended after exceeding the recoat window.

**If the primer is allowed to sit for an extended period without being topcoated, the surface must be kept clean of contaminants to avoid any topcoat issues.**

For improved scheduling please contact your Endura Representative.

#### Topcoating Information

EP Sandable Low VOC 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 Sandable Low VOC Primer 1 mixed gallon (3.78l) |             |                  |
|---|-------------|------------------|
| Comp A - Grey                                     | FEA0380-033 | 3 quarts (2.84l) |
| Comp B  | FEB0380-020 | 1 quart (946ml)  |

| EP Sandable Low VOC Primer 4 mixed gallons (15.1l) |             |                    |
|--|-------------|--------------------|
| Comp A - Grey                                      | FEA0380-053 | 3 gallons (11.34l) |
| Comp B   | FEB0380-030 | 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     | 40 in. lbs; NO failure       |
| <b>Flexibility</b>        | ASTM D522      | 1/4 mandrel bend: NO failure |
| <b>Service Temp Range</b> | -40°F to 200°F | -40°C to 93°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)