



## HFE3080 Primer

### Technical Data Sheet (TDS)

#### Product Description

**Endura HFE3080** is a low VOC zinc-rich epoxy primer. It contains a minimum of 80% zinc in the dry film to provide cathodic protection.

#### Product features:

- Excellent corrosion protection
- Has an indefinite recoat window.
- Ability to fill a sandblast profile in one coat
- Can provide Cathodic protection
- VOC Compliant

#### Recommended Uses

Endura HFE3080 Primer is intended for industrial applications; either new build or maintenance. HFE3080 Primer is suitable for application on properly sanded or sandblasted steel. HFE 3080 Primer is also suitable for properly prepared galvanized or zinc coated substrates. This primer must be topcoated to achieve the best results.

It is recommended for areas requiring high corrosion protection such as coastal service.

#### Industries:

- Oilfield & Energy Services
  - Well Service vehicles
  - Drilling
- Cranes and Construction Equipment
- Waste and Recycling Industry
  - Garbage Trucks

#### Mix Ratio

5 parts by volume of component A [FEA0056]  
1 part by volume of component B [FEB0056]

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

#### Product Characteristics

**Finish:** Low Gloss

**Volume Solids Mixed:** 56% +/- 1%

**Pot Life:** 10 Hours at 77°F (25°C) and 50% RH

**VOC Mixed (Unreduced)** (EPA Method 24):  
Grey: 247 g/l (2.056 lbs/gal)

#### Shelf Life:

Component A: 3 years at 77°F (25°C)  
Component B: 2 years at 77°F (25°C)

**Note: For unopened product**

#### Surface Prep

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 80 grit sand paper.

Near White Blast SSPC-SP10 or White Blast SSPC-SP5 sandblasting is required for and any offshore or coastal environments.

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

#### Application Method

HFE3080 Primer can be applied using most spray painting 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 (20-30mins)

**Note: agitation is not required while spraying; the zinc is fully suspended in the coating.**

Contact your Endura representative for details on an indefinite recoat window.



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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	10-14 oz/min
Air Assist Airless	13-17 Thou	1,000-1,800 psi	
Airless	13-17 Thou	1,700-3,000 psi	

#### Spray Viscosity

Using a Ford 4 Cup (White)	
22 Seconds*	Reduce as necessary*
←—————→	
Conventional	Airless

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

To maintain VOC compliance, thin HFE3080 Primer with Endura Low VOC Epoxy Reducers.  
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

HFE3080 Primer has a recommended film build thickness of:

**Wet (unreduced): 5.5 – 9.0 mils wet  
(140 – 230 microns)**

**Dry: 3.0 – 5.0 mils DFT (76 – 127 microns)**

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

Theoretical coverage at 1.0 mil (25 microns)  
DFT: 898 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>	3 Hours	1 Hours	30 Minutes
<b>Full Cure</b>	7-9 Days	5-6 Days	3-4 Days

**Note: Dry Times subject to ambient conditions (temperature and humidity) and good airflow and film build of the primer.**

For best results surface temperature must be 86°F (30°C) or less before topcoating.

Maximum re-coat window without sanding is 3 Days at 68°F (20°C)

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

For questions about scheduling please contact your Endura representative.

#### Topcoating Information

HFE3080 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.



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#### Ordering Information (sizing)

Available in Gallons and Pails.  
Other custom sizes may be available.

<b>1 Gallon</b>		
Comp A - Grey	FEA0056-035	3.15L
Comp B	FEB0056-022	0.63L

<b>Pail Kits:</b>		
<b>Approx. 4 gal</b>		
Comp A - Grey	FEA0056-055	12.6 L
Comp B	FEB0056-036	2.25 L

#### 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.**

#### Specifications

Solvent Resistance	ASTM D4752	50 MEK rubs. NO failure
Impact resistance	ASTM D2794	40 in. lbs; NO failure
Salt Spray Resistance (1000 Hours)	ASTM B117	No blistering, cracking or delamination of film. No more than 3/16 inch rust
Service Temp	-40°C to + 121°C	-40°F to 250°F
Percentage of zinc in the dry film		80%

#### 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](http://www.endura.ca).