

## HS-421 Primer

### Technical Data Sheet (TDS)

#### Product Description

**HS-421 Primer** is a medium solid, medium build, two-component, urethane surfacer. It is designed to be applied to previously coated surfaces where high build and easy sanding is required.

#### Product features:

- Excellent sanding characteristics
- High build to 10.0 mils dry
- Easy sanding in as little as 2 hours
- Formulated to fill imperfections in rough surfaces

#### Recommended Uses

HS-421 Primer is intended as an automotive type of surfacer and is suitable for application on previously coated surfaces including fiberglass and wood.

**Application of HS-421 is not recommended over bare metal if corrosion or impact resistance are expected.**

**Flexible surfaces should not be coated with this primer.**

**HS-421 primer must be sealed with Epoxy Primer Sealer or EP-2C CF after sanding and before application of the topcoat.**

#### Mix Ratio

4 parts by volume of component A [**FEA0313**]

1 part by volume of component B [**FUB0100**]

OR

1 part by volume of component B [**FUB0112**]

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

#### Product Characteristics

<b>Finish:</b>	Lo Gloss
<b>Volume Solids Mixed:(Unreduced) FEA0313: FUB0100 (4:1)</b>	45% ± 1%
<b>Pot Life:(77°F (25°C) and 50% RH)</b>	3 Hours
<b>VOC Mixed (Unreduced): EPA Method 24 FEA0313: FUB0100 (4:1)</b>	472 g/l 3.938 lb /gal
<b>VOC content will vary with each B component</b>	
<b>Shelf Life:</b>	
<b>Component A</b>	3 years
<b>Component B</b>	2 years
<b>For unopened product (77°F (25°C))</b>	

#### 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.

**A first coat of Epoxy Primer Sealer or EP-2C CF is recommended on bare metal to provide the best corrosion resistance.**

Polyester body filler and or putty must be finish sanded with 180 grit sandpaper prior to application of HS-421 Primer.

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

#### Application Method

HS-421 Primer can be applied using most spray systems, although electrostatic sprayers are not recommended.

Apply 1-3 coats as required to achieve the desired film thickness. Allow sufficient flash time between coats especially with higher film builds applied (10-20minutes).

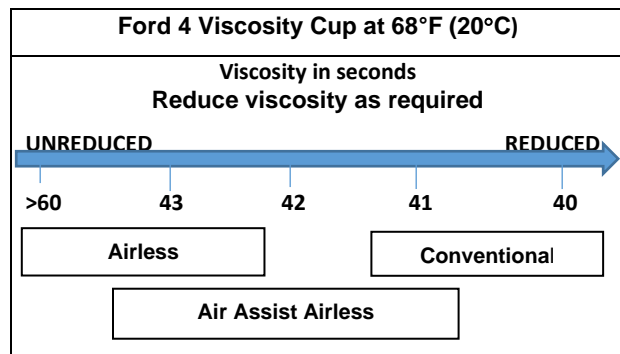
#### Spray Gun Setup

Feed Type	Fluid Tip	Application Pressures (heel of gun)	Fluid Delivery
Siphon Feed	1.6-2.0 mm	40-50 psi	
Gravity Feed	1.6-2.0 mm	30-40 psi	
Pressure Feed	1.4-2.0 mm	50-60 psi	10-14 oz/min
Air Assist Airless	9-17 Thou	1,000-1,800 psi	
Airless	11-15 Thou	1,700-3,000 psi	

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#### Spraying 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 topcoat thinners/reducers

FTH0086 – EX-2C Thinner .  
FTH0014 – Medium Topcoat Reducer  
FTH0090 – EX-2C Slo Thinner

#### Film Build

HS-421 Primer has a recommended film build thickness of:

<b>Wet: WFT Unreduced</b>	<b>6.0 – 11.0 mils</b>	<b>152 – 280 microns</b>
<b>Dry: DFT</b>	<b>3.0 – 5.0 mils</b>	<b>76 – 127 microns</b>

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

Theoretical coverage at 1.0 mil (25 microns).  
DFT: 733 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>To Sand</b>	4 hours	3 hours	2 hours
<b>To Seal</b>	1 hours	45 minutes	30 minutes
<b>Full Cure</b>	7-9 days	5-6 days	3-4 days

**The above dry times are based on the using Supercatalyst II at a rate of 1 fluid oz (30ml) per mixed quart of HS-421. Use of Supercatalyst II is recommended to reduce dry times.**

**Note: 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 3 days at 68°F (20°C). Recommended mechanical sanding with 180–220 grit after the recoat window has been exceeded before sealing with Epoxy Primer Sealer or EP-2C CF.

**Note: 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

**HS-421 primer must be sealed with Epoxy Primer Sealer or EP-2C CF after sanding and before application of the topcoat.**

HS-421 Primer can be topcoated with the entire range of Endura topcoat products after being sealed

#### 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.  
Other custom sizes may be available.

1 <sup>1</sup> / <sub>4</sub> mixed gallons (4.73 l)		
Comp A - Grey	FEA0313-030	1 gallon (3.78l)
Comp B	FUB0100-020 OR FUB0112-020	1 quart (946ml)

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#### 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	100 in. lbs; NO failure
Flexibility	ASTM D522	1/4 mandrel bend: NO failure
Service Temp	-40°F to 360°F	-40°C to 182°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).