

HS-421 Primer

Technical Data Sheet (TDS)

Product Description

Endura HS-421 Primer is a medium solids, medium build two-component urethane surfacer. It is designed as 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

Endura HS-421 Primer is intended as an automotive primer where high build and easy sanding characteristics are Endura HS-421 Primer is suitable for application on previously coated surfaces, fiberglass and wood.

Note: 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 EP 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

Finish: Low Gloss

Volume Solids Mixed: 45% +/- 1%

Pot Life: 3 Hours at 77°F (25°C) and 50% RH

VOC Mixed (Unreduced) (EPA Method 24):
Grey: 478 g/l (3.993 lb/gal) with FUB0100

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 to a minimum of SSPC- SP6 or mechanically sanded with 80 grit sand paper.

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

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

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- 20mins).

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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	1000-1800 psi	
Airless	11-15 Thou	1700-3000 psi	

Spraying Viscosity*

Using a Ford 4 Cup (White)	
23 Seconds*	Reduce as necessary*
Conventional	Airless

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

If require, thin HS-421 with Endura Topcoat thinners.

FTH0086 – EX-2C Thinner (use in lower ambient temperatures).
FTH0014 – Medium Topcoat Reducer (use in average ambient temperatures).
FTH0090 – Slo EX-2C Thinner (for use in higher ambient temps).

Film Build

EP Sandable Primer has a recommended film build thickness of:

**Wet (unreduced): 6.0 – 11.0 mils wet
(152 – 282 microns)**

Dry: 3.0 – 5.0 mils dry (76 – 127 microns)

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

Theoretical coverage at 1.0 mil (25 microns).
DFT: 715 ft² per gallon at 100% transfer efficiency.

Dry Times

	68°F (20°C)	86°F (30°C)	104°F (40°C)
To Sand	4 hrs	3hrs	2 hrs
To Seal	1hr	45 min	30 min
Full Cure	7-9 Days	5-6 Days	3-4 Days

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 180 – 220 grit mechanical sanding before sealing with EP Sealer or EP-2C CF.

For improved scheduling please contact your Endura representative.

Topcoating Information

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

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.

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Ordering Information (sizing)

Available in Gallons.

Other custom sizes may be available.

5 quarts		
Comp A - Grey	FEA0313-030	1 Gal
Comp B	Fub0100-020 OR FUB0112-020	1Qt

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	100 MEK Rubs; NO failure
Impact resistance	ASTM D2794	20 in. lbs; NO failure
Flexibility	ASTM D522	1/4 mandrel bend: NO failure
Service Temp	-40°C to 182°C	-40°F to 360°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.endura.ca.