

Intermix 4:1 Primer

Technical Data Sheet (TDS)

Product Description

Endura Intermix 4:1 Primer is a medium solids, medium build, two-component, epoxy primer providing excellent adhesion, hardness and corrosion resistance.

Product features:

- Ability to fill a sandblast profile in one coat
- No induction time required
- Can be topcoated in 1 hour
- 7 day topcoat window
- Available in various colors

Recommended Uses

Endura Intermix 4:1 Primer is intended for industrial applications; either new build or maintenance. Intermix 4:1 Primer is suitable for application on steel, aluminum and fiberglass substrates. This primer must be topcoated to achieve the best results.

Intermix 4:1 is not recommended in thin films as a sealer.

Mix Ratio

4 parts by volume of component A
[Part number varies with color]
1 part by volume of component B [FEB0181]

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

Product Characteristics

Finish: Low Gloss

Volume Solids Mixed: 55% +/- 2%

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

VOC Mixed (Unreduced): (EPA Method 24):

Grey: 394 g/l (3.293 lb/gal)

Note: The VOC level will vary per color.

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.

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

Application Method

Intermix 4:1 Primer can be applied using most spray painting systems.

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).

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	9-17 Thou	1,000-1,800 psi	
Airless	11-15 Thou	1,700-3,000 psi	

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Spray Viscosity

Using a Ford 4 Cup (White)	
22-23 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 required, thin Intermix 4:1 with Endura Epoxy Reducers.

[FTH0654] Epoxy Reducer - Fast (for use in lower ambient temps)

[FTH0653] Epoxy Reducer - Regular (for use in average temps)

[FTH0652] Epoxy Reducer - Slow (for use in higher ambient temps)

Film Build

Intermix 4:1 Primer has a recommended film build thickness of:

**Wet (unreduced): 5.5 – 9.0 mils wet
(140 – 229 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: 876 ft² per gallon at 100% transfer efficiency.

Dry Times

	68°F (20°C)	86°F (30°C)	104°F (40°C)
Topcoat	1-2 Hours	1 Hour	45 Minutes
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 the 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)
Recommended 180 – 220 grit mechanical sanding before topcoating.

Note: Intermix 4:1 Primer is difficult to sand. If extensive sanding is required, EP Sandable Primer is recommended.

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

Intermix 4:1 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)

Available in Gallons and Pails

Other custom sizes may be available.

5 Quarts		
Comp A - Grey	FEA0170-030	1 Gal
Comp A - Black	FEA0171-030	1 Gal
Comp A - White	FEA0204-030	1 Gal
Comp B	FEB0181-020	1 Qt

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3Gallons 3 Quarts		
Comp A - Grey	FEA0170-053	3 Gal
Comp A - Black	FEA0171-053	3 Gal
Comp A - White	FEA0204-053	3 Gal
Comp A - Red Oxide	FEA0190-053	3 Gal
Comp A - Buff Yellow	FEA0800-053	3 Gal
Comp B	FEB0181-033	3 Qts

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
Flexibility	ASTM D522	3/8 mandrel bend: NO Failure

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.