

## Intermix 4:1 Primer

### Technical Data Sheet (TDS)

#### Product Description

**Intermix 4:1 Primer** is a medium solid, 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

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.**

#### Industries:

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

#### Mix Ratio

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

<b>Finish:</b>	Lo Gloss
<b>Volume Solids Mixed: (Unreduced)</b> <b>FEA0170: FEB0181 (4:1)</b>	55% ± 2%
Volume solids will vary by color	
<b>Pot Life:</b> (77°F (25°C) and 50% RH)	10 Hours
<b>VOC Mixed (Unreduced):</b> EPA Method 24 <b>FEA0170:FEB0181 (4:1)</b>	394 g/l 3.293 lb /gal
VOC content will vary with each color	
<b>Shelf Life:</b>	
<b>Component A</b>	3 years
<b>Component B</b>	2 years
For unopened product (77°F (25°C))	

#### 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.

#### 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 (20-30 minutes).

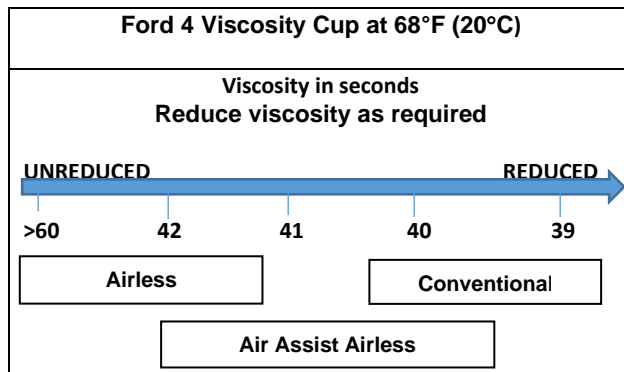
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#### Spray Gun Setup

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	9-15 Thou	1,000-1,800 psi	
Airless	9-13 Thou	1,700-3,000 psi	

#### Spray 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 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:

<b>Wet: WFT Unreduced</b>	<b>5.5 – 9.0 mils</b>	<b>140 – 229 microns</b>
<b>Dry: DFT</b>	<b>3.0 – 5.0 mils</b>	<b>76 – 127 microns</b>

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

Theoretical coverage at 1.0 mil (25 microns)  
DFT: 876 ft<sup>2</sup> per gallon at 100% transfer efficiency.

#### Dry Times

	<b>68°F (20°C)</b>	<b>86°F (30°C)</b>	<b>104°F (40°C)</b>
<b>Topcoat</b>	1-2 Hours	1 Hour	45 Minutes
<b>Full Cure</b>	7-9 Days	5-6 Days	3-4 Days

**Note: Dry Times are subject to ambient conditions (temperature and humidity), 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.**

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#### 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 Mixed 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.

3 ¾ Mixed Gallons		
Comp A - Grey	FEA0170-053	3 Gals.
Comp A - Black	FEA0171-053	3 Gals.
Comp A - White	FEA0204-053	3 Gals.
Comp A - Red Oxide	FEA0190-053	3 Gals.
Comp A - Buff Yellow	FEA0800-053	3 Gals.
Comp B	FEB0181-033	3 Qts.

#### Environmental Conditions

For optimum coating performance, the 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	30 in. lbs; NO Failure
Flexibility	ASTM D522	1/4 in. mandrel bend: NO failure
Service Temp Range	-40°F to 250°F	-40°C to 121°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).