



Velocity Low VOC Primer

Technical Data Sheet (TDS)

Product Description

Endura Velocity Low VOC Primer is a Low VOC, quick drying epoxy zinc primer. It provides superior adhesion, impact resistance and corrosion protection.

Product features:

- Provides corrosion protection
- Ability to fill a sandblast profile in one coat
- Quick dry time and a 7 day topcoat window
- No induction required
- VOC Compliant

Recommended Uses

Endura Velocity Low VOC Primer is intended for industrial applications; either new build or maintenance. Velocity Low VOC Primer is suitable for application on steel, and other ferrous metals.

This primer must be topcoated to achieve the best results.

- Ideal choice for high production environments.

Industries:

- Oilfield & Energy Services
 - Well Service vehicles
- Cranes and Construction Equipment
- Trailers

Mix Ratio

3 parts by volume of component A [FEA0067] Grey

Or

3 parts by volume of component A [FEA0069] Beige

1 part by volume of component B [FEB0067]

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

Product Characteristics

Finish: Low Gloss

Volume Solids Mixed: 47% +/- 2% (varies with color)

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

VOC Mixed (Unreduced) EPA Method 24:
Grey: 230 g/l (1.923 lbs/gallon)

Note: All colors are below 250g/l. VOC levels 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

Note: The use of EpoCat in Velocity primer is not required or recommended.

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.

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

Application Method

Velocity Low VOC Primer can be applied using most spray 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 (20-30 mins).



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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 | 1.4-1.6 mm | 40-50 psi | |
| Pressure Feed | 1.0-1.3 mm | 30-40 psi | 12-16 oz/min |
| Air Assist Airless | 11-13 Thou | 1,000-1,800 psi | |
| Airless | 11-13 Thou | 1,700-3,000 psi | |

Spray Viscosity

Using a Ford 4 Cup (White)

| | |
|---------------|----------------------|
| 16-17 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 Velocity Low VOC Primer with Endura Low VOC Epoxy Reducers.
VOC level of the following thinners: (0g/l, 0lbs/gal)

[FTH0016] Low VOC Epoxy Reducer – Regular
[FTH0027] Low VOC Epoxy Reducer - Slow

Film Build

Velocity Low VOC Primer has a recommended film build thickness of:

**Wet (unreduced): 6.0 – 10.5 mils wet
(150 – 267 microns)**

Dry: 3.0 – 5.0 mils dry (75 – 125 microns)

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

Theoretical coverage at 1.0 mil (25 microns)
DFT: 746 ft² per gallon at 100% transfer efficiency.

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Dry Times

| | 50°F (10°C) | 73°F (23°C) | 86°F (30°C) |
|-------------------------|-------------|-------------|-------------|
| Topcoat 5.0 mils wet | 2 Hour | 1 Hour | 30 Minutes |
| Topcoat 10 mils wet | 4-5 Hours | 2-3 Hours | 1-2 Hours |
| Full Cure | 7-14 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 7 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.

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.

Topcoating Information

Velocity Low VOC 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.

Version: 1.2



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Ordering Information (sizing)

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

| | | |
|-----------------|-------------|------|
| 1 Gallon | | |
| Comp A – Grey | FEA0067-033 | 3 Qt |
| Comp A - Beige | FEA0069-033 | 3 Qt |
| Comp B | FEB0067-020 | 1 Qt |

| | | |
|------------------|-------------|-------|
| 4 Gallons | | |
| Comp A – Grey | FEA0067-053 | 3 Gal |
| Comp A - Beige | FEA0069-053 | 3 Gal |
| Comp B | FEB0067-030 | 1 Gal |

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 | ASTM4752 | 50 MEK rubs; NO failure |
| Impact resistance | ASTM D2794 | 40 in. lbs; NO failure |
| Flexibility | ASTM D522 | 1/8 mandrel bend: NO failure |
| Service Temp Range | -40°C to +121°C | -40°F to 250°F |
| Percentage of zinc in the dry film | 35% | |

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.