

Endura EP-2C Primer/Sealer is a two-component type epoxy urethane product designed for a variety of surfaces. It provides an excellent blend of adhesion, hardness, and corrosion resistance over aluminum, bare steel, and other metal surfaces. Contains Zinc Chromate to enhance rust inhibitive properties over sandblasted steel, bare steel, and other ferrous metals.

product features

- Enhanced rust inhibiting properties
- High temperature service
- Non-sanding sealer
- No induction time required
- Excellent adhesion to a wide variety of substrates
- Intercoat adhesion greater than 2000 psi
- Suitable for sealing HS-421 Primer

additional information

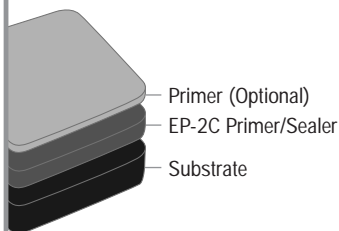
Theoretical solids content:

- By weight 48%
- By volume 35%

Shelf Life:

Component A - Indefinite
Component B - 1 yr. (unopened)

quality products from endura

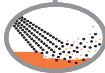


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suitability

Endura EP-2C Primer/Sealer can be applied over many surfaces including bare metal, aluminum, fibreglass, reinforced plastics, existing finishes and polyester fillers.



surface preparation

Surfaces must be free of all contaminants such as dust, oil, grease, and salt. To remove rust and oxidation, and to etch the metal, it is recommended that all steel and other ferrous surfaces be degreased, and either sandblasted or sanded and/or treated with metal conditioners.

Aluminum surfaces should be etched with Endura Aluminum Cleaner and treated with Endura Aluminum Conversion Coating. Satin coat or galvanized surfaces (sanded or not) must be pre-treated with Metal Prep and Galvaprep.



mixing ratio

1 Part By Volume Component A
1 Part By Volume Component B

When used as a sealer, thin 15 - 20% with Endura EX-2C Thinner.



spraying viscosity

14 seconds # 4 Ford cup when mixed 1:1
12 seconds # 4 Ford cup when reduced 15 to 20% for use as a sealer

Reduce with Endura EX-2C Slo or EX-2C Thinner.

application method

As a Surface Primer: Apply two coats allowing 30 minutes dry time between coats. Allow 8 - 12 hours drying time before applying Endura EX-2C Topcoat.
As a Sealer for Existing Surfaces: Apply a single coat, allowing 1 hour drying time before applying Endura EX-2C Topcoat.

Note: Under normal conditions this primer does not require sanding for 16 - 24 hours. After 24 hours, adhesion of topcoat to primer is reduced and thorough sanding with 180 - 280 grit sandpaper is required. Endura EP-2C Primer/Sealer can be applied using most spray painting systems.



spray gun setup

Feed Type	Fluid tip	Application Pressures (at the heel of the 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
Airless	11 - 13 Thou	1700 - 2000 psi	



pot life of mixed product

8 hours

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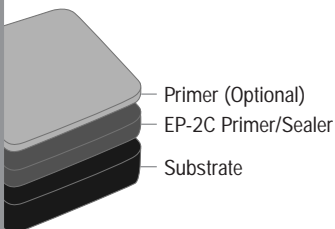
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recommended film build thickness and cover rate

Endura EP-2C Primer/Sealer recommended dry film build thickness:

As a Primer: 1.5 - 2.5 mils dry (37 - 63 microns). Cover rate is approximately 250 - 400 ft² per gallon.

As a Sealer: 0.7 - 1.3 mils dry (17 - 33 microns). Cover rate is approximately 400 - 500 ft² per gallon.



curing rate and drying time

Drying time will vary depending upon temperature, humidity, air flow and other environmental factors. The following table is based on 50% Relative Humidity.

For best results, Endura EP-2C Primer/Sealer should be topcoated within 24 hours. To provide the best protection, topcoat with Endura EX-2C Topcoat.

	Normal 20°C (68°F)	38°C (100°F)	60°C (140°F)
As a Sealer (thinned 15-20%)	1 coat = 1.0 mils (25 microns)		
Topcoat To Sand	60 minutes 4 hours	20 minutes 2 hours	10 minutes 1 hour
As a Primer on Sandblasted Steel	2 coats = 2.0 - 3.0 mils (50 - 75 microns)		
Topcoat To Sand	8 - 12 hours 12 - 16 hours	6 hours 6 - 8 hours	1 hour 1 hour
Full Cure	7 - 10 Days		

specifications

Hardness	H
Solvent Resistance	50 methyl ethyl ketone rubs; NO failure
Abrasion Resistance	1000 cycles CS-17; 76 mg loss
Impact Resistance	40 in. lbs.; NO failure
Flexibility	1/8 mandrel bend; NO failure
VOC	4.80 lbs/gal 576 g/litre

For VOC regulated areas, please request VOC compliant products.

clean up

EX-2C Thinner or High Strength Gunwash.

note

For more information, refer to the EP-2C Primer/Sealer detailed specification datasheets.

