

Endura Titan Primer is a two-component, high solids, high build epoxy primer. It forms an extremely durable coating that has good wetting properties, excellent aged recoatability and low temperature curing properties.

### Product Features

- ◆ Excellent corrosion protection
- ◆ Excellent alkali and salt spray resistance
- ◆ Cold weather cure
- ◆ Surface tolerant
- ◆ Low VOC
- ◆ Self-priming on steel
- ◆ Superior recoatability

### Theoretical Solids Content:

Volume: 77%

### Shelf Life\*

Component A: (3) years  
Component B: (1) year

\*For unopened product.

### Pot Life of Mixed Product:

1-1.5 Hours\* @ 77°F (25°C) and 50% RH

\* Mixing large quantities will reduce pot life.



### Suitability

Endura Titan Primer provides an excellent adhesion and corrosion resistance for metal substrates such as steel structural members, machinery, equipment, piping and storage tanks.



### Surface Preparation

Sandblasting or machine sanding with 40 grit sandpaper is acceptable for most applications. Sandblast media, mesh size 16/30 or 30/50 or LG 50 steel shot. For use on fiberglass or wood boat hulls, machine sand with 80 grit sandpaper. A minimum of 10 mils (250 microns) dry film thickness is required for waterproofing. Endura EX-2C Topcoat is not recommended below the waterline.



### Mixing Ratio

3 parts by volume of component A [GMI0114]  
1 part by volume of component B [GTH0120]

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

### Environmental Conditions

For optimum coating performance product, substrate and ambient temperature should be between 20°C-25°C\* (68°F-77°F). To prevent condensation during application the surface temperature must be 3°C (5°F) or more above the dew point at all times.

\*for use outside this range please contact your Endura representative.



### Spraying Viscosity\*

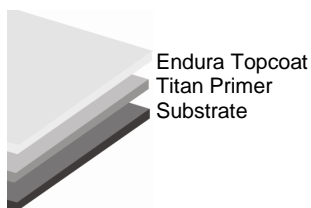
23 Seconds*	Using a Ford 4 Cup (white) reduce as necessary *
Conventional	Airless

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



### 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	12-16 oz/min
Air Assist Airless	9-17 Thou	1,000-1,800 psi	
Airless	13-17 Thou	1,700-3,000 psi	



# Titan

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### Recommended Film Build Thickness and Cover Rate

The recommended film build is 4-8 mils DFT.

Wet (unreduced): 5.0 – 10.0 mils wet (125 – 250 microns)

Dry: 4.0 – 8.0 mils dry (100 – 200 microns)

Theoretical coverage at 1.0 mil (25 microns) DFT: 1232 ft² per gallon @ 100% transfer efficiency.



### Drying Time\*

	20°C (68°F)	30°C (86°F)	40°C (104°F)
Topcoat			
4 mils	3 Hours	2 Hours	1 Hour
8 mils	6 Hours	4 Hours	2 Hours
Full Cure	7-9 Days	5-6 Days	3-4 Days

Note: Extended overcoating is dependant on surface cleanliness. The substrate may require washing with a suitable detergent prior to overcoating.

\* Subject to ambient conditions (temperature and humidity) and good airflow. For improved scheduling please contact your Endura representative.

### Specifications

Impact resistance	ASTM D2794	40 in.lbs: NO failure
Solvent resistance	ASTM D4752	50 MEK rubs: NO failure
Flexibility	ASTM D522	1/8" mandrel; NO failure
VOC	For VOC amounts please refer to the product MSDS	



### Clean Up

Endura high strength gun wash, Endura epoxy reducer or Endura EX-2C thinner.

