

EP-2C Sealer

Endura EP-2C Sealer is a two-component 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 on 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

Theoretical Solids Content:

Volume: 35%

Shelf Life*

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

*For unopened product.

Pot Life of Mixed Product:

8 Hours @ 77°F (25°C) and 50% RH



Suitability

Endura EP-2C Sealer can be applied over many surfaces including bare metal, aluminum, fiberglass, reinforced plastics, wood, 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 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 Endura Metal Prep and Endura Galvaprep.



Mixing Ratio

1 part by volume of component A [FUA0650]
1 part by volume of component B [FUB0651]

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*

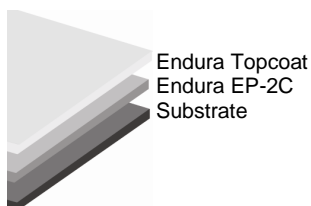
Using a Ford 4 Cup (white)	
14 Seconds*	reduce as necessary *
Conventional	Airless

* 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		N/A	
Airless		N/A	



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Application Method

Apply a single coat; allow 1 hour drying time before applying Endura EX-2C Topcoat. **Note:** Under normal conditions this sealer does not require sanding for 16 - 24 hours. After 24 hours, adhesion of topcoat to sealer is reduced and thorough sanding with 180 - 280 grit sandpaper is required.

Recommended Film Build Thickness and Cover Rate

Endura EP-2C has a recommended film build thickness of 2.0-3.0* mils wet, or approximately 1 mil dry.

Theoretical coverage at 1.0 mil (25 microns) DFT: 560 ft² per gallon @ 100% transfer efficiency.

*Loss of topcoat adhesion may result if recommended film build parameters are not followed.



Drying Time*

	20°C (68°F)	30°C (86°F)	40°C (104°F)
Topcoat	1 Hours	30 Minutes	15 Minutes
Full Cure	7-9 Days	5-6 Days	3-4 Days

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

Specifications

Impact resistance (direct)	ASTM D2794	40 in.lbs: NO Failure
Water immersion	ASTM D1308	Excellent
Service temperature limits		400°F (204°C)
Flexibility	ASTM D522	1/8" mandrel bend; 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.

