

EP-2C Sealer FC

Endura EP-2C Sealer FC is a very flexible two-component epoxy urethane product designed to be used to prime new polyester aircraft fabric or as a sealer (tie coat) over existing cellulose Butyrate Dopes. It provides excellent adhesion, flexibility, and UV protection.

Product Features

- ◆ Temperature service up to 200°C
- ◆ Non-sanding sealer
- ◆ Excellent adhesion to a wide variety of substrates
- ◆ Intercoat adhesion greater than 2000 psi

Theoretical Solids Content:

Volume: 45%

Shelf Life*

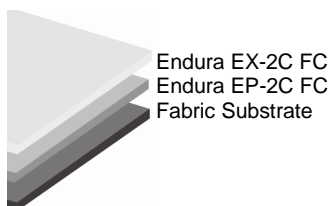
Component A: (3) years
Component B: (1) year

*For unopened product.

Pot Life of Mixed Product:

1 Hour @ 77°F (25°C) and 50% RH

**** Mix this product in small amounts...only what is required for each job due to the short pot life.****



Suitability

In addition to use on polyester aircraft fabric, Endura EP-2C Sealer FC contains corrosion inhibiting additives which means it can also be used to protect metal and composite airplane parts. (Sandblasted steel and other non-ferrous metals after appropriate pretreatment).



Surface Preparation

Clean new fabric surfaces with methyl ethyl ketone (MEK) or isopropanol. Wipe with tack rag to remove any lint or dust. New fabric must be treated with 2 primer/sealer coats. Previously coated fabric needs 1 sealer coat.

Note: Refer to the EP-2C Sealer datasheet for information on metal substrate preparation.

Note: For information on application over previously coated fabric please see the Endura Coating Fabric Covered Aircraft Guide.

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.



Mixing Ratio

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

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



Spraying Viscosity*

Using a Ford 4 Cup (white)	
15 Seconds*	N/A *
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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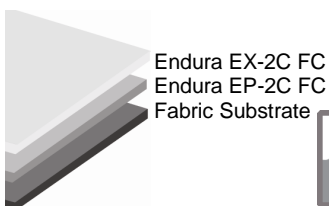
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Application Method

As a Primer/Sealer for new Fabric: New fabric must be coated with 2 primer/sealer applications. Apply one coat, brushing into and through the weave of the material. While the brush coat is still wet, spray apply a sealer coat at 45 - 50 psi.

As a sealer for existing surfaces: Apply a single coat, allowing 1 hour drying time before applying Endura EX-2C SFC Topcoat.

Note: EP-2C Primer/Sealer FC (fabric) can be topcoated without sanding for up to 24 hours at 20°C (68°C). After 24 hours, adhesion of topcoat to primer is reduced and thorough sanding with 220 - 320 grit wet sandpaper is recommended. Endura EP-2C Primer/Sealer FC fabric can be applied using most spray painting systems.

Recommended Film Build Thickness and Cover Rate

As a Primer/Sealer Ep-2C FC (fabric) has a recommended film build thickness of 1.5 - 2.5* mils dry (37 - 63 microns).

As a Sealer the recommended film build is 0.7 - 1.3 mils dry (18 - 33 microns).

Theoretical coverage at 1.0 mil (25 microns) DFT: 720 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	60 Minutes	20 Minutes	10 Minutes
To Sand	6 Hours	3 Hours	1-2 Hours
Full Cure	7-9 Days		
<i>For use on sandblasted steel please refer to the EP-2C Datasheet</i>			

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

Specifications

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.