

EP-521

Endura EP-521 Epoxy Primer is a high solids two-component primer designed for high impact resistance over a wide range of surfaces. It is specially formulated to fill a sandblast profile in one coat. This is our most durable primer for equipment.

Product Features

- ◆ Available in many colours for use as a basecoat
- ◆ Formulated for use where high impact resistance is required
- ◆ High Solids formulation fills a sandblast profile in one coat
- ◆ Quick dry time and a 3 day topcoat window
- ◆ No induction required

Theoretical Solids Content:

Volume: 59% ± 1%

Shelf Life*

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

*For unopened product.

Pot Life of Mixed Product:

10 Hours @ 77°F (25°C) and 50% RH



Suitability

Endura EP-521 Epoxy Primer provides excellent corrosion resistance combined with superior impact resistance. It may be applied to many surfaces: aluminum, steel, stainless steel, galvanized and zinc-coated steel, other ferrous metals, fiberglass, and concrete.

This product is not recommended in thin films as a sealer.



Surface Preparation

Commercial 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.



Mixing Ratio

5 parts by volume of part A [Part# varies by color]
1 part by volume of part B [FEB0522]

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*

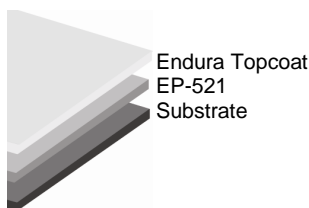
Using a Ford 4 Cup (white)	
22 Seconds*	reduce as necessary *
Conventional	Airless

* 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	9-17 Thou	1,000-1,800 psi	
Airless	13-15 Thou	1,700-3,000 psi	



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Recommended Film Build Thickness and Cover Rate

Endura EP-521 Epoxy Primer has a recommended film build thickness of 5.0 – 8.5 mils wet, 3.0 – 5.0 mils dry.

Theoretical coverage at 1.0 mil (25 microns) DFT: 944 ft² per gallon @ 100% transfer efficiency.



Drying Time*

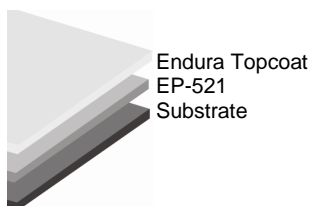
After 72 hours, this primer must be scuff sanded.

	20°C (68°F)	30°C (86°F)	40°C (104°F)
Topcoat	3 Hours	2 Hour	1-2 Hours
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

Solvent resistance	ASTM D4752	50 MEK rubs; NO failure
Impact resistance	ASTM D2794	40 in. lbs; NO failure
Flexibility	ASTM D522	3/8 mandrel bend; NO failure
service temperature range**	-40°C to +121°C	-40°F to 250°F
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.