

EP HiBuild

Endura EP HiBuild Epoxy Primer is designed as a multi-mil coating for use on bare metals and fiberglass-reinforced plastics. It is ideally suited for heavy industrial uses and/or waterproofing requirements.

Product Features

- ◆ Proven for heavy industrial applications
- ◆ Waterproof capability at 10 mils dry film thickness
- ◆ High solids provide quick film build
- ◆ Excellent alkali and salt spray resistance

Theoretical Solids Content:

Volume: 74%

Shelf Life*

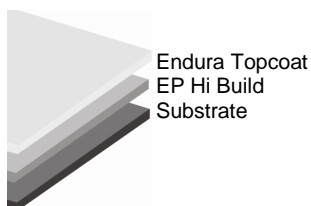
Component A: (3) years
Component B: (1) year

*For unopened product.

Pot Life of Mixed Product:

6 Hours* @ 77°F (25°C) and 50% RH

*For extended pot life phone Endura technical dept.



Suitability

It is often used for offshore drilling rigs, pulp mills, chemical plants, boats, and bridges. EP HiBuild Epoxy Primer can be used as a self-prime coating or topcoated with Endura EX-2C Topcoat. This primer is not suitable for automotive applications.



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

4 parts by volume of component A [varies by color]
1 part by volume of component B [FEB0275]

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

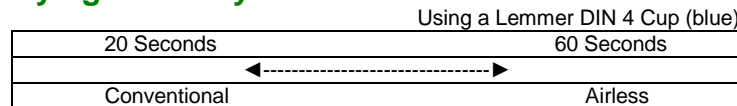
Environmental Conditions

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



Spraying viscosity is achieved with reduction using Endura epoxy reducer.



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	

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Recommended Film Build Thickness and Cover Rate

Endura EP HiBuild Epoxy Primer has a recommended film build thickness of 5.5 – 8.0 mils wet; 4.0 - 6.0 mils dry.
For waterproofing 10+ mils DFT are required.

Theoretical coverage at 1.0 mil (25 microns) DFT: 1184 ft² per gallon @ 100% transfer efficiency.

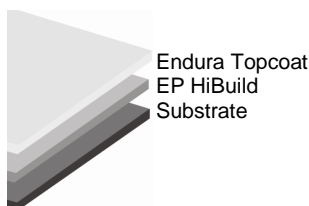


Drying Time*

	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
12 mils	12 Hours	8 Hours	4 Hours
Full Cure	7-9 Days	5-6 Days	3-4 Days

Specifications

Impact resistance (direct)	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	223 grams/liter (1.86 lbs/gal)	



Clean Up

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