

EP Sandable

Endura EP Sandable epoxy primer is a high solids, medium build, two-component primer providing excellent adhesion, hardness, and corrosion resistance over a wide range of surfaces. It is specially formulated to be scuff sanded overnight.

Product Features

- ◆ Can be topcoated in 1-2 hours
- ◆ No induction required
- ◆ Next shift sandability (min. 4 hours)

Theoretical Solids Content:

Volume: 51%

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 Sandable epoxy primer provides excellent adhesion, hardness, and corrosion resistance to many types of substrates. This primer must be topcoated to achieve the best results.



Surface Preparation

Surface must be free of all contaminants such as dust, oil, grease, and salt. It is recommended that all steel and other ferrous surfaces be sandblasted or mechanically sanded with 80 grit sand paper.



Mixing Ratio

3 parts by volume of component A [FEA0038]
1 part by volume of component B [FEB0038]

The recommended temperature when mixed is 25°C (77°F).
Temperatures lower than 15 degree C (59 degree F) may cause topcoat adhesion failure.

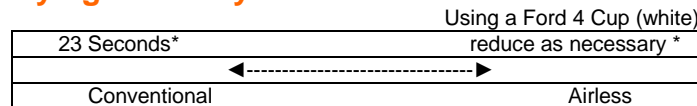
Environmental Conditions

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*

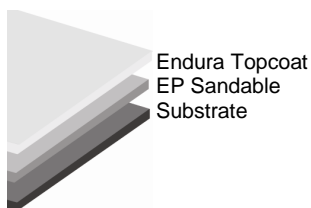


* Spraying viscosity and thinning will depend on ambient conditions, spray equipment used, and on the desired surface finish.



Spray Gun Setup

| Feed Type | Fluid Tip | Application Pressures (heel of gun) | Fluid Delivery |
|--------------------|------------|---------------------------------------|----------------|
| Siphon Feed | 1.6-2.0 mm | 40-50 psi | |
| Gravity Feed | 1.6-2.0 mm | 30-40 psi | |
| Pressure Feed | 1.4-2.0 mm | 50-60 psi | 10-14 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 Sandable epoxy primer has a recommended film build thickness of:

Wet (unreduced): 4.0 – 7 mils wet (100 – 175 microns)
Dry: 2.0-3.5 mils dry (50-88 microns)

Theoretical coverage at 1.0 mil (25 microns) DFT: 496 ft² per gallon @ 100% transfer efficiency.



Drying Time*

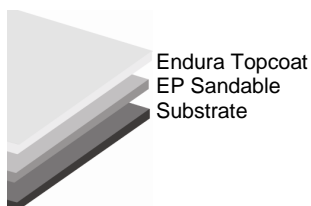
For best results surface temperature must be 30°C (80°F) or less before top coating. Maximum re-coat window without sanding is 7 days at 20°C.

| | 20°C (68°F) | 30°C (86°F) | 40°C (104°F) |
|---------|--|-------------|--------------|
| Topcoat | 1-24 Hours | | 45 Minutes |
| To Sand | For optimal results 8 hours (4 hours min.) | | |

* 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 | 1/8" mandrel bend; NO failure |
| service temperature range | -40°C to 93°C | -40°F to 200°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.