ENDURA PAINT

Technical Data Sheet

Endura Manufacturing Co. Ltd. TEL 1-800-661-9930

Updated: Aug 2011

HS-421

Endura HS-421 Primer is a two-component primer/surfacer designed for spray application. It is designed as an automotive primer for previously painted surfaces where high build and easy sanding characteristics are required.

Product Features

- Excellent sanding characteristics
- High build - to 10.0 mils dry
- Easy sanding in as little as two hours
- Formulated to fill imperfections in rough or porous surfaces
- Used to eliminate minor imperfections after sanding

Theoretical Solids Content:
Volume: 48%

Shelf Life*
Component A: (3) years
Component B: (1) year

*For unopened product.

Pot Life of Mixed Product:
3 Hours* @ 77°F (25°C) and 50% RH

*Less when Endura Super Catalyst II is used.

Suitability

Endura HS-421 Primer is designed for use over previously painted surfaces. It can be used directly over wood or fiberglass. For best results, **HS-421 Primer should be sanded and then sealed with EP-FD Epoxy Primer or EP-2C Sealer before topcoat application.**
Application of this primer is not recommended over bare metal if corrosion or impact resistance are expected.
Flexible surfaces should not be coated with this Primer.

Surface Preparation

Surfaces must be free of all contaminants such as dust, oil, grease, and salt. A first coat of EP-2C Sealer is recommended on bare metal to provide the best corrosion resistance. Polyester body filler and putty should be finished with 180 grit or finer sandpaper.

Mixing Ratio

4 parts by volume of component A [FEA0313]
1 part by volume of component B [FUB0100]
1 Part EX-2C Thinner
When improved durability and better holdout is required from this primer, use a 2:1 ratio of Part A to B. (Sandability will be reduced.)
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*

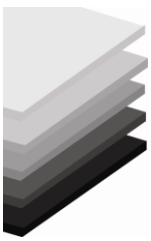
Using a Ford 4 Cup (white)

23 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	10-14 oz/min
Air Assist Airless	9-17 Thou	1,000-1,800 psi	
Airless	11-13 Thou	1,700-3,000 psi	



Endura Topcoat
EP-2C Sealer or
EP-FD Primer**
HS-421 Primer
EP-2C Sealer**
Substrate

**optional

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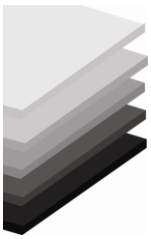

Endura Topcoat
EP-2C Sealer or
EP-FD Primer**
HS-421 Primer
EP-2C Sealer**
Substrate

**optional

Application Method

Endura HS-421 Primer can be applied using most spray painting systems.
As a Primer: Apply 1 - 3 consecutive wet coats with a 10 - 20 minute flash-off between coats. A flash-off period of 2 or more hours is required before sanding.
As a High Build Primer: Under normal conditions, the product must be allowed to dry 4 - 8 hours before sanding and sealing.

Recommended Film Build Thickness and Cover Rate

Endura HS-421 Primer has a recommended dry film thickness of:

Wet (unreduced): 4.0 – 8.0 mils wet (100 – 200 microns)
Dry: 2.0 - 4.0 mils (50- 100 microns)

Theoretical coverage at 1.0 mil (25 microns) DFT: 768 ft² per gallon @ 100% transfer efficiency.

Drying Time*

For best results, Endura HS-421 Primer must be sealed before topcoat application. To provide best protection, topcoat with Endura EX-2C Topcoat.

	20°C (68°F)	30°C (86°F)	40°C (104°F)
Topcoat			
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	100 MEK rubs; NO failure
Impact resistance	ASTM D2794	20 in.lbs; NO failure
Flexibility	ASTM D522	¼" mandrel bend; NO failure
service temperature range	-40°C to 182°C	-40°F to 360°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.