



EP-521 Low VOC Primer (new formula after B070404)

Endura EP-521 Low VOC 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

- ◆ Formulated for use where high impact resistance is required
- ◆ High solids formulation fills a sandblast profile in one coat
- ◆ No induction time required
- ◆ Up to a 3 day topcoat window
- ◆ **VOC Compliant**

Theoretical Solids Content:

Volume: 60%
(Depending on colour)

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 Low VOC 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.

Endura EP-521 Low VOC is formulated to exceed the Canadian Automotive refinishing guidelines for VOC levels in primers.



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 component A [part# varies by colour] (currently available in beige)
1 part by volume of component B [FEB0579]

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- 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.

To achieve the correct spraying viscosity and for VOC compliance, thin up to 15% with Endura Low VOC Epoxy Reducers.

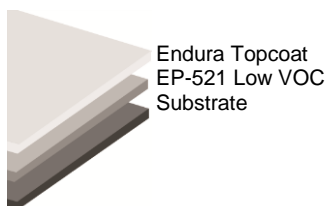
[FTH0016] Low VOC Epoxy Reducer- Regular (VOC = 0 g/L, 0 lbs/gal)

[FTH0027] Low VOC Epoxy Reducer- Slow (VOC = 0 g/L, 0 lbs/gal).



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	13-15 Thou	1,000-1,800 psi	
Airless	13-15 Thou	1,700-3,000 psi	
HVLP	1.6-2.0 mm	Max gun setting (35 psi)	





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Recommended Film Build Thickness and Cover Rate

Endura EP-521 Low VOC Epoxy Primer recommended film build thickness:

Wet (unreduced): 5.0 – 8.5 mils wet (125 – 212.5 microns)

Dry: 3.0 – 5.0 mils dry (75 – 125 microns).

Theoretical coverage at 1.0 mil (25 microns) DFT: 960 ft² per gallon @ 100% transfer efficiency.



Drying Time*

After 72 hours, at 20°C (68°F), this primer must be scuff sanded.

	20°C (68°F)	30°C (86°F)	40°C (104°F)
Topcoat	3 Hours	2 Hours	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
VOC	< 228 grams/liter (1.9 lbs/gallon)	



Clean Up

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

Notes

For batches of EP-521 Low VOC prior to B07040 the product was ready to spray and did not generally require thinning.

EP-521 Low VOC after B070404 was produced to provide applicators with greater flexibility in achieving their desired spraying viscosity; depending on the ambient conditions, spray equipment used, and on the surface finish that is desired. This version will require reduction to achieve proper spraying viscosity.

