



## 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
- ◆ **VOC Compliant**

### Theoretical Solids Content:

Volume: 77%

### 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.

**Endura EP HiBuild is formulated to exceed the Canadian Automotive refinishing guidelines for VOC levels in primers.**



### 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 part A [part# varies by color]  
1 part by volume of part 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\*

| Using a Ford 4 Cup (white) |                       |
|----------------------------|-----------------------|
| 25 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 maintain VOC compliance thin EP-HiBuild with Endura Low VOC Epoxy Reducers.

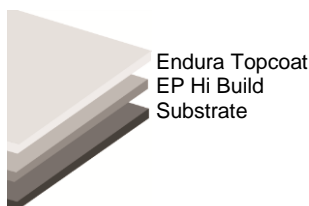
[FTH0016] Low VOC Epoxy Reducer- Regular (VOC = 0 g/L, 0 lbs/gal)

[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                       |                |





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### Recommended Film Build Thickness and Cover Rate

Endura EP HiBuild Epoxy Primer has a recommended film build thickness of:

Wet (unreduced): 5.0 – 7.5 mils wet (125 – 187.5 microns)

**Dry: 4.0 - 6.0 mils dry (100 – 150 microns)**

*For waterproofing 10+ mils DFT are required.*

Theoretical coverage at 1.0 mil (25 microns) DFT: 1184 ft<sup>2</sup> 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     |

\* Subject to ambient conditions (temperature and humidity) film build and good airflow. For improved scheduling please contact your Endura representative.

### 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 |
| service temperature range** | -40°C to +121°C                          | -40°F to 250°F          |
| <b>VOC</b>                  | <b>224 grams/liter (1.86 lbs/gallon)</b> |                         |



### Clean Up

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

