



EP-PA Low VOC Primer

Endura EP-PA Low VOC Primer is a two-component epoxy primer designed for use on smooth aluminum.

Product Features

- ◆ Excellent hardness and flexibility
- ◆ Ideally suited for aluminum aircraft
- ◆ Superior primer for aluminum
- ◆ Excellent corrosion resistance
- ◆ VOC Compliant

Theoretical Solids Content:

Volume: 35%

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-PA Low VOC Primer is formulated for use on aluminum aircraft and boats above the water line. It is an excellent primer due to its corrosion resistance on aluminum, steel, zinc-coated steel and other ferrous and non-ferrous metals.

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



Surface Preparation

Aluminum surfaces must be etched with Endura Aluminum Cleaner and treated with Endura Aluminum Conversion Coating. Alternative preparation procedure is the Endura Metalink™ process.



Mixing Ratio

1 part by volume of component A [FEA0054]
1 part by volume of component B [FEB0054]

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*

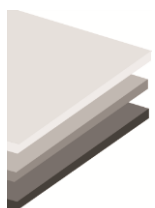
Using a Ford 4 Cup (white)	
15 Seconds *	N/A *
Conventional	Airless

* 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	1.3-1.4 mm	40-50 psi	
Pressure Feed	1.0-1.2 mm	30-40 psi	7-10 oz/min
Air Assist Airless	9-11 thou	1000-1800 psi	
Airless		N/A	



Endura Topcoat
EP-PA Low VOC
Substrate



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Recommended Film Build Thickness and Cover Rate

The recommended film build thickness for the Endura EP-PA Low VOC primer is 1.0 – 1.5 mils DFT. Apply in 2 light coats of 2 wet mils per coat.

Theoretical coverage at 1.0 mil (25 microns) DFT: 560 ft² per gallon @ 100% transfer efficiency.

*Loss of topcoat adhesion may result if recommended film build parameters are not followed. At recommended film thickness the primer may appear semi transparent.



Drying Time*

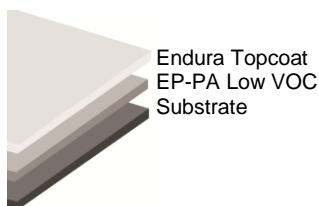
Under normal conditions the product must be allowed to dry for 2 - 24 hours before topcoat application. Best protection is provided when topcoated with Endura EX-2C Low VOC Topcoat. **If allowed to dry more than 24 hours at normal temperature, Endura EP-PA Low VOC Primer must be scuff sanded.**

	20°C (68°F)	30°C (86°F)	40°C (104°F)
Topcoat	2 Hours	1 Hour	30 minutes
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	ASTM D2794	40 in. lbs; NO failure
Flexibility	ASTM D522	1/8 mandrel bend; NO failure
VOC	248 grams/liter (2.1 lbs/gallon)	



Clean Up

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