



EP-521 Low VOC Primer

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
- ◆ Quick dry time and a 3 day topcoat window
- ◆ No induction time required
- ◆ **VOC Compliant**

Theoretical Solids Content:

Volume: 60% ± 1%
(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.



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] (see website for color list)
1 part by volume of component B [FEB0850]

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 *	N/A *
Conventional	Airless

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

If required and to maintain VOC compliance thin EP-521 with Endura Low VOC Epoxy Reducers.

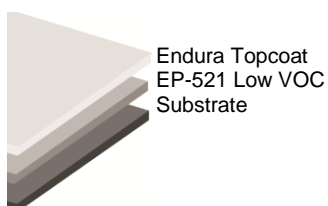
[FTH0016] Low VOC Epoxy Reducer- Regular (VOC = 0 g/L, 0 lbs/gal)

[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 has a recommended film thickness of:

Wet (unreduced): 5.0 – 8.0 mils wet (125 – 200 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.

**the 72 hour recoat is based on 20°C and no Endura EpoCat, higher temperatures and the use of EpoCat will reduce the recoat window.

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	< 248 grams/liter (2.07 lbs/gallon)	



Clean Up

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

