Endura Manufacturing Co. Ltd
12425 - 149 Street NW
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Phone: +1-780-451-4242/ 1-800-661-9930
www.endurapaint.com

EP Sandable Primer

Technical Data Sheet (TDS)

Product Description

EP Sandable Primer is a medium solids, medium build, two-component, epoxy primer providing excellent adhesion, hardness and corrosion resistance.

Product features:

- Can be topcoated in 1-2 hours
- No induction required
- Next shift sandability (min. 4 hours)
- Slow B is available for large projects
- Available in Grey and Black

Recommended Uses

EP Sandable Primer is intended for industrial applications; either new build or maintenance. EP Sandable Primer is suitable for application on steel, aluminum and fiberglass substrates. This primer must be topcoated to achieve the best results.

Industries:

- Oilfield & Energy Services
  - Well Services Equipment
- Cranes and Construction Equipment
- Trailers
- Waste and Recycling Industry
  - Garbage Trucks
- Marine (above the water line)

Mix Ratio

USING REGULAR B:
3 parts by volume of component A **[FEAXXXX]**
[Part Number varies with color]
1 part by volume of component B **[FEB0038]**

USING SLOW B:
3 parts by volume of component A **[FEAXXXX]**
[Part Number varies with color]
1 part by volume of component **B** **[FEB0138]**

The recommended temperature when mixed is 68-77°F (20-25°C).

Product Characteristics

Finish:	Lo Gloss
Volume Solids Mixed: (Unreduced) **FEA0038: FEB0038 (3:1)**	47% ± 2%
Volume solids will vary by color and B component	
Pot Life: (77°F (25°C) and 50% RH)	10 Hours
VOC Mixed (Unreduced): EPA Method 24 **FEA0038: FEB0038 (3:1))**	460 g/l 3.839 lb /gal
VOC content will vary with each color and B component	
Shelf Life:	
Component A	3 years
Component B	2 years
For unopened product (77°F (25°C))	

Surface Preparation

Surface must be free of all contaminants such as dust, oil, grease and salt. It is recommended that all steel and other ferrous surfaces be sandblasted to a minimum of SSPC-SP6 or mechanically sanded with 80 grit sandpaper.

For all other substrates, refer to the Endura recommended surface preparation instruction sheets or contact your Endura Representative.

Application Method

EP Sandable Primer can be applied using most spray systems, although electrostatic sprayers are not recommended.

Apply 1-2 coats as required to achieve the desired film thickness. Allow sufficient flash time between coats especially with higher film builds applied (20-30 minutes).

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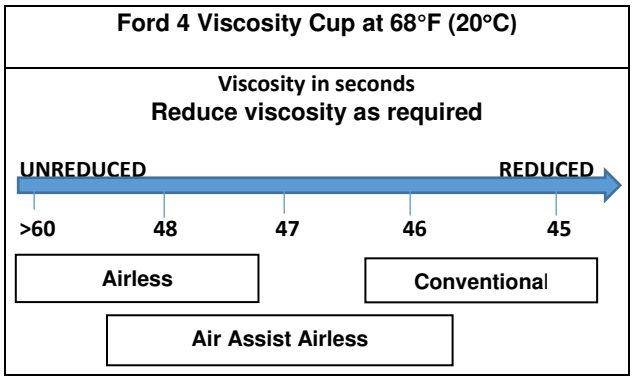
Spray Gun Setup

Feed Type	Fluid Tip	Application Pressures (heel of gun)	Fluid Delivery
Siphon Feed	1.6-2.0 mm	40-50 psi	
Gravity Feed	1.6-2.0 mm	30-40 psi	
Pressure Feed	1.4-2.0 mm	50-60 psi	10-14 oz/min
Air Assist Airless	9-17 Thou	1,000-1,800 psi	
Airless	11-15 Thou	1,700-3,000 psi	

Spraying Viscosity



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

If required, recommended spraying viscosity is achieved by reducing with one of the following Endura Epoxy reducers:

[FTH0654] Epoxy Reducer - Fast (for use in lower ambient temps)
[FTH0653] Epoxy Reducer - Regular (for use in average temps)
[FTH0652] Epoxy Reducer - Slow (for use in higher ambient temps)

Film Build

EP Sandable Primer has a recommended film build thickness of:

Wet: WFT Unreduced	**6.0 – 10.0 mils**	**152 – 254 microns**
Dry: DFT	**3.0 – 5.0 mils**	**76 – 127 microns**

The recommended dry film thickness is above the blast/sanding profile

Theoretical coverage at 1.0 mil (25 microns) DFT: 750 ft² per gallon at 100% transfer efficiency. (Regular B)

Dry Times

REGULAR B	68°F (20°C)	86°F (30°C)	104°F (40°C)
Topcoat	1-2 Hours	1 Hour	45 Minutes
To Sand	Optimal: 8 Hours Minimum: 4 Hours		

SLOW B	68°F (20°C)	86°F (30°C)	104°F (40°C)
Topcoat	2-3 Hours	1-2 Hours	1 Hour
To Sand	Optimal: 8 Hours Minimum: 4 Hours		

Note: Dry Times are subject to ambient conditions (temperature and humidity) and good airflow and film build of primer.

For best results, surface temperature must be 86°F (30°C) or less before topcoating. Maximum re-coat window without sanding is 7 days at 68°F (20°C). Recommended mechanical sanding with 180–220 grit after the topcoat window has been exceeded.

Note: If the primer is allowed to sit for an extended period without being topcoated, the surface must be kept clean of contaminants to avoid any topcoat issues.

For improved scheduling please contact your Endura Representative.

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Topcoating Information

EP Sandable Primer can be topcoated with the entire range of Endura topcoat products.

Clean Up

Clean all equipment immediately after use with Endura High Strength Gun Wash, Endura epoxy reducer or Endura EX-2C thinner.

Follow manufacturer's safety recommendations when using any solvent

Ordering Information (sizing)

Available in Gallons and Pails
Other custom sizes may be available.

1 Mixed Gallon		
Comp A - Grey	**FEA0038-033**	**3 Qts.**
Comp A - Black	**FEA0338-033**	**3 Qts.**
Comp B	**FEB0038-020**	**1 Qt.**
	OR	
Slow Comp B	**FEB0138-020**	**1 Qt.**

4 Mixed Gallons		
Comp A - Grey	**FEA0038-053**	**3 Gals.**
Comp A - Black	**FEA0338-053**	**3 Gals.**
Comp B	**FEB0038-030**	**1 Gal.**
	OR	
Slow Comp B	**FEB0138-030**	**1 Gal.**

Environmental Conditions

For optimum coating performance, product, substrate and ambient temperature should be between 68°F-77°F (20°C-25°C). To prevent condensation during application, the surface temperature must be 5°F (3°C) or more above the dew point at all times.

For use outside this range please contact your Endura Representative.

Specifications

Solvent Resistance	ASTM D4752	100 MEK Rubs; NO failure
Impact Resistance	ASTM D2794	40 in. lbs; NO failure
Flexibility	ASTM D522	1/4 mandrel bend: NO failure
Service Temp Range	-40°F to 200°F	-40°C to 93°C

Safety Precautions

Please refer to all Safety Data Sheets (SDS) before using this product. SDS sheets can be found on our website at www.endurapaint.com