Endura Manufacturing Co. Ltd
12425 - 149 Street NW
Edmonton, Alberta, Canada T5L 2J6
Phone: +1-780-451-4242/ 1-800-661-9930
www.endurapaint.com

HFE3080 Primer

Technical Data Sheet (TDS)

Product Description

HFE3080 is a low VOC, zinc-rich, epoxy primer. It contains a minimum of 80% zinc in the dry film to provide cathodic protection.

Product features:

- Excellent corrosion protection
- Ability to fill a sandblast profile in one coat
- Can provide Cathodic protection
- VOC Compliant

Recommended Uses

HFE3080 Primer is intended for industrial applications; either new build or maintenance. HFE3080 Primer is suitable for application on properly sanded or sandblasted steel and for properly prepared galvanized or zinc coated substrates.
This primer must be topcoated to achieve the best results.

HFE3080 Primer It is recommended for areas requiring high corrosion protection such as coastal service.

Industries:

- Oilfield & Energy Services
  - Well Service vehicles
  - Drilling Rigs
- Cranes and Construction Equipment
- Trailers
- Waste and Recycling Industry
  - Garbage Trucks

Mix Ratio

5 parts by volume of component A **[FEA0056]**
1 part by volume of component B **[FEB0056]**

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

Product Characteristics

Finish:	Lo Gloss
Volume Solids Mixed: (Unreduced) **FEA0056: FEB0056 (5:1)**	56% ± 1%
Pot Life: (77°F (25°C) and 50% RH)	10 Hours
VOC Mixed (Unreduced): EPA Method 24 **FEA0056:FEB0056 (5:1)**	217 g/l 1.819 lbs./gal
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 a minimum of SSPC- SP6 or mechanically sanded with 80 grit sand paper.

Near White Blast SSPC–SP10 or White Blast SSPC–SP5 sandblasting is required for and any offshore or coastal environments.

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

Application Method

HFE3080 Primer can be applied using most spray painting 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).

Agitation is not required while spraying; the zinc is fully suspended in the coating.

Endura Manufacturing Co. Ltd
12425 - 149 Street NW
Edmonton, Alberta, Canada T5L 2J6
Phone: +1-780-451-4242/ 1-800-661-9930
www.endurapaint.com

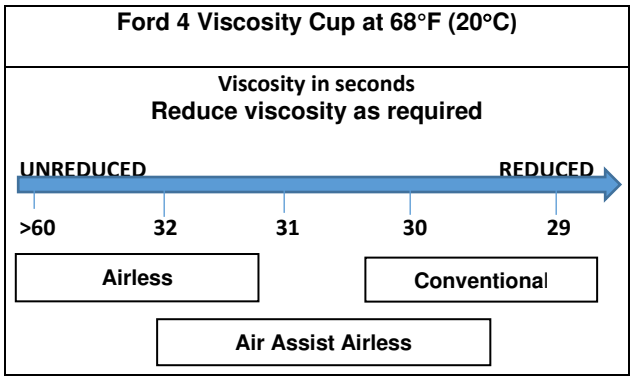
HFE3080 Primer

Technical Data Sheet (TDS)

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	40-50 psi	10-14 oz/min
Air Assist Airless	13-17 Thou	1,000-1,800 psi	
Airless	13-17 Thou	1,700-3,000 psi	

Spray 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 Low VOC Epoxy reducers. These will maintain VOC compliance of HFE 3080 Primer.

VOC content of the following Reducers: (0g/l, 0 lbs. /gal)

[FTH0016] Low VOC Epoxy Reducer- Regular
[FTH0027] Low VOC Epoxy Reducer- Slow

Film Build

HFE3080 Primer has a recommended film build thickness of:

Wet: WFT Unreduced	**5.5 – 9.0 mils**	**140 – 230** 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: 898 ft² per gallon at 100% transfer efficiency.

Dry Times

	68°F (20°C)	86°F (30°C)	104°F (40°C)
Topcoat	3 Hours	1 Hours	30 Minutes
Full Cure	7-9 Days	5-6 Days	3-4 Days

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

For best results surface temperature must be 86°F (30°C) or less before topcoating.
Maximum re-coat window without sanding is 3 Days at 68°F (20°C)
Recommended Sanding 180 – 220 grit after the topcoat window has been exceeded.

For questions about scheduling please contact your Endura Representative.

Topcoating Information

HFE3080 Primer can be topcoated with the entire range of Endura topcoat products.

Endura Manufacturing Co. Ltd
12425 - 149 Street NW
Edmonton, Alberta, Canada T5L 2J6
Phone: +1-780-451-4242/ 1-800-661-9930
www.endurapaint.com

HFE3080 Primer

Technical Data Sheet (TDS)

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.

Product lead times may apply.
Please contact your Endura Representative for further information regarding stock availability and lead times.

1 Mixed Gallon		
Comp A - Grey	**FEA0056-035**	**3.15 L**
Comp B	**FEB0056-022**	**0.63 L**

Approximately 4 Mixed Gallons		
Comp A - Grey	**FEA0056-055**	**12.6 L**
Comp B	**FEB0056-036**	**2.25 L**

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	100 in. lbs Direct; 50 in. lbs Reverse NO failure
Flexibility	ASTM D522	1/4 in. mandrel bend: NO failure
Service Temp	-40°F to 250°F	-40°C to 121°C
Percentage of zinc in the dry film		80%

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.