



Velocity Low VOC Primer

Technical Data Sheet (TDS)

Product Description

Velocity Low VOC Primer is a quick drying epoxy zinc primer. It provides superior adhesion, impact resistance and corrosion protection.

Product features:

- Provides corrosion protection
- Ability to fill a sandblast profile in one coat
- Ideal choice for high production environments.
- Quick dry time and a 7 day topcoat window
- VOC Compliant

Recommended Uses

Velocity Low VOC Primer is intended for industrial applications, either new build or maintenance. Velocity Low VOC Primer is suitable for application on steel and other ferrous metals.

This primer must be topcoated to achieve the best results.

Industries:

- Oilfield & Energy Services
 - Well Service Vehicles
- Cranes and Construction Equipment
- Trailers

Mix Ratio

3 parts by volume of component A **[FEA0067]**
(Part number varies with color)
1 part by volume of component B **[FEB0067]**

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

Product Characteristics

Finish:	Lo Gloss
Volume Solids Mixed: (Unreduced) FEA0067: FEB0067 (3:1)	47% ± 2%
Pot Life: (77°F (25°C) and 50% RH)	10 Hours
VOC Mixed (Unreduced): EPA Method 24 FEA0067: FEB0067 (3:1)	230 g/l 1.923 lb /gal
Note: All colors are below 250g/l	
Shelf Life:	
Component A	3 years
Component B	2 years
For unopened product (77°F (25°C))	

The use of EpoCat in Velocity Low VOC Primer is not required or recommended.

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.

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

Application Method

Velocity Low VOC 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).



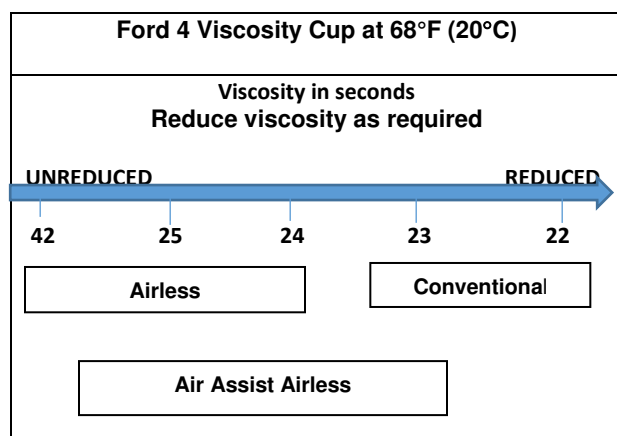
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Technical Data Sheet (TDS)

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	1.4-1.6 mm	40-50 psi	
Pressure Feed	1.0-1.3 mm	30-40 psi	12-16 oz/min
Air Assist Airless	11-13 Thou	1,000-1,800 psi	
Airless	11-13 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.

To maintain VOC compliance, if required, thin with one of the following Endura Low VOC Epoxy reducers.

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

Film Build

Velocity Low VOC Primer has a recommended film build thickness of:

Wet: WFT Unreduced	6.5 – 10.5 mils	165 – 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: 753 ft² per gallon at 100% transfer efficiency.

Dry Times

	50°F (10°C)	73°F (23°C)	86°F (30°C)
To Topcoat			
5.0 mils wet	2 Hour	1 Hour	30 Minutes
10 mils wet	4-5 Hours	2-3 Hours	1-2 Hours
Full Cure	7-14 Days		

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 sanding 180 – 220 grit after the topcoat window has been exceeded.

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 questions about scheduling please contact your Endura Representative.



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Topcoating Information

Velocity Low VOC 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	FEA0067-033	3 Qt
Comp B	FEB0067-020	1 Qt

4 Mixed Gallons		
Comp A - Grey	FEA0067-053	3 Gal
Comp B	FEB0067-030	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	50 MEK Rubs; No Failure
Impact resistance	ASTM D2794	40 in. lbs; NO failure
Flexibility	ASTM D522	1/8 in. mandrel bend: NO failure
Service Temp	-40°F to 250°F	-40°C to 121°C
Percentage of zinc in the dry film	21%	

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.