

## Epoxy Primer Surfacer

### Technical Data Sheet (TDS)

#### Product Description

Epoxy Primer Surfacer is a two-component epoxy primer sealer that can be used over multiple surfaces with various degrees of preparation.

**Product features:**

- Ultra smooth finish
- Thin film coating
- Low VOC
- Chrome free formulation

**Do not use below the waterline.**

#### Recommended Uses

Use as a sealer over existing or aged coatings prior to finish coat application. Epoxy Primer Surfacer produces an ultra smooth thin film sealer finish over fiberglass, aluminum, reinforced plastics, wood, and pre-existing coatings that must be sealed before urethane top-coat is applied. This product is intended for professional use.

#### Mix Ratio

**1 part by volume of component A [MPA0200]**

**1 part by volume of component B [MPB0200]**

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

#### Product Characteristics

<b>Finish</b>	Low gloss
<b>Volume Solids Mixed:(Unreduced)</b>	27% ± 2%
<b>Pot Life: (77°F (25°C) and 50% RH)</b>	10 Hours
<b>VOC Mixed (Unreduced): EPA Method 24: Typical</b>	334 g/l 2.792 lb /gal
<b>Shelf Life:</b>	2 years unopened
<b>Available Sizes:</b>	Quarts, Gallons

#### Surface Preparation

**Bare Fiberglass or epoxy or existing finishes:** Remove all contaminants such as dust, oil, grease, and salt. Flush with fresh water and allow to dry. Sand with 80 -120 grit. Remove all sanding dust before priming.

**Bare Aluminum:** Clean the surface with Degreaser 10 (follow the product instructions). Once the Aluminum surface has properly dried from using Degreaser 10, mechanically sand the surface with 80-120 grit. A maroon nylon scuffing pad can be used in hard-to-reach areas. Once sanded, Epoxy Primer Surfacer must be applied within 4 hours to achieve optimal adhesion. If the time between sanding and priming exceeds 4 Hours, the surface should be re-sanded.

For any surfaces not mentioned or for further information contact your Endura Representative.

#### Application

Epoxy Primer Surfacer can be brushed, rolled or spray applied using most spray systems (airless application is not recommended).

**Spraying:** Apply 2 light coats. Allow sufficient flash time between coats (20-30 minutes). **Spraying viscosity and thinning will depend on ambient conditions, spray equipment used, and the desired surface finish.**

**Brushing or Rolling:** For brushing use a natural hair bristle brush or for rolling a short (1/8") pile solvent resistant roller. Apply one medium coat.

Epoxy Primer Surfacer can be topcoated with the full range of Endura Marine Topcoats

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#### Dry Times

	68°F (20°C)	86°F (30°C)	104°F (40°C)
Topcoat	1 Hour	30 Minutes	15 Minutes
Dry Hard	3-5 Hours		
Full Cure	7-9 Days	5-6 Days	3-4 Days

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

The maximum re-coat window without sanding Epoxy Primer Surfacer is 24 hours at 68°F (20°C). If the topcoat window has been exceeded sand with 220 – 320 grit sandpaper and blow off sanding dust prior to topcoating.

**If the substrate crosses the dew point, there is potential for the primer film to absorb moisture and cause adhesion problems leading to delamination. Booth temperature should be maintained between prime coat and topcoat to avoid this issue.**

For questions about scheduling please contact your Endura Representative.

#### Film Build

Epoxy Primer Surfacer has a recommended film build thickness of:

Wet: WFT Unreduced	3.5 – 5.5 mils	89 – 140 microns
Dry: DFT	1.0 – 1.5 mils	25 – 38 microns

Theoretical coverage at 1.0 mil (25 microns) DFT: 433 ft<sup>2</sup> per gallon at 100% transfer efficiency.

#### Clean Up

Clean all equipment immediately after use with a High Strength Gun Wash, Endura epoxy reducers or Endura topcoat thinners/reducers. Follow manufacturer's safety recommendations when using any solvent.

#### 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 (5°F) or more above the dew point at all times.

For use outside this range contact your Endura Representative.

#### Safety Precautions

Refer to all Safety Data Sheets (SDS) before using this product. SDS sheets can be found on our website at [www.enduramarinepaint.com](http://www.enduramarinepaint.com)