

Epoxy Primer Technical Data Sheet (TDS)

Product Description

Epoxy Primer is a two-component epoxy that can be applied in multiple coats to cover fiberglass, aluminum, wood, and steel substrates.

Product features:

- Ability to fill a sandblast profile in one coat
- Quick dry time
- 3 day topcoat window
- chrome free formulation

Do not use below the waterline.

Recommended Uses

Use to seal fillers and fairing work. Epoxy Primer is suitable for the following substrates: fiberglass, aluminum, wood, and pre-existing coatings that require a medium build epoxy primer. This product is intended for professional use.

Mix Ratio

5 parts by volume of component A [MPA0300]

1 part by volume of component B [MPB0300]

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

Thin as required for application with Marine Epoxy Reducer [MER0200] or Marine Slow Epoxy Reducer [MER0100].

Product Characteristics

Finish	Low gloss
Volume Solids Mixed:(Unreduced)	54 % ± 1%
Pot Life: (77°F (25°C) and 50% RH)	10 Hours
VOC Mixed (Unreduced): EPA Method 24: Typical	371 g/l 3.101 lb /gal
Shelf Life:	2 years unopened
Container Sizes:	Gallons, 5 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.

Bare Steel (Above Waterline): It is recommended that all steel and other ferrous surfaces be sandblasted a minimum of SSPC-SP6 or mechanically sanded with 80 grit sandpaper.

For any surfaces not mentioned or for further information of preparation below the waterline contact your Endura Representative.

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Application

Epoxy Primer can be sprayed, brushed, or rolled. Mariner Epoxy Primer can be applied using most spray systems.

Spraying: Apply 1 -2 coats as required to achieve the desired film build. 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 1-2 coats as required to achieve the desired film build. Allow sufficient flash time between coats (20-30 minutes).

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

Dry Times

	68°F (20°C)	86°F (30°C)	104°F (40°C)
Topcoat	3 Hours	2 Hours	1-2 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 is 3 days at 68°F (20°C). If the topcoat window has been exceeded sand with 180 – 220 grit sandpaper and blow off sanding dust prior to topcoating.

If Marine Epoxy Accelerator is used, the topcoat window is 12 hours maximum.

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 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

Theoretical coverage at 1.0 mil (25 microns) DFT: 862 ft² per gallon at 100% transfer efficiency.

Clean Up

Clean all equipment immediately after use with a High Strength Gun Wash, Endura Marine Epoxy Reducer or Endura Marine Urethane Reducer. 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

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