

# ENDURO PRIME

## DTM Epoxy Primer



### TECHNICAL DATA SHEET

ENDURO PRIME is a user-friendly two-component epoxy primer, free of lead chromate and isocyanates. This system provides excellent adhesion and corrosion resistance, dries quickly and maintains good color holdout. Available in two colors, ENDURO PRIME provides an exceptionally strong and durable foundation for complete and/or partial refinishing work. May be applied directly over properly prepared steel, aluminum, factory finishes, fiberglass, body fillers and other substrates. Unlike most epoxies, ENDURO PRIME won't gum up when sanded after about two-three days. Mixes 1:1 with epoxy catalyst, with no induction time required.

- National Rule Compliant
- Easy 1:1 mix ratio, yields two sprayable gallons
- No induction time required
- Exceptional durability and corrosion resistance
- Excellent adhesion over bare metal and other substrates
- May be converted into a sealer
- Builds fast, fills well and may be sanded easily
- Exceptional value

#### COATING TYPE:

Catalyzed epoxy primer

#### PRODUCT CODE:

EP-611 / EP-611QT (Gray)  
EP-612 / EP-612QT (Black)

#### CATALYST:

EPC-611 / EPC-611QT

#### REDUCERS:

UR-9065 / UR-8065 Fast (Low temp)  
UR-9075 / UR-8075 Medium (Mid temp)  
UR-9085 / UR-8075 Slow (High temp)  
UR-9095 / UR-8095 Super slow (Very high temp)  
UE-8000 Universal Zero-VOC Reducer



#### PHYSICALS:

|                           |   |
|---------------------------|---|
| <b>Appearance:</b>        | Gray or black   |
| <b>Weight per Gallon:</b> | 9.0 – 9.4 lbs (Varies with color)   |
| <b>Package Measure:</b>   | 1 U.S. gallon / 128 fl. oz. (3.785 liters)<br>1 U.S. quart / 32fl. oz. (0.946 liters) |
| <b>RTS VOC:</b>           | 4.70 lbs/gallon (568 g/L)   |
| <b>RTS Viscosity:</b>     | 20-22 sec. In #2 Zahn cup   |



**SURFACE PREP:**

ENDURO PRIME is an ideal choice for use after sandblasting, as it will fill any pits left in the metal while providing excellent adhesion to the substrate. If sandblasting is not an option, be sure to grind or sand all surface rust and remove / neutralize any traces of oxidation before attempting to apply any coating.

**For bare metal:**

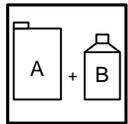
Remove all traces of wax, grease, silicone, oil and other contaminants with detergent wash, followed with a solvent wash (such as Kirker's 650 Wax & Grease Remover). Abrade substrate with 180 grit, and then re-clean with final wash cleaner (such as Kirker's 600 Surface Wash).

A chemical pre-treatment (such as Kirker's R-6820 Self-Etching Reducer) may help to further enhance adhesion over bare metal. Though not required, this etching acid/solvent blend should be applied one section at a time with a clean cloth, and then wiped down with another clean, dry cloth.

**For factory finishes:**

Remove all traces of wax, grease, silicone, oil and other contaminants with detergent wash, followed with a solvent wash (such as Kirker's 650 Wax & Grease Remover). Abrade substrate with 320 - 400 grit, and then re-clean with final wash cleaner (such as Kirker's 600 Surface Wash).

Be sure to mask all adjacent panels to prevent dry overspray.



**MIXING:**

Mix ratio: 1:1 by volume. Thoroughly mix one (1) part ENDURO PRIME (EP-611 or EP-612) with one (1) part Epoxy Catalyst (EPC-611). No induction time is required.

No additional reduction is required, though reducing the 1:1 mix may improve sprayability and will decrease the total film build, which is desirable in situations where a sealer is called for. ENDURO PRIME may be reduced with one of Kirker's urethane-grade reducers (chosed from the list below depending on the anticipated shop temperature at the time of application) or by up to 20% with Kirker's Universal Zero-V.O.C. Reducer, UE-8000. As an exempt reducer, UE-8000 will not increase the V.O.C. of ENDURO-PRIME.

| Temperature range | Less than 70° F | 70° F - 80° F | 80° F – 90°F  | Above 90°F    |
|-------------------|-----------------|---------------|---------------|---------------|
| Reducer (Gallon)  | UR-9065 (Gal)   | UR-9075 (Gal) | UR-9085 (Gal) | UR-9095 (Gal) |
| Reducer (Quart)   | UR-8065 (Qt)    | UR-8075 (Qt)  | UR-8085 (Qt)  | UR-8095 (Qt)  |
| Speed             | FAST            | MEDIUM        | SLOW          | SUPER SLOW    |

Caution: Mix only as much material as you will need to complete the immediate job.

1:1

|                      |              |               |               |               |
|----------------------|--------------|---------------|---------------|---------------|
| EP-611 or EP-612     | 3oz          | 6 oz.         | 12 oz.        | 17 oz.        |
| EPC611 Catalyst      | 3 oz.        | 6 oz.         | 12 oz.        | 17 oz.        |
| <b>TOTAL MIXTURE</b> | <b>6 oz.</b> | <b>12 oz.</b> | <b>24 oz.</b> | <b>32 oz.</b> |

+ 20%

**LOW BUILD OPTION:**

|                      |              |               |               |               |
|----------------------|--------------|---------------|---------------|---------------|
| EP-611 or EP-612     | 2oz          | 6 oz.         | 12 oz.        | 16 oz.        |
| EPC611 Catalyst      | 2 oz.        | 6 oz.         | 12 oz.        | 16 oz.        |
| UE-8000 Reducer      | 1 oz.        | 3 oz.         | 6 oz.         | 8 oz.         |
| <b>TOTAL MIXTURE</b> | <b>5 oz.</b> | <b>15 oz.</b> | <b>30 oz.</b> | <b>40 oz.</b> |



**POT LIFE:**

Approximately 90 minutes at 70°F

Caution: Pot life is significantly shorter at elevated temperatures and in humid conditions. These environmental factors also may affect flow and leveling during the application process.



**GUN SETTINGS:**

| <b>GUN TYPE</b>            | <b>TIP SIZE</b> | <b>AIR PRESSURE</b>  |
|----------------------------|-----------------|----------------------|
| Conventional Siphon Feed:  | 1.6 mm – 1.8mm  | 45-55 psi at the gun |
| Conventional Gravity Feed: | 1.4 mm – 1.6 mm | 45-55 psi at the gun |
| HVLP                       | 1.4 mm – 1.8 mm | 8-10 psi at the tip  |

*Always refer to gun manufacturer's recommendations for additional details on suggested tip size, air pressure and other adjustments.*



**APPLICATION:**

Apply one (1) to two (2) wet coats, depending upon desired film build, allowing 30 minutes flash time between coats. A dry film thickness of 1 mil. Is recommended.

As per mixing directions on previous page, catalyzed ENDURO PRIME may be mixed by up to 20% with a Urethane-Grade Reducer, or Zero-V.O.C. Reducer such as Kirker's UE-8000 to decrease the total film build. In these situations, apply only one even, wet coat, and then allow 30 minutes flash before topcoating.



**DRY TIMES / RECOAT:**

Allow a minimum of 30 minutes for ENDURO PRIME to flash before topcoating. After applying two coats, wait a minimum of 45-60 minutes before topcoating.

After sufficient flash, ENDURO PRIME may be topcoated for approximately five (5) days with no sanding required. After approximately five days, epoxy should be scuff sanded before topcoat application.

ENDURO PRIME may be wet sanded the day after application, or dry after two to three days.

ULTRA-GLO acrylic urethane, ACRYL-GLO acrylic enamel and SYN-GLO synthetic enamel single-stage topcoats may all be applied directly over ENDURO-PRIME after sufficient flash time has passed. ENDURO PRIME may also be topcoated with PERFECT PRIME 2K urethane primer surfacer (overall) or RAPID PRIME 2K urethane primer surfacer (spot/panel).

*Air-dry times may vary slightly depending on shop temperatures, airflow and total film thickness. All dry times listed are approximate, at 70° - 75°F.*



**CLEANUP:**

Close all containers tightly after each use. Clean gun and spray equipment with gun wash or other appropriate solvent products immediately after application to prevent damage.

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**HEALTH / SAFETY PRECAUTIONS:**

THIS PRODUCT IS INTENDED FOR USE BY PROFESSIONALS ONLY.

USE THIS PRODUCT ONLY WITH ADEQUATE VENTILATION: Wear appropriate, properly fitted fresh-air-supplied NIOSH/MSHA-approved respirator (TC-19C or equivalent) as directed by the manufacturer. Protect hands with impervious nitrile gloves. Always wear eye and face protection. Individuals with lung or breathing problems should neither use nor be exposed to this product, its vapors or spray mist. READ ALL WARNINGS ON ALL LABELS BEFORE USING.

This product is designed to be mixed with other components. Mixture will have hazards of all components. Before opening the packages, read all warning labels. Follow all precautions. See Material Safety Data Sheet for additional health and safety information.

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**WARRANTY:**

All recommendations for the use of Kirker products are based on tests and experience believed to be reliable. Since the methods of use, conditions of application, and the application itself are beyond our control, product warranty is restricted to replacement of material only. No other warranty, written or oral, is expressed or implied.

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**FOR ADDITIONAL INFORMATION:**



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