

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 three different colors, ENDURO PRIME provides an exceptionally strong and durable foundation for complete and/or partial refinish work. May be applied directly over properly prepared steel, aluminum, factory finishes, fiberglass, body fillers and other substrates. Unlike most epoxies, ENDURO PRIME may be easily sanded after two or three days. Mixes 1:1 with epoxy catalyst. No induction time required.

- ◆ Low-VOC formula (2.1 lbs/gal)
- ◆ 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:

DTM Epoxy Primer

PRODUCT CODES:

EP610 / EP610QT (White)

EP611 / EP611QT (Gray)

EP612 / EP612QT (Black)

CATALYST:

EPC611 / EPC611QT

WEIGHT PER GALLON:

11-12.5 lbs (varies by color)

PACKAGE MEASURE:

1 US Gallon / 128 fl. oz. / 3.785 Liters

1 US Quart / 32 fl. oz. / 0.946 liters

RTS VOC:

Varies by color (will not exceed 2.1 lbs/gallon)

RTS Viscosity:

20-22 seconds, #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 6860 DTM PREP) may help to further enhance adhesion over bare metal. Though not required, this acid etch solution should be applied one section at a time with a clean cloth, and then wiped down with another clean, dry cloth before being neutralized with water or Surface Wash.

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 (EP610, EP611 or EP612) with one (1) part Epoxy Catalyst (EPC611). No induction time is required.

TO MIX	12 oz	24 oz	32 oz
PRIMER	6 oz	12 oz	16 oz
CATALYST	6 oz	12 oz	16 oz

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 any of Kirker's ULTRA-GLO Urethane-Grade Reducers or BLACK DIAMOND Low-VOC Reducers (choose from the list below depending on the anticipated shop temperature at the time of application).

BELOW 70°	70-80°	80-90°	ABOVE 90°
FAST	MEDIUM	SLOW	SUPER SLOW
UR-9065	UR-9075	UR-9085	UR-9095
UR-8065	UR-8075	UR-8085	UR-8095
LVR-565	LVR-575	LVR-585	LVR-595

POT LIFE

Approximately 90 minutes at 70°F.

Mix only as much material as is needed to complete the immediate job.

GUN SETTINGS

Always refer to gun manufacturer's recommendations for additional

GUN TYPE	TIP SIZE	AIR PRESSURE
Conventional Siphon	1.6-1.8 mm	45-55 psi
Conventional Gravity	1.4-1.6 mm	45-55 psi
HVLP	1.4-1.8 mm	8-10 psi

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, catalyzed ENDURO PRIME may be mixed by up to 20% with a Urethane-Grade Reducer or Low-VOC Reducer to decrease the total film build, converting to a sealer-like coating. In these situations, apply only one even, wet coat, and then allow 30 minutes for 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 Kirker's VOC Compliant Gun Wash (670) or other appropriate solvent products immediately after application to prevent damage.

HEALTH / SAFETY

THIS PRODUCT IS INTENDED FOR USE BY PROFESSIONALS ONLY. 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 Safety Data Sheet for additional health and safety information.

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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