



# Dampney Protective Coatings

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## Endcor<sup>®</sup> 400 Wash Primer

### Description

Endcor 400 Wash Primer is a vinyl metal conditioner that eliminates the need for wash-off types of phosphoric acid pre-treatments and additional temporary "shop" coats.

Endcor 400 Wash Primer --Low Flash meets U.S. Specification MIL-C-15328B Coating Pre-treatment (Formula 117 for Metals). Endcor 400 may be applied to moist or wet metal, and even under these conditions will dry within one-half hour to permit immediate application of finish coatings.

### Recommended Uses

Endcor 400 Wash Primer is designed as a priming conditioner for ferrous and non-ferrous metals prior to application of selected Endcor coatings.

NOTE: When used as a conditioner under the Endcor 300 series vinyls, always apply Endcor 350 Primer as a tie-coat between Endcor Wash Primers and the Endcor 300 series topcoats.

### Features

- Improves topcoat adhesion and impermeability
- Assists in inhibiting corrosion creepage should topcoating become damaged in service
- Gives temporary corrosion protection where sandblasted surfaces cannot be quickly primed.
- Fast drying time
- Can be applied to moist surfaces
- Brush or spray application

### Not Recommended For

Do not use under coatings designed for high heat service. Do not use inorganic zinc coatings. Although termed a primer, Endcor 400 is principally a Metal Conditioner and is not a substitute for substantial rust inhibitive primers.

### Surface Preparation

Steel: For best results, surfaces should be free from oil, grease, dirt, mill scale, rust, corrosion products, oxides, paint, and foreign matter. Abrasive blast surface to commercial grade per Steel Structures painting Council Specification SSPC-SP6, "Commercial Blast Cleaning," or per NACE specification No. 3. If abrasive blasting cannot be permitted, remove loose mill scale, loose rust,

and loose paint per specification SSPC-SP3, "Power Tool Cleaning."

New galvanized surfaces: Remove all oil, grease and flux by solvent cleaning per Specification SSPC-SP1, "Solvent Cleaning."

Weathered galvanized surfaces: Remove all dirt, oil and grease by solvent cleaning. Remove rust or foreign deposits by wire brushing per specification SSPC-SP2, "Hand Tool Cleaning," or power tool cleaning per specification SSPC-SP3, "Power Tool Cleaning."

Endcor 400 Wash Primer may be applied on moist surfaces.

### Mixing

Endcor 400 Wash Primer is a two component product consisting of base material and activator. For Endcor 400 Wash Primer the ratio is 4/5 gallon of base material (Component A) and 1/5 gallon of activator (Component B) which is in the smaller plastic bottle. Pour the activator into the base material and mix thoroughly.

Prepare only the amount required for one day's use. For smaller amounts of Endcor400, always mix the components in the ratio 4 parts by volume of base material to 1 part activator.

### Application

Endcor 400 Wash Primer may be applied by brush or conventional spray equipment. Airless spray application is not recommended. For best results, the applied film must be *extremely thin*--only 1/4 to 1/3 mil (dry)! Coverage is approximately 350 square feet per gallon on rough surfaces, and as high as 700 square feet per gallon on smooth surfaces. NEVER apply more than one coat of Endcor Wash Primer.

### Application Equipment

*Brush:* Apply suggested thinning procedures are identical to those for spray application as described below.

*Conventional spray equipment:* the specification MIL-C-15328 B contains no direct reference to thinning procedures. Atomizing is made easier with reductions of 25% by volume of the mixed primer. The spraying data

contained in this bulletin was obtained with this suggested reduction. Attaining a viscosity of 14-15 seconds No. 4 Ford Cup is considered ideal for good spraying practice.

As a guide only...

Spray gun	DeVilbiss P-MBC or JGA or equal
Air hose I.D.	5/16"
*Fluid hose I.D.	3/8"
Fluid nozzle	FF(.055")
Air cap	765 or 758
Pot pressure	15/20 lbs.
Atomizing pressure	60/65 lbs.
Needle adjustment	Full open
Distance from work	10-12"

\*Smaller hose diameters, or hose lengths greater than 25 feet may require increased pressures.

### Storage

Store in a cool, dry place, preferably below 80°F.

### Clean up

Clean brushes and spray equipment with Endcor 490 Thinner. Denatured alcohol may be substituted for cleaning purposes, but may not be used for thinning.

### Drying time

Allow 24 hours dry time between coats, or one hour between coats if heat cured at 350-400°F (177-204°C). Allow one hour solvent flash-off period after applications of each coat before heat curing or placing into high temperature service.

### Precautionary Information

Keep away from heat, sparks and flame. Use only with adequate ventilation. Avoid contact with eyes and skin. Avoid prolonged breathing of vapor or spray mist.

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In confined spaces, observe safety precautions and follow procedures described in OSHA regulations, Sections 1915.25-Painting, 1915.25-Flammable Liquids, and 1915.82-Respiratory Protection.

Provide adequate forced air ventilation. Require workmen to wear U.S. Bureau of Mines-approved air line respirator, and non-sparking footwear. Use only non-sparking tools and equipment. Use only explosion-proof lights and electrical equipment. Make certain all electrical equipment is grounded. Use protective clothing and skin cream.

FIRST AID: In case of contact with skin, flush with plenty of water. For eyes, immediately flush with plenty of water for 15 minutes and get medical attention. If exposed to high concentration of vapor, remove to fresh air. If swallowed, CALL A PHYSICIAN IMMEDIATELY. DO NOT induce vomiting.

Notice: Reports have associated repeated or prolonged occupational overexposure to solvents with permanent brain and nervous system damage. Intentional misuse deliberately concentrating and inhaling the contents may be harmful or fatal.

**See Material Safety Data Sheet (MSDS) on this product for complete precautionary information.**

### FOR INDUSTRIAL USE ONLY

### KEEP OUT OF REACH OF CHILDREN

<b>Shipping Weights</b>	<b>1's</b>	<b>5's</b>
Endcor 400	7.5 lbs.	38 lbs.
Endcor 490 Thinner	6 lbs.	30 lbs.

### Technical Data

Characteristics	Endcor 400 Wash Primer
Color	Greenish-Yellow
Base to Activator ratio	4:1 by volume
Weight per gallon	7.4 lbs.
% Solids by volume	10
Maximum Temperature resistance	130°F
Theoretical coverage per gallon*	160 mil sq. ft.
Dry film thickness per coat	.25-.33 mils
Wet film thickness per coat	2.5-3.3 mils
Drying time	1/2 hour
Shelf Life (unmixed components)	1 year
Flash Point ( T.O.C)	63°F
Pot Life ( after mixing)	8 hours

\*Note: actual coverage rate will vary depending upon material losses during mixing and application, and upon type and condition of surface to be coated. Allowance must be made for losses when estimating material requirements. See Bulletin 3110 "Calculating Coating Requirement" for additional information.

**Warranty** Dampney protective coating products are expressly warranted to meet applicable technical and quality specifications. The Technical data contained herein are accurate at the date of issuance but are subjected to change without prior notification. No warranty of current accuracy is hereby given or implied. User must contact Dampney to verify correctness before ordering. Dampney assumes no responsibility for coverage, performance or injuries resulting from handling or use and LIABILITY, IF ANY, SHALL BE LIMITED TO

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