



EX-2C Low VOC Topcoat (A.C.T. B)

Technical Data Sheet (TDS)

Product Description

Endura EX-2C Low VOC (with A.C.T. B) is a two component highly cross-linked, high performance polyester polyurethane coating providing a high gloss surface finish.

Product features:

- Extended clear coat window to 72 hours
- Faster tape time for multi-color jobs
- Must be Clear coated
- A library of over 40,000 colors
- **VOC Compliant**

Recommended Uses

Endura EX-2C Low VOC Topcoat (with ACT B) is intended for industrial applications; either new build or maintenance. EX-2C Low VOC Topcoat (with ACT B) is suitable for application on all Endura primers.

EX-2C Low VOC Topcoat (with ACT B) is designed specifically for use in multi color paint jobs requiring masking.

NOTE:

EX-2C Low VOC Topcoat(with ACT B) MUST BE Clear Coated

Industries:

- Oilfield & Energy Services
 - Well Service vehicles
 - Drilling
 - Tanks
- Cranes and Construction Equipment
- Waste and Recycling Industry
 - Garbage Trucks
- Trailers and Rolling Stock
- Marine (*above the water line*)

Mix Ratio

1 part by volume of component A [**CLRXXXXX**]
(Part Number varies with color)

1 part by volume of component B [**FUB2100**]

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

Please contact your sales representative if you have any questions.

Product Characteristics

Gloss: EX-2C Low VOC Topcoat (with ACT B) **MUST BE Clear Coated**

Note: Clear Endura Topcoats are available in many gloss levels

Volume Solids Mixed: Using Comp B FUB2100
42% +/- 4% (depending on color)

Pot Life: 8-10 Hours at 77°F (25°C) and 50% RH

Note: Pot life is reduced when Supercat II is used

VOC Mixed (Unreduced): (EPA Method 24):
White 120: Comp B FUB2100: 297 g/l (2.478 lb /gal)

Note: All colors are below 420 g/l (3.5 lb/gal)
VOC content will vary with each color and component B utilized.

Shelf Life:

Component A: 3 years at 77°F (25°C)

Component B: 2 years at 77°F (25°C)

Note: For unopened product



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Surface Prep

EX-2C Low VOC Topcoat (with ACT B) can be applied over all Endura primer sealers and primer surfacers without sanding during their topcoat window. The topcoat window varies with each primer. See the relevant primer technical data sheet for the specific topcoat window data.

If the primer topcoat window has been surpassed; the primer should be sanded with 240 – 280 grit sandpaper to achieve intercoat adhesion. All sanding dust must be blown off prior to application of the topcoat.

Application Method

EX-2C Low VOC Topcoat (with ACT B) can be applied using most spray painting systems.

Note: Assure that any solvent absorbent primer surfacers are properly sealed with a primer sealer prior to application of the topcoat.

Solid Colors:

Apply two single wet coats allowing up to 30 minutes flash time between coats.

It is recommended that a thinner first coat be applied 1.5 – 2.0 mils wet, followed by a wet coat of 2.0 - 3.5 mils wet. Allow up to 30 minutes between coats.

Metallic Colors:

Three coats are recommended for metallic colors. Apply two medium coats. Allow up to 30 minutes flash off time between coats then apply a third “mist coat” to achieve a uniform finish.

NOTE:

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Spray Gun Setup

Feed Type	Fluid Tip	Application Pressures (heel of gun)	Fluid Delivery
Siphon Feed	1.6-1.8 mm	40-50 psi	
Gravity Feed	1.3-1.4 mm	30-40 psi	
Pressure Feed	1.0-1.4 mm	55-65 psi	12-14 oz/min
Air Assist Airless	9-13 Thou	1,000-1,800 psi	
Airless	9-13 Thou	1,000-3,000 psi	

Spray Viscosity

14 Seconds	Reduce as necessary*
Conventional	Airless

Note: Spraying viscosity and thinning will depend on ambient conditions, spray equipment used, and the desired surface finish.

Note EX-2C Low VOC Topcoat (with ACT B) has a lower viscosity than the original EX-2C formulation. A spray test should be done prior to reducing.

EX-2C Low VOC Topcoat (with ACT B) typically does not require thinning.

To maintain VOC compliance, if required, thin EX-2C LVOC Topcoat with Endura Low VOC topcoat Thinners/Reducers. VOC content of the following Reducers: (0g/l, 0lbs/gal)

FTH0021 – Low VOC Topcoat Thinner/ Reducer

FTH0023 – Slow Low VOC Topcoat Thinner / Reducer

Film Build

Endura EX-2C Topcoat has a recommended film build thickness of:

Wet (unreduced): 3.5 – 5.5 mils

(90 – 137.5 microns)

Dry: 1.5 – 2.0 mils DFT (38 – 65 microns)

Note: With poor hiding colors film build may be higher

Theoretical coverage at 1.0 mil (25 microns)

Average DFT is: 675 ft² per gallon at 100% transfer efficiency.

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Dry Times

Masking and Dry time chart:

Using: 2 ounces Supercat II per mixed gallon

	68°F (20°C)	86°F (30°C)	104°F (40°C)
Tape Time	2.5 Hours	1.5 Hours	1 Hour
Clear Coat Window	72 Hours	72 Hours	72 Hours

Using: 4 ounces Supercat II per mixed gallon

	68°F (20°C)	86°F (30°C)	104°F (40°C)
Tape Time	90 mins	1 hour	45 mins
Clear Coat Window	72 Hours	72 Hours	72 Hours

Note: Prior to applying masking tape, check the prior coat to ensure paint is sufficiently dry to prevent masking lines.

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

Note: Using poly and vinyl masking tape may mark the surface and cause the risk of solvent popping. They are not recommended for use with ACT B.

A breathable masking tape or paper is recommended.

Important Note: Ensure that no more than three coats of paint are applied in a 12-hour shift. This includes primer, mid-coat, topcoats and clear coat.

If more than 3 coats have been applied wait 10-12 hours to allow for proper solvent evaporation.

For questions about scheduling please contact your Endura representative.

Clean Up

Clean all equipment immediately after use with Endura high strength gun wash, Endura epoxy reducer or Endura EX-2C thinner.

Follow manufacturer's safety recommendations when using any solvent.

Ordering Information (sizing)

Available in Pints, Quarts, Gallons, 5 Gallon Pails

Other custom sizes may be available.

1 Quart		
Comp A	CLRXXXXX-010	1 Pt.
Part numbers vary by color		
Comp B	FUB2100-010	1 Pt.

2 Quarts		
Comp A	CLRXXXXX-020	1 Qt.
Part numbers vary by color		
Comp B	FUB2100-020	1 Qt.

2 Gallons		
Comp A	CLRXXXXX-030	1 Gal.
Part numbers vary by color		
Comp B	FUB2100-030	1 Gal.



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10 gallons		
Comp A	CLRXXXXX-050	5 Gal
Part numbers vary by color		
Comp B	FUB2100-050	5Gal

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 (3°C) or more above the dew point at all times.

Note: For use outside this range please contact your Endura Representative.

Specifications

Hardness	ASTM D3363	N/A <i>Product must be cleared</i>
Solvent Resistance	ASTM D4752	N/A <i>Product must be cleared</i>
Abrasion resistance (1000 cycles CS-17)	ASTM D4060	N/A <i>Product must be cleared</i>
Impact resistance	ASTM D2794	40 in. lbs; NO failure
Flexibility	ASTM D522	1/8 mandrel bend: NO failure
Service Temp	-40°C to +182°C -40°F to 360°F	

Safety Precautions

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

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