

EX-2C Low VOC Topcoat with (A.C.T. B) Technical Data Sheet (TDS)

Product Description

EX-2C Low VOC Topcoat (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 up 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

EX-2C Low VOC Topcoat (with A.C.T. B) is intended for industrial applications, either new build or maintenance. It is designed specifically for use in multi color paint jobs requiring masking and is suitable for application on all Endura primers.

Industries:

- Oilfield & Energy Services
- Cranes and Construction Equipment
- Waste and Recycling Industry
- Trailers and Rolling Stock
- Marine (above the water line)

Product Characteristics

Gloss: Not Applicable	
EX-2C Low VOC Topcoat (with A.C.T. B) MUST be clear coated.	
Volume Solids Mixed: (Unreduced) FUA0120:FUB2100 (1:1)	43% ± 2%
Volume solids will vary by color	
Pot Life: (77°F (25°C) and 50% RH)	8-10 Hours
Pot life is reduced when Super Catalyst II is used	
VOC Mixed (Unreduced): EPA Method 24 FUA0120:FUB2100 (1:1)	289 g/l 2.414 lb /gal
All colors are below 420 g/l (3.5 lb/gal). VOC content will vary with each color and specific component B used.	
Shelf Life: For unopened product (77°F (25°C))	
Component A	3 years
Component B	2 years

Surface Preparation

EX-2C Low VOC Topcoat (with A.C.T. 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 inter-coat adhesion. All sanding dust must be blown off prior to application of the topcoat.

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).

Application Method

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

Ensure 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 at 1.5 -2.0 mils wet, followed by a second 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. Immediately following the second wet coat apply a third “mist coat” to achieve a uniform finish.

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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	1.3-1.8 mm	30-40 psi	
Pressure Feed	1.0-1.4 mm	50-60 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	

Suggested Viscosity Ranges Ford 4 Viscosity Cup at 68°F (20°C)	
Airless	16 - 18 secs
Air Assist Airless	14 - 17 secs
Conventional	14 – 16 secs

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

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

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Recommended spraying viscosity is achieved by reducing with one of the following Endura Low VOC Topcoat reducers up to 25% by volume.

The following reducers will maintain VOC compliance.

FTH0021 – Low VOC Topcoat Thinner/ Reducer
FTH0023 – Slow Low VOC Topcoat Thinner / Reducer

Film Build

EX-2C LVOC Topcoat (with A.C.T. B) recommended film thickness:

Wet: WFT Unreduced	3.5 – 6.0 mils	89 – 152 microns
Dry: DFT	1.5 – 2.5 mils	38 – 63 microns

Poor hiding colors film build may be higher.

Theoretical coverage at 1.0 mil (25 microns). Average DFT is: 689 ft² per gallon at 100% transfer efficiency.

Dry Times

Masking and Dry time charts:

Using: 2 ounces Super Catalyst 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 Super Catalyst II per mixed gallon			
	68°F(20°C)	86°F(30°C)	104°F(40°C)
Tape Time	1.5 Hour	1 Hour	45 Minutes
Clear Coat Window	72 Hours	72 Hours	72 Hours

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

Prior to applying masking tape, check the previous coat to ensure paint is sufficiently dry to prevent masking lines. Using poly and vinyl masking tape may mark the surface and increase the risk of solvent popping. They are not recommended for use with A.C.T. B. A breathable masking tape or paper is recommended.

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 three 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, or Endura EX-2C thinner.

Follow manufacturer's safety recommendations when using any solvent.

Ordering Information (sizing)

Component A part numbers vary by color

EX-2C LVOC (with A.C.T. B)		1 mixed quart (946ml)
Comp A	CLRXXXXX-010	1 pint (473ml)
Comp B	FUB2100-010	1 pint (473ml)

EX-2C LVOC (with A.C.T. B)		2 mixed quarts (1.89l)
Comp A	CLRXXXXX-020	1 quart (946 ml)
Comp B	FUB2100-020	1 quart (946 ml)

EX-2C LVOC (with A.C.T. B)		2 mixed gallons (7.56l)
Comp A	CLRXXXXX-030	1 gallon (3.78l)
Comp B	FUB2100-030	1 gallon (3.78l)

EX-2C LVOC (with A.C.T. B)		10 mixed gallons (37.8l)
Comp A	CLRXXXXX-050	5 gallons (18.9l)
Comp B	FUB2100-050	5 gallons (18.9l)

Other custom sizes may be available.

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.

For use outside this range please contact your Endura Representative.

Specifications

Hardness	ASTM D3363	N/A - Product must be cleared
Solvent Resistance	ASTM D4752	N/A - Product must be cleared
Abrasion Resistance (1000 cycles CS-17)	ASTM D4060	N/A - Product must be cleared
Impact Resistance	ASTM D2794	100 in. lbs; NO failure
Flexibility	ASTM D522	1/8 mandrel bend: NO failure
Service Temp	-40°F to 360°F	-40°C to 182°C

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.