

## EX-2C TF2K Topcoat

### Technical Data Sheet (TDS)

#### Product Description

**EX-2C TF2K Topcoat** is a two component highly cross-linked, high performance polyester polyurethane coating providing a medium gloss surface finish. EX-2C TF2K Topcoat is formulated with enhanced abrasion resistance.

#### Product features:

- Provides a non-stick surface
- Outstanding resistance to abrasion
- Excellent resistance to jet fuel and kerosene
- Available in solid, metallic and pearl colors
- A library of over 40,000 colors

#### Recommended Uses

EX-2C TF2K Topcoat is intended for industrial applications; either new build or maintenance. EX-2C TF2K Topcoat is suitable for application on all Endura primers.

This coating provides a non-stick surface ideal for tankers, bulkers and hoppers.

Transport industry use should be limited to specific problem areas requiring abrasion and impact protection.

EX-2C TF2K Topcoat **CANNOT** be recoated even after sanding. Complete removal is required.

**EX-2C TF2K is NOT available in a High Gloss Finish.**

#### Mix Ratio

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

1 part by volume of component B [**FUB0100**]

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

#### Product Characteristics

|  |                            |
|--|----------------------------|
| <b>Gloss:</b>  | Medium:<br>40-50 GU at 60° |
| <b>Volume Solids Mixed: (Unreduced)<br/>CLR18245:FUB0100 (1:1)</b>       | 47% ± 4%                   |
| <b>Volume solids will vary by color</b>                                  |                            |
| <b>Pot Life:</b><br>(77°F (25°C) and 50% RH)                             | 8-10 Hours                 |
| <b>Note: Pot life is reduced when Super Catalyst II is used</b>          |                            |
| <b>VOC Mixed (Unreduced):</b><br>EPA Method 24<br>CLR18245:FUB0100 (1:1) | 429 g/l<br>3.580 lb /gal   |
| <b>VOC content will vary with specific Component B used</b>              |                            |
| <b>Shelf Life:</b>   |                            |
| <b>Component A</b>   | 3 years                    |
| <b>Component B</b>   | 2 years                    |
| <b>For unopened product (77°F (25°C))</b>                                |                            |

#### Surface Preparation

EX-2C TF2K Topcoat 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.

EX-2C TF2K Topcoat may be applied directly over an existing EX-2C Topcoat or EX-2C Clear 100 after thorough cleaning and sanding with 240 – 280 grit sandpaper.

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#### Application Method

EX-2C TF2K Topcoat can be applied using most spray painting systems. For electrostatic spray equipment, EX-2C Electrostatic component B component is recommended for best performance.

**Note: 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:

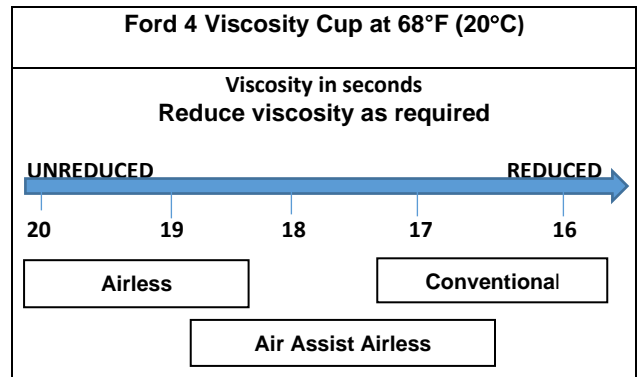
Three coats are recommended for metallic colors. Apply two medium coats. Allow up to 30 minutes flash off time between coats. Immediately following the second wet coat apply a third “mist coat” to achieve a uniform finish.

Contact your Endura Representative regarding recoating T2FK after a full cure.

#### 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  | 50-60 psi                           | 10-14 oz/min   |
| Air Assist Airless | 9 -13 Thou  | 1,000-1,800 psi                     |                |
| Airless            | 11 -13 Thou | 1,700-3,000 psi                     |                |

#### Spray Viscosity



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

If required, recommended spraying viscosity can be achieved by reducing with Endura EX-2C Thinner/Reducer.

FTH0086 – EX-2C Thinner/ Reducer  
FTH0090 – Slo EX-2C Thinner/Reducer  
FTH0014 – Medium Topcoat Reducer

#### Film Build

EX-2C TF2K Topcoat has a recommended film build thickness of:

|                  |                       |                         |
|------------------|-----------------------|-------------------------|
| <b>Wet: WFT</b>  | <b>3.5 – 5.5 mils</b> | <b>89 – 140 microns</b> |
| <b>Unreduced</b> |                       |                         |
| <b>Dry: DFT</b>  | <b>1.5 – 2.5 mils</b> | <b>38 – 63 microns</b>  |

**Poor hiding colors film build may be higher.**

Theoretical coverage at 1.0 mil (25 microns)  
Average DFT: 750 ft<sup>2</sup> per gallon at 100% transfer efficiency.

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#### Dry Times

|                  | 68°F<br>(20°C) | 86°F<br>(30°C) | 104°F<br>(40°C) |
|------------------|----------------|----------------|-----------------|
| <b>Dust Free</b> | 2 Hours        | 1 Hour         | 30 Minutes      |
| <b>Full Cure</b> | 7-14 Days      | 5-6 Days       | 3-4 Days        |

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

**The use of Super Catalyst II with Endura topcoats will accelerate drying times.**

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)

Available in Pints, Quarts, Gallons and Pails  
Other custom sizes may be available.

| 1 Mixed Quart                        |              |       |
|--------------------------------------|--------------|-------|
| Comp A<br>Part numbers vary by color | CLRXXXXX-010 | 1 Pt. |
| Comp B                               | FUB0100-010  | 1 Pt. |

| 2 Mixed Quarts                       |              |       |
|--------------------------------------|--------------|-------|
| Comp A<br>Part numbers vary by color | CLRXXXXX-020 | 1 Qt. |
| Comp B                               | FUB0100-020  | 1 Qt. |

| 2 Mixed Gallons                      |              |        |
|--------------------------------------|--------------|--------|
| Comp A<br>Part numbers vary by color | CLRXXXXX-030 | 1 Gal. |
| Comp B                               | FUB0100-030  | 1 Gal. |

| 10 Mixed Gallons                     |              |        |
|--------------------------------------|--------------|--------|
| Comp A<br>Part numbers vary by color | CLRXXXXX-050 | 5 Gal. |
| Comp B                               | FUB0100-050  | 5 Gal. |

#### 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    | 3H                           |
| Solvent Resistance                         | ASTM D4752    | 100 MEK Rubs;<br>No Failure  |
| Abrasion Resistance<br>(1000 cycles CS-17) | ASTM D4060    | 20 mg loss                   |
| Impact Resistance                          | ASTM D2794    | 100 in. lbs; NO failure      |
| Flexibility                                | ASTM D522     | 1/8 mandrel bend: NO failure |
| Service Temp                               | -40°F à 360°F | -40°C à 182°C                |

#### Safety Precautions

Please refer to all Safety Data Sheets (SDS) before using this product. SDS sheets can be found on our website [www.endurapaint.com](http://www.endurapaint.com).