



Intermix 3:1 Low VOC Primer

Technical Data Sheet (TDS)

Product Description

Endura Intermix 3:1 Low VOC Primer is a medium solids, medium build, two-component, epoxy primer providing excellent adhesion, hardness and corrosion resistance.

Product features:

- Ability to fill a sandblast profile in one coat
- No induction time required
- Can be topcoated in 1 hour
- 7 day topcoat window
- Available in grey and black
- VOC Compliant

Recommended Uses

Endura Intermix 3:1 Low VOC Primer is intended for industrial applications; either new build or maintenance. Intermix 3:1 Low VOC Primer is suitable for application on steel, aluminum and fiberglass substrates. This primer must be topcoated to achieve the best results.

Intermix 3:1 Low VOC Primer is not recommended in thin films as a sealer.

Mix Ratio

3 parts by volume of component A
[Part Number varies with color]
1 part by volume of component B [FEB0065]

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

Product Characteristics

Finish: Low Gloss

Volume Solids Mixed: 50% +/- 2% (varies with color).

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

VOC Mixed (Unreduced)(EPA Method 24):
Grey: 248 g/l (2.07lbs/gallon)

Note: All colors are below 250g/l. VOC levels will vary per color.

Shelf Life:

Component A: 3 years at 77°F (25°C)

Component B: 2 years at 77°F (25°C)

Note: For unopened product.

Surface Prep

Surface must be free of all contaminants such as dust, oil, grease and salt. It is recommended that all steel and other ferrous surfaces be sandblasted a minimum of SSPC- SP6 or mechanically sanded with 80 grit sand paper.

All other substrates refer to the Endura recommended surface preparation instruction sheets or contact your Endura representative.

Application Method

Intermix 3:1 Low VOC Epoxy Primer can be applied using most spray painting systems.

Apply 1-2 coats as required to achieve the desired film thickness. Allow sufficient flash time between coats especially with higher film builds applied (20-30mins).



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Spray Gun Setup

Feed Type	Fluid Tip	Application Pressures (heel of gun)	Fluid Delivery
Siphon Feed	1.6-2.0 mm	40-50 psi	
Gravity Feed	1.6-2.0 mm	30-40 psi	
Pressure Feed	1.4-2.0 mm	50-60 psi	12-16 oz/min
Air Assist Airless	9-17 Thou	1,000-1,800 psi	
Airless	11-15 Thou	1,700-3,000 psi	

Spray Viscosity

Using a Ford 4 Cup (White)

22-23 Seconds*	Reduce as necessary*
Conventional	Airless

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

To maintain VOC compliance, thin Intermix 3:1 Low VOC with Endura Low VOC Epoxy Reducers.
VOC content of the following Reducers: (0g/l, 0lbs/gal)

[FTH0016] Low VOC Epoxy Reducer – Regular
[FTH0027] Low VOC Epoxy Reducer - Slow

Film Build

Intermix 3:1 Low VOC Primer has a recommended film build thickness of:

**Wet (unreduced): 6.0 – 10.0 mils wet
(152 – 254 microns)**

Dry: 3.0 – 5.0 mils dry (76 – 127 microns)

Note: The recommended dry film thickness is above the blast/ sanding profile.

Theoretical coverage at 1.0 mil (25 microns).
DFT: 800 ft² per gallon at 100% transfer efficiency.

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Dry Times

	68°F (20°C)	86°F (30°C)	104°F (40°C)
Topcoat	1 Hour	55 Minutes	45 Minutes
Full Cure	7-9 Days	5-6 Days	3-4 Days

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

For best results surface temperature must be 86°F (30°C) or less before topcoating.
Maximum re-coat window without sanding is 7 days at 68°F (20°C)
Recommended 180 – 220 grit mechanical sanding before topcoating.

Note: Intermix 3:1 Low VOC Primer is difficult to sand. If extensive sanding is required we recommend EP Sandable Low VOC Primer.

Note: If the primer is allowed to sit for an extended period without being topcoated; The surface must be kept clean of contaminants to avoid any topcoat issues.

For improved scheduling please contact your Endura representative.

Topcoating Information

Intermix 3:1 Low VOC Primer can be topcoated with the entire range of Endura topcoat products.

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.



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Ordering Information (sizing)

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

1 Gallon Kits:		
Comp A - Grey	FEA0065-033	3 Qt
Comp A - Black	FEA0651-033	3 Qt
Comp B	FEB0065-020	1 Qt

4 Gallon Kits:		
Comp A	FEA0065-053	3 Gal
Comp A	FEA0651-053	3 Gal
Comp B	FEB0065-030	1 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.

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

Specifications

Solvent Resistance	ASTM D4752	50 MEK Rubs; NO Failure
Impact Resistance	ASTM D2794	40 in. lbs; NO Failure
Flexibility	ASTM D522	3/8 mandrel bend: NO Failure
Service Temp Range	40°C to + 121°C	-40°F to 250°F