



## Intermix 3:1 Low VOC Primer

### Technical Data Sheet (TDS)

#### Product Description

**Intermix 3:1 Low VOC Primer** is a medium solid, 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

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.**

#### Industries:

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

#### Mix Ratio

3 parts by volume of component A **[FEAXXXX]**  
(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

<b>Finish:</b>	Lo Gloss
<b>Volume Solids Mixed: (Unreduced)</b> <b>FEA0065: FEB0065 (3:1)</b>	50% ± 2%
<b>Volume solids will vary by color</b>	
<b>Pot Life:</b> (77°F (25°C) and 50% RH)	10 Hours
<b>VOC Mixed (Unreduced):</b> EPA Method 24 <b>FEA0065:FEB0065 (3:1)</b>	248 g/l 2.07 lb /gal
<b>VOC content will vary with each color</b> <b>Note: All colors are below 250g/l.</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

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.

For 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 (20-30 minutes).



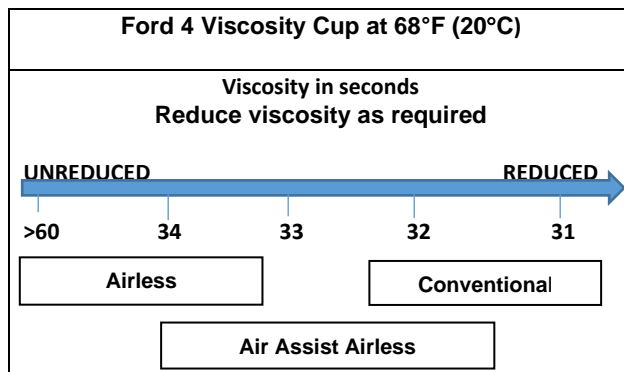
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#### Spray Gun Setup

Feed Type	Fluid Tip	Application Pressures (heel of gun)	Fluid Delivery
Siphon Feed	1.6-1.8 mm	40-50 psi	
Gravity Feed	1.6-1.8 mm	30-40 psi	
Pressure Feed	1.4-1.8 mm	50-60 psi	10-14 oz/min
Air Assist Airless	9-15 Thou	1,000-1,800 psi	
Airless	9-13 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 is achieved by reducing with one of the following Endura Low VOC Epoxy reducers. These will maintain VOC compliance of Intermix 3:1 Low VOC Primer.

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:

<b>Wet: WFT Unreduced</b>	<b>6.0 – 10.0 mils</b>	<b>152 – 254 microns</b>
<b>Dry: DFT</b>	<b>3.0 – 5.0 mils</b>	<b>76 – 127 microns</b>

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

Theoretical coverage at 1.0 mil (25 microns).  
DFT: 800 ft<sup>2</sup> per gallon at 100% transfer efficiency.

#### Dry Times

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

**Note: Dry Times are subject to ambient conditions (temperature and humidity), 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.

**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.



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#### 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.

#### Ordering Information (sizing)

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

1 Mixed Gallon		
Comp A - Grey	FEA0065-033	3 Qts.
Comp A - Black	FEA0651-033	3 Qts.
Comp B	FEB0065-020	1 Qt.

4 Mixed Gallons:		
Comp A	FEA0065-053	3 Gals.
Comp A	FEA0651-053	3 Gals.
Comp B	FEB0065-030	1 Gal.

#### Environmental Conditions

For optimum coating performance, the 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

Solvent Resistance	ASTM D4752	100 MEK Rubs; NO Failure
Impact resistance	ASTM D2794	30 in. lbs; NO Failure
Flexibility	ASTM D522	1/4 in. mandrel bend: NO failure
Service Temp Range	-40°F to 250°F	-40°C to 121°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](http://www.endurapaint.com).