



Intermix 4:1 Low VOC Primer

Technical Data Sheet (TDS)

Product Description

Intermix 4:1 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
- VOC Compliant

Recommended Uses

Intermix 4:1 Low VOC Primer is intended for industrial applications; either new build or maintenance. Intermix 4:1 Low VOC Primer is suitable for application on steel, aluminum and fiberglass substrates. This primer must be topcoated to achieve the best results.

Intermix 4:1 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

Mix Ratio

4 parts by volume of component A **[FEA0065]**
1 part by volume of component B **[FEB0650]**

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

Product Characteristics

Finish:	Lo Gloss
Volume Solids Mixed: (Unreduced) FEA0065: FEB0650 (4:1)	53% ± 2%
Volume solids will vary by color	
Pot Life: (77°F (25°C) and 50% RH)	10 Hours
VOC Mixed (Unreduced): EPA Method 24 FEA0065:FEB0650 (4:1)	248 g/l 2.07 lb /gal
VOC content will vary with each color	
Shelf Life:	
Component A	3 years
Component B	2 years
For unopened product (77°F (25°C))	

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 4:1 Low VOC 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).

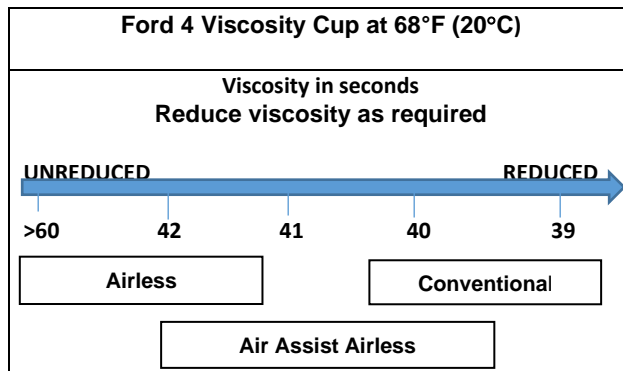
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Spray Gun Setup

Feed Type	Fluid Tip	Application Pressures (heel of gun)	Fluid Delivery
Siphon Feed	1.6-1.8 mm	40-50 psi	
Gravity Feed	1.6-2.0 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



Note: Spraying viscosity and thinning will depend on ambient conditions, spray equipment used, and on 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 4:1 Low VOC Primer.

VOC content of the following Reducers: (0g/l, 0 lbs/gal)

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

Film Build

Intermix 4:1 Low VOC Primer has a recommended film build thickness of:

Wet: WFT Unreduced	5.5 – 9.0 mils	140 – 229 microns
Dry: DFT	3.0 – 5.0 mils	76 – 127 microns

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

Theoretical coverage at 1.0 mil (25 microns)
DFT: 856 ft² per gallon at 100% transfer efficiency.

Dry Times

	68°F (20°C)	86°F (30°C)	104°F (40°C)
Topcoat	1-2 Hours	1 Hour	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.

Intermix 4:1 Low VOC Primer is difficult to sand. If extensive sanding is required, EP Sandable Low VOC Primer is recommended.

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 4:1 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 Gallon and Pail kits.
Other custom sizes may be available.

1 ¹ / ₄ mixed gallons (4.73l)		
Comp A - Grey	FEA0065-030	1 gallon (3.78l)
Comp B	FEB0650-020	1 quart (946ml)

3 ³ / ₄ mixed gallons (14.18l)		
Comp A - Grey	FEA0065-053	3 gallons (11.34l)
Comp B	FEB0650-033	3 quarts (2.84l)

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 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.