



EX-2C Low VOC (ACT B)

Technical Data Sheet (TDS)

Product Description

Endura EX-2C Low VOC (with ACT B) is a two component topcoat designed for multi-color paint jobs requiring accelerated dry times for masking and an extended window for clear coating.

Endura EX-2C Low VOC (with ACT B) MUST be cleared

Product features:

- Extended cure time
 - Increases clear coat window to 72 hours
- Faster tape time for multi color jobs
 - **SuperCat II must be used to speed tape time** (Please see SuperCat II Chart)
- **VOC Compliant**

Recommended Uses

Endura EX-2C Low VOC Topcoat (with ACT B) is a high performance coating designed specifically for use in multi color paint jobs requiring masking.

Industries:

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

Mix Ratio

1 part by volume of component A [*varies by color*]
1 part by volume of component B [FUB0112]

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

**Please note that other EX-2C B components are available (for different ambient conditions and application requirements) please contact your representative if you have any questions.*

Product Characteristics

Finish: Product must be cleared
(*Clear is available in many gloss levels*)

Volume Solids: 43 ± 4% (depending on color)

Pot Life: 8-10 Hours* @ 77°F (25°C) and 50% RH

VOC (EPA Method 24): All colors < 420 gram/liter (3.5 lbs/gallon)

Shelf Life**:

Component A: 3 years

Component B: 2 years

**Less when Endura Super Catalyst II is used*

***For unopened product*

Surface Prep

Can be directly applied to most surfaces that have been: degreased, sanded with 280 – 320 grit sandpaper and prepared with appropriate Endura products.

The primed surface should be dry and free from all contaminants, please see the relevant primer technical data sheet. (for topcoat windows)

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	55-65 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	



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Spray Viscosity*

Product typically does not require thinning

*Spraying viscosity and thinning will depend on ambient conditions, spray equipment used, and on the desired surface finish. Endura EX-2C Low VOC has a lower viscosity than the original EX-2C formulation. A spray test should be done prior to reducing EX-2C Low VOC.

If required, recommended spraying viscosity is achieved by reducing with Endura Low VOC topcoat reducers:

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

Application Method

Solid Colors: Apply two single wet coats, heavier first coat followed up by a lighter second coat with 30 minutes between coats. On high solids primers and other absorbent solvent substrates, use greater care in achieving the required film build thickness.

Metallic Colors: Three coats are recommended for metallic colors. 1. Apply two medium coats. 2. Allow 30 minutes between coats then apply a third “mist coat” to achieve a uniform finish. A high-hide version of any metallic color can be used.

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Film Build

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

Wet (unreduced): 3.5 – 5.5 mils (90 – 137.5 microns)

Dry: 1.5 – 2.0 mils DFT (38 – 65 microns)

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

Dry Times*

Masking and dry times chart (with SuperCat II)
@ 20-25°C (68-77°F)

****Based on a mixed gallon of EX-2C****

	2 oz SuperCat II	**4 oz** SuperCat II
Tape Time	2.5 hours*	90 minutes*

*It is important to check substrate prior to applying masking tape. To ensure paint is sufficiently dry to prevent masking lines.
(Mil thickness and environmental conditions can affect tape times.)

Clear Coat window (with SuperCat II)
@ 20-25°C (68-77°F) is **72 hours***

Using poly and vinyl masking tape may mark the surface and cause the risk of solvent popping...they are not recommended for use with ACT B. It is recommended that a breathable masking tape or paper be used.

*Subject to ambient conditions (temperature and humidity) and good airflow.

**Please ensure that no more than three coats of paint are applied in a given 12-hour shift (including primer, mid-coat, topcoats and clear coat). If more than 3 coats have been applied, please wait 10-12 hours to allow for proper solvent evaporation.

Clean Up

Clean up spills, and equipment 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 Pint, Quart, Gallon and Pail kits.

Other custom sizes may be available.

Pint Kit	Comp A	CLR****-010 (1 Pint) [part# varies by color]
	Comp B	FUB2100-010 (1 Pint)
Quart Kit	Comp A	CLR****-020 (1 Quart) [part# varies by color]
	Comp B	FUB2100-020 (1 Quart)
Gallon Kit	Comp A	CLR****-030 (1 Gallon) [part# varies by color]
	Comp B	FUB2100-030 (1 Gallon)
Pail Kit	Comp A	CLR****-050 (1 Pail) [part# varies by color]
	Comp B	FUB2100-050 (1 Pail)

Environmental Conditions

For optimum coating performance product, substrate and ambient temperature should be between 20°C-25°C* (68°F-77°F). To prevent condensation during application the surface temperature must be 3°C (5°F) 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 <i>Product must be cleared</i>
Solvent Resistance	ASTM D4752	N/A <i>Product must be cleared</i>
Abrasion resistance (1000 cycles CS-17)	ASTM D4060	N/A <i>Product must be cleared</i>
Impact resistance	ASTM D2794	40 in. lbs; NO failure
Flexibility	ASTM D522	1/8 mandrel bend: NO failure
Service Temp	-40°C to +182°C -40°F to 360°F	

Safety Precautions

Please refer to all Safety Data Sheets (SDS) before using this product. SDS sheets can be found on our website at www.endura.ca.