



EX-2C Low VOC Colour Coat

Endura EX-2C Low VOC Topcoat is a two component highly cross-linked, high performance polyurethane coating, providing high gloss, color retention and outstanding resistance to chemicals, abrasion, and impacts, provide maximum protection and an impressive surface finish.

Product Features

- ◆ High gloss and color retention
- ◆ Outstanding resistance to chemicals, abrasion & impact
- ◆ A library of over 40,000 colors
- ◆ Color matching service available
- ◆ Available in: High and reduced gloss, Pearl, Metallic and Candied
- ◆ **VOC Compliant**

Theoretical Solids Content:

Volume: 45 ± 2.5%
(Depending on colour)

Shelf Life*

Component A: (3) years
Component B: (1) year

*For unopened product.

Pot Life of Mixed Product:

8-10 Hours* @ 77°F
(25°C) and 50% RH

* Less when Endura Super Catalyst II is used.



Suitability

Endura EX-2C Low VOC Topcoat is a high performance coating for protecting all surfaces. It provides maximum protection in all environments.

All Endura EX-2C Low VOC colours are formulated to meet or exceed the Canadian automotive refinishing guidelines for VOC levels in colour coats.



Surface Preparation

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



Mixing Ratio

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

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

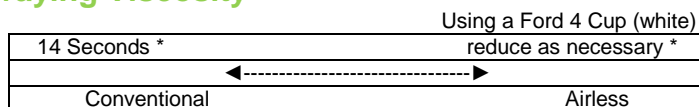
Environmental Conditions

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.



Spraying Viscosity*



*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.

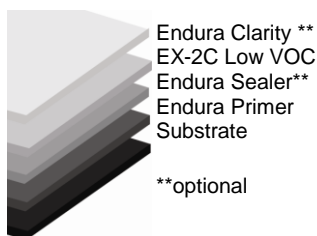
If required, recommended spraying viscosity is achieved by reducing with Endura Low VOC topcoat reducers:

- Max 10% with FTH0021 – Low VOC Topcoat Reducer- Regular
- Max 10% with FTH0023 – Slow Low VOC Topcoat Reducer- Slow



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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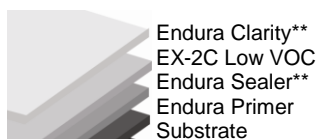
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Endura Clarity**
EX-2C Low VOC
Endura Sealer**
Endura Primer
Substrate

**optional

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 and third "mist coat" to achieve a uniform finish. A high-hide version of any metallic color can be used, and then clear coated for superior gloss retention and UV stability.

*Refer to the Super Catalyst II Data Sheet.

Recommended Film Build Thickness and Cover Rate

Endura EX-2C Low VOC has a recommended film thickness of:

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

Dry: 1.5 - 2.5 mils (38 - 65 microns) dry

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

Drying Time*

* Please note that the use of Super Catalyst II with Endura topcoats will accelerate drying times.

	20°C (68°F)	30°C (86°F)	40°C (104°F)
Dust Free	2 Hours	1 Hour	30 Minutes
Full Cure	7-14 Days		

* Subject to ambient conditions (temperature and humidity) film build and good airflow. For improved scheduling please contact your Endura representative.

Specifications

Hardness	ASTM D3363	2H
Solvent resistance	ASTM D4752	100 MEK rubs; NO Failure
Abrasion resistance (1000 cycles CS-17)	ASTM D4060	32 mg loss
Impact resistance	ASTM D2794	40 in. lbs: NO failure
service temperature range**	-40° C to +182° C	-40°F to 360°F
Flexibility	ASTM D522	1/8" mandrel bend; NO failure
VOC	All colours < 420 grams/liter (3.5 lbs/gallon)	

Clean Up

Endura high strength gun wash, Endura epoxy reducer or Endura EX-2C thinner.