



# Intermix 3:1 Low VOC Primer

Endura Intermix Epoxy Primer 3:1 Low VOC is a medium solids, medium build, two-component primer providing excellent adhesion, hardness, and corrosion resistance over a wide range of surfaces. It is specially formulated to fill a sandblast profile in one coat.

### Product Features

- ◆ Formulated to fill a sandblast profile in one coat
- ◆ No induction time required
- ◆ Can be topcoated in 1 hour
- ◆ Available in grey
- ◆ **VOC Compliant**

### Theoretical Solids Content:

Volume: 50%

### Shelf Life\*

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

\*For unopened product.

### Pot Life of Mixed Product:

10 Hours @ 77°F (25°C) and 50% RH



### Suitability

Endura Intermix 3:1 Low VOC Epoxy Primer provides excellent adhesion, hardness, and corrosion resistance to many types of substrates. It features a prolonged pot life and a topcoat window without sanding. This primer must be topcoated to achieve best results. *This product is not recommended in thin films as a sealer.*

**Endura Intermix 3:1 Low VOC is formulated to exceed the Canadian Automotive refinishing guidelines for VOC levels in primers.**



### Surface Preparation

Surfaces 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 or mechanically sanded with 80 grit sandpaper.

Aluminum surfaces should be etched with Endura Aluminum Cleaner and treated with Endura Aluminum Conversion Coating. Satin coat\* or galvanized surfaces (sanded or not) must be pre-treated with Metal Prep and GalvaPrep.

\*Sanding satin coated metal can cause adhesion problems.



### Mixing Ratio

3 parts by volume of component A [FEA0065] Grey  
1 part by volume of component B [FEB0065]

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\*

Using a Ford 4 Cup (white)	
22- 23 Seconds *	reduce as necessary *
Conventional	Airless

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

To maintain VOC compliance thin Intermix 3:1 Low VOC with Endura Low VOC Epoxy Reducers.

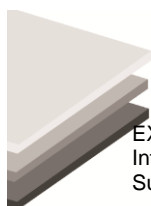
[FTH0016] Low VOC Epoxy Reducer- Regular (VOC = 0 g/L, 0 lbs/gal)

[FTH0027] Low VOC Epoxy Reducer- Slow (VOC = 0 g/L, 0 lbs/gal)



### 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	13-15 Thou	1,700-3,000 psi	



EX-2C Low VOC  
Intermix 3:1 Low VOC  
Substrate



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### Application Method

Endura Intermix 3:1 Low VOC Epoxy Primer can be applied using most spray painting systems. Under normal conditions, it can be top coated in 1 hour - 14 days. After 14 days, primer must be scuff sanded.

### Recommended Film Build Thickness and Cover Rate

Endura Intermix 3:1 Low VOC Epoxy Primer has a recommended film thickness of:  
Wet (unreduced): 5.0 – 7.0 mils wet (125 – 175 microns)  
**Dry: 2.5 - 3.5 mils dry (62.5 – 87.5 microns)**

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



### Drying Time\*

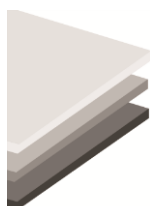
After 14 days, this primer must be scuff sanded.

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

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

### Specifications

Solvent resistance	ASTM D4752	50 MEK rubs; NO failure
Impact resistance	ASTM D2794	40 in. lbs; NO failure
service temperature range**	40°C to +121°C	-40°F to 250°F
Flexibility	ASTM D522	3/8 mandrel bend: NO failure
<b>VOC</b>	<b>243.0 grams/liter (2.02 lbs/gallon)</b>	



EX-2C Low VOC  
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### Clean Up

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