

EX-2C

Endura EX-2C Topcoat is a two component highly cross-linked, high performance polyester polyurethane coating for protecting a wide range of surfaces. 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

Theoretical Solids Content:

Volume: 43 ± 4%
(depending on color)

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 Topcoat is a high performance coating for protecting all surfaces. It provides maximum protection in all environments.



Surface Preparation

Can be directly applied to most surfaces that have been: degreased, sanded with 240 - 280 grit sandpaper, and prepared with appropriate Endura products.



Mixing Ratio

1 parts by volume of component A [part# varies by color]
1 part by volume of component B [FUB0100]

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.*

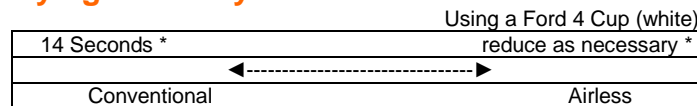
Environmental Conditions

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*

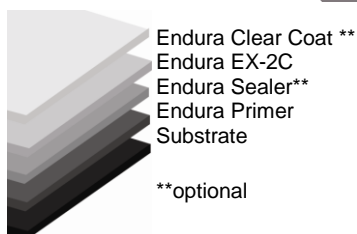


* Spraying viscosity and thinning will depend on ambient conditions, spray equipment used, and on the desired surface finish. If required, recommended spraying viscosity is achieved by reducing with Endura Ex-2C thinners.



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 | 1.0-1.8 mm | 50-60 psi | 10-14 oz/min |
| Air Assist Airless | 9-13 Thou | 1,000-1,800 psi | |
| Airless | 11-13 Thou | 1,700-3,000 psi | |



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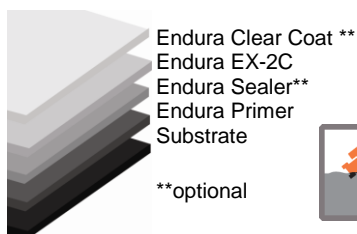
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Application Method

Solid Colors: Apply two single wet coats with 30 minutes between coats. On high solids primers and other absorbent solvent substrates, use greater care in achieving the required film build thickness. It is recommended that a thinner first layer be applied at 1.0-1.5 mils. Allow 30-45 minutes between coats

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.

Recommended Film Build Thickness and Cover Rate

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

Wet (unreduced): 3.5 – 5.5 mils wet (87.5 – 137.5 microns)
Dry: 1.5 - 2.5 mils dry (37.5 – 62.5 microns)

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

Drying Time*

Recoats or clear coating may be applied after 4** hours for solid colors and 6** hours for metallic colors (based on 70F and 50% RH).

After 18 hours EX-2C topcoat must be sanded to achieve intercoat adhesion.

* 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 | 7-9 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.

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

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 |
| Flexibility | ASTM D522 | 1/8" mandrel bend; NO failure |
| service temperature range** | -40° C to +182° C | -40°F to 360°F |
| VOC | For VOC amounts please refer to the product MSDS | |

** some colors may discolor at the upper temperature range.

Clean Up

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