

DuraCoat Clear

Technical Data Sheet (TDS)

Product Description

DuraCoat Clear is a two-component, epoxy modified polyurethane topcoat. DuraCoat Clear is designed to provide extra protection against harsh chemical environments and provides extra protection against acids and acid rain.

Product features:

- High gloss
- Excellent protection against hydrochloric acid
- Excellent chemical resistance
- Excellent abrasion resistance
- Excellent impact resistance
- Excellent ultraviolet light protection

Recommended Uses

DuraCoat Clear is intended for industrial applications, either new build or maintenance. DuraCoat Clear is suitable for protecting most coated surfaces including clear and solid colors.

Industries:

- Oilfield & Energy Services
 - Well Service Vehicles
 - Drilling
 - Tanks
- Cranes and Construction Equipment
- Chemical plants
- Waste and Recycling Industry
 - Garbage Trucks
- Trailers and Rolling Stock

Mix Ratio

2 parts by volume of component A [**FUA0207**]
1 parts by volume of component B [**FUB0083**]

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

Product Characteristics

Gloss:	High: 90+ GU at 60°
Volume Solids Mixed: (Unreduced) FUA0207:FUB0083 (2:1)	50% ± 1%
Pot Life: (77°F (25°C) and 50% RH)	3 - 6 Hours
Note: Pot life is reduced when Super Catalyst II is used	
VOC Mixed (Unreduced): EPA Method 24 FUA0207:FUB0083 (2:1)	421.4 g/l 3.517 lb /gal
Shelf Life:	
Component A	3 years
Component B	2 years
For unopened product (77°F (25°C))	

Surface Preparation

DuraCoat Clear can be applied on EX-2C Topcoat colors without sanding during their topcoat window. Ensure that surfaces to be clear coated are free of flaws, surface contaminants and other surface imperfections.

If the EX-2C Topcoat has been allowed to cure longer than 24 hours, sanding will be required to achieve inter-coat adhesion. Sand the topcoat lightly with 400 grit sandpaper or Maroon Scuff Pads.

Application Method

DuraCoat Clear can be applied using most spray painting systems.

After application of EX-2C Topcoat wait for the following times before application of DuraCoat Clear:

Solid Colors	Metallic Colors
3-18 Hours	6-18 hours

Apply two wet coats of DuraCoat Clear allowing up to 30 minutes between coats.

DuraCoat Clear

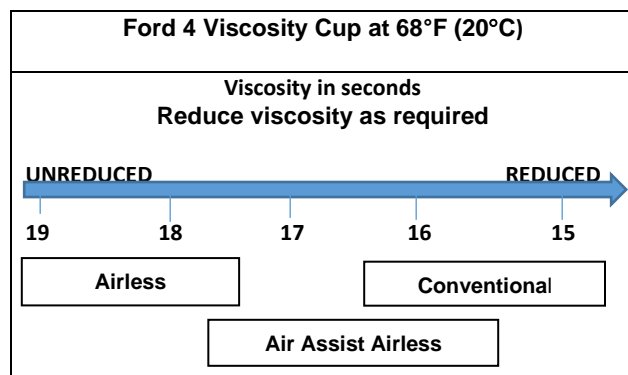
Technical Data Sheet (TDS)

The use of Super Catalyst II with Endura topcoats will accelerate drying times.

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	9-13 Thou	1,700-3,000 psi	

Spray Viscosity



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

If required, recommended spraying viscosity is achieved by reducing with one of the desired Endura topcoat thinner/ reducer.

FTH0086 – EX-2C Thinner / Reducer
FTH0090 – Slo EX-2C Thinner /Reducer
FTH0014 – Medium Topcoat Reducer

Film Build

DuraCoat Clear has a recommended film build thickness of:

Wet: WFT Unreduced	4.5 – 9.0 mils	115 - 225 microns
Dry: DFT	2.0 – 4.0 mils	50 – 100 microns

Theoretical coverage at 1.0 mil (25 microns)
DFT: 802 ft² per gallon at 100% transfer efficiency.

Dry Times

	68°F (20°C)	86°F (30°C)	104°F (40°C)
Dust Free	2 Hours	1 Hour	30 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 the topcoat.

For best results surface temperature must be 86°F (30°C) or less before topcoating.

The use of Super Catalyst II with Endura topcoats will accelerate drying times.

Important Note: Ensure that no more than three coats of paint are applied in a 12-hour shift. This includes primer, mid-coat, topcoats and clear coat. If more than 3 coats have been applied wait 10-12 hours to allow for proper solvent evaporation.

For questions about scheduling please contact your Endura Representative.

Clean Up

Clean all equipment immediately after use with Endura High Strength Gun Wash, or Endura EX-2C thinner.

Follow manufacturer's safety recommendations when using any solvent.

DuraCoat Clear

Technical Data Sheet (TDS)

Ordering Information (sizing)

Available in Gallons.
Other custom sizes may be available.

Product lead times may apply.
Please contact your Endura Representative for further information regarding stock availability and lead times.

3 Mixed Gallons		
Comp A - 2X	FUA0207-030	1 Gal.
Comp B	FUB0083-030	1 Gal.

Environmental Conditions

For optimum coating performance, 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 please contact your Endura Representative.

Specifications

Hardness	ASTM D3363	4H
Solvent Resistance	ASTM D4752	100 MEK Rubs; No Failure
Impact Resistance	ASTM D2794	70 in. lbs; NO failure
Abrasion Resistance (1000 cycles CS-17)	ASTM D4060	70 mg loss
Flexibility	ASTM D522	1/8 mandrel bend: NO failure
Service Temp	-40°F to 360°F	-40°C to 182°C