Endura Manufacturing Co. Ltd
12425 149 Street
Edmonton, Alberta T5L 2J6
Toll Free: 1-800-661-9930
www.endura.ca

Nexus 80 Clear

Technical Data Sheet (TDS)

Product Description

Nexus 80 Clear is an iso-free two-component polysiloxane coating, providing a high gloss surface finish.

Product features:

- High gloss
- Cures down to 0°C
- Excellent adhesion
- Excellent chemical resistance
- Excellent UV resistance
- Easy to clean
- Resists high humidity and moisture
- Wide application window
- **VOC Compliant**

Recommended Uses

Nexus 80 Clear is intended for industrial applications; either new build or maintenance.
Nexus 80 Clear can be applied Direct-to-Metal.

Nexus 80 Clear is recommended as a protective, adhesive coat for new steel structures in severely corrosive atmospheric environments.

Industries:

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

Mix Ratio

1 part by volume of component A **[FEA0114]**
1 part by volume of component B **[FEB0071]**

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

Product Characteristics

Gloss: High Gloss 90+ GU at 60 deg.

Volume Solids Mixed: 72% +/- 1%

Pot Life: 5 Hours at 77°F (25°C) and 50% RH

VOC Mixed (Unreduced): (EPA Method 24):
Nexus 80**: 249 g/l (2.082 lb/gal)**

Note: VOC Compliant below 250 g/l (2.083 lb/gal)

Shelf Life:
Component A: 3 years at 77°F (25°C)
Component B: 2 years at 77°F (25°C)

Note: For unopened product.

Surface Prep

Direct to Metal Application:

Surface 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 to a minimum of SSPC-SP6 or mechanically sanded with 80 grit sand paper.

Round off all rough welds and remove all weld spatter.

Application Method

Nexus 80 Clear can be applied using most spray painting systems.

Apply one to two single wet coats allowing up to 30 minutes flash time between coats.

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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	55-65 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	

Spray Viscosity

Using a Ford 4 Cup (White)

14-25 Seconds*	Reduce as necessary*
⟷	
Conventional	Airless

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

If required, thin Nexus 80 Clear with a maximum of 18% xylol to achieve the recommended spraying viscosity.

Film Build

Nexus 80 Clear has a recommended film build thickness of:

Direct to metal Application:

Wet (unreduced): 4.0 – 7.0 mils wet
(125 – 175 microns)

Dry: 3.0 – 5.0 DFT (75 – 125 microns)

Theoretical coverage at 1.0 mil (25 microns)
DFT: 1150 ft^2 per gallon at 100% transfer efficiency.

Dry Times

	68°F (20°C)	86°F (30°C)	104°C (40°C)
Dust Free	120 Mins.	90 mins	60 mins
Full Cure	7 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.

If Nexus 80 Clear needs to be recoated; the maximum re-coat window without sanding is 18 hrs at 68°F (20°C). After 18 hours Nexus 80 Clear must be sanded to achieve inter-coat adhesion.

Sanding with 320-400 grit sandpaper before recoating is recommended.

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, 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 Gallons.

Other custom sizes may be available.

2 Gallons		
Comp A	FEA0114-030	1 Gal
Comp B	FEB0071-030	1Gal

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.

Note: For use outside this range please contact your Endura Representative.

Specifications

Solvent Resistance	ASTM D4752	100 MEK rubs, NO failure
Impact resistance	ASTM D2794	30 in. lbs; NO failure
Service Temp	-40°C to +93°C -40°F to 200°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.