



## 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

<b>Gloss:</b>	High: 90+ GU at 60°
Slight gloss variations will occur depending on color.	
<b>Volume Solids Mixed: (Unreduced)</b> FEA0114: FEB0071 (1:1)	72% ± 1%
<b>Pot Life:</b> (77°F (25°C) and 50% RH)	5 Hours
<b>VOC Mixed (Unreduced):</b> EPA Method 24 FEA0114: FEB0071 (1:1)	249 g/l 2.082 lb /gal
<b>VOC Compliant below 250 g/l (2.083 lb/gal)</b>	
<b>Shelf Life:</b>	
<b>Component A</b>	3 years
<b>Component B</b>	2 years
<b>For unopened product (77°F (25°C))</b>	

#### Surface Preparation

##### 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.

##### Clear coat over Fusion 90:

Nexus 80 Clear can be applied on Fusion 90 colors without sanding during the topcoat window. Ensure that surfaces to be clear coated are free of flaws, surface contaminants and other surface imperfections.

If the Fusion 90 has been allowed to cure longer than 18 hours, sanding will be required to achieve inter-coat adhesion. Sand the topcoat lightly with 400 grit sandpaper or maroon/grey scuff pads.



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#### Application Method

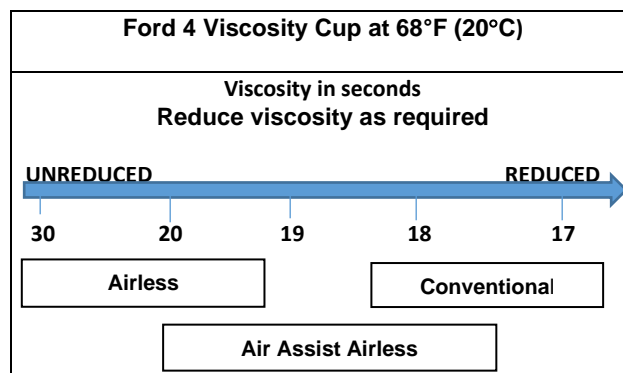
Nexus 80 Clear can be applied using most spray painting systems.

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

#### 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



**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:

<b>Wet: WFT Unreduced</b>	<b>4.0 – 7.0 mils</b>	<b>100 – 175 microns</b>
<b>Dry: DFT</b>	<b>3.0 – 5.0 mils</b>	<b>75 – 125 microns</b>

#### Application over Fusion 90 :

<b>Wet: WFT Unreduced</b>	<b>2.5 – 5.0 mils</b>	<b>65 – 125 microns</b>
<b>Dry: DFT</b>	<b>2.0 – 4.0 mils</b>	<b>50 – 100 microns</b>

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

#### Dry Times

	<b>68°F (20°C)</b>	<b>86°F (30°C)</b>	<b>104°F (40°C)</b>
<b>Dust Free</b>	2 Hours	90 Minutes	60 Minutes
<b>Full Cure</b>	7 Days		

**Note: Dry Times are subject to ambient conditions (temperature and humidity), 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 hours at 68°F (20°C). After 18 hours, Nexus 80 Clear must be sanded to achieve inter-coat adhesion. Mechanical sanding with 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.



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#### 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.

#### 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.

2 Mixed Gallons		
Comp A	FEA0114-030	1 Gal.
Comp B	FEB0071-030	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	B
Solvent Resistance	ASTM D4752	100 MEK rubs, NO failure
Impact resistance	ASTM D2794	30 in. lbs; NO failure
Abrasion Resistance (1000 cycles CS-17)	ASTM D4060	51 mg loss
Flexibility	ASTM D522	1/2" mandrel bend: NO failure
Service Temp	-40°F to 200°F	-40°C to 93°C

#### Safety Precautions

Please refer to all Safety Data Sheets (SDS) before using this product. SDS sheets can be found on our website at [endurapaint.com](http://endurapaint.com)