

## 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. It is recommended as a protective, adhesive coat for new steel structures in severely corrosive atmospheric environments and can be applied Direct-to-Metal.

#### Industries:

- Oilfield & Energy Services
- Cranes and Construction Equipment
- Waste and Recycling Industry
- Trailers and Rolling Stock

#### Product Characteristics

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

#### 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 sandpaper.

**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.

#### 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).

#### 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
<b>Siphon Feed</b>	1.6- 1.8 mm	40-50 psi	
<b>Gravity Feed</b>	1.3-1.4 mm	30-40 psi	
<b>Pressure Feed</b>	1.0-1.8 mm	55-65 psi	10-14 oz/min
<b>Air Assist Airless</b>	9-13 Thou	1,000-1,800 psi	
<b>Airless</b>	11-13 Thou	1,700-3,000 psi	

Suggested Viscosity Ranges Ford 4 Viscosity Cup at 68°F (20°C)	
<b>Airless</b>	19 - 30 secs
<b>Air Assist Airless</b>	17 - 20 secs
<b>Conventional</b>	16 – 19 secs

**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 recommended film thickness:

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

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Application over Fusion 90 :		
Wet: WFT Unreduced	2.5 – 5.0 mils	65 – 125 microns
Dry: DFT	2.0 – 4.0 mils	50 – 100 microns

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

#### Dry Times

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

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.

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.

#### Ordering Information (sizing)

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

Nexus 80 Clear			2 mixed gallons (7.56l)
Comp A	FEA0114-030	1 gallon (3.78l)	
Comp B	FEB0071-030	1 gallon (3.78l)	

Other custom sizes may be available.

#### 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	½" 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).