

FUSION 90

Updated: Nov 2010

Endura Fusion 90 is a two-component; polysiloxane based coating, providing superior protection on any metal surface. It has excellent UV, chemical and moisture resistance with a high gloss 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

Theoretical Solids Content:

Volume: 90%

Shelf Life*

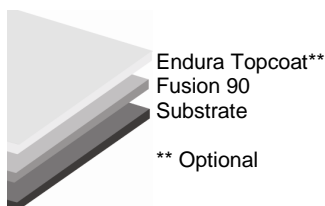
Component A: (3) years

Component B: (1) year

*For unopened product.

Pot Life of Mixed Product:

4-10 Hours @ 77°F (25°C) and 50% RH



Suitability

Endura Fusion 90 is recommended as a protective, adhesive coat for new steel structures in severely corrosive atmospheric environment.



Surface Preparation

Coating performance is, in general, proportional to the degree of surface preparation. Refer to specifications for the specific primer being used. Prior to coating, primed surface must be clean, dry, undamaged and free of all contaminants including salt deposits. Round off all rough welds and remove all weld spatter.



Mixing Ratio

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

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

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

Using a Lemmer DIN 4 Cup (blue)	
13 Seconds	Unreduced
Conventional	Airless

**Thinning is not recommended, but if needed for work-ability, thin with xylene up to 5-10%.



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	

*Please contact your Endura representative, if you wish to use this Endura Fusion 90 with an airless spray system.

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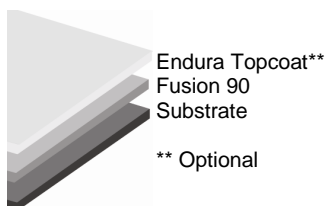
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Recommended Film Build Thickness and Cover Rate

Can be applied from 2-7 mils DFT, subject to performance requirements:

1. 2 - 4 mils as a topcoats
2. 4-7 mils as a DTM one coat system.

Theoretical coverage at 1.0 mil DFT: 1440 ft² per gallon @ 100% transfer efficiency.



Drying Time*

	20°C (68°F)	30°C (86°F)	40°C (104°F)
Dust Free	120 Minutes	90 Minutes	60 Minutes
Full Cure	7 Days		

* Subject to ambient conditions (temperature and humidity) and good airflow. For improved scheduling please contact your Endura representative.

Specifications

Hardness	ASTM D3363	H
Abrasion resistance (1000 cycles CS-17)	ASTM D4060	70 mg loss
Impact resistance	ASTM D2794	20 in. lbs; NO failure
Flexibility	ASTM D522	1/2 " mandrel bend; NO failure
VOC	126 g/L (1.1 lbs/gal)	



Clean Up

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