



Nexus 80 Clear

Endura Nexus 80 is a two-component; polysiloxane based clear 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
- ◆ VOC Compliant

Theoretical Solids Content:

Volume: 80%

Shelf Life*

Component A: (1) year
Component B: (1) year

*For unopened product.

Pot Life of Mixed Product:

5 Hours @ 77°F (25°C) and 50% RH



Suitability

Endura Nexus 80 is recommended as a protective, adhesive clear coat for new steel structures in severely corrosive atmospheric environment.

Endura Nexus 80 is formulated to exceed the Canadian Automotive refinishing guidelines for VOC levels in clear coats.



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 [FEA0114]
1 part by volume of component B [FEB0080]

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*

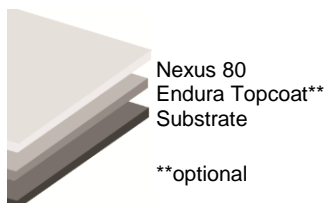
14-25 Seconds *	Using a Ford 4 Cup (white) reduce as necessary *
Conventional	Airless

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



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	





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Recommended Film Build Thickness and Cover Rate

Endura Nexus 80 has a recommended film build of:

Wet (unreduced): 4.0 – 6.0 mils wet (100 – 150 microns)
Dry: 3.0 – 5.0 mils dry (75 – 125 microns)

Theoretical coverage at 1.0 mil DFT: 1280 ft² per gallon @ 100% transfer efficiency.

Drying Time*

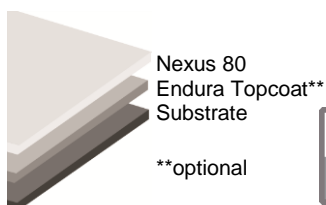
	20°C (68°F)	30°C (86°F)	40°C (104°F)
Topcoat	3-5 Hours	Topcoat	3-5 Hours
Full Cure	7 Days		

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



Specifications

Solvent resistance	ASTM D4752	100 MEK rubs; NO failure
Impact resistance	ASTM D2794	30 in. lbs; NO failure
VOC	< 245 grams/liter (2.04 lbs/gallon)	



Clean Up

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