

Bondon 110 Epoxy Blast Primer

Product Description	A two pack epoxy, zinc phosphate blast primer for steelwork.				
Features & Use	<ul style="list-style-type: none"> • Fast drying to ensure minimal stoppage for continual blasting operations • Can be overcoated with most generic groups (excluding zinc rich) • Where temporary protection is required prior to fabrication • Use for steelwork in industrial locations, bridges, chemical plants and general use • Application by airless and conventional spray 				
Approvals/ Certification	Please consult Axalta Coating Systems				
Finish	Matt				
Volume Solids	47 ± 2% (varies with colour)				
VOC Content	460 ± 20 g/litre (varies with colour)				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Minimum	30 µm	64 µm	15.6 m ² /litre	
	Maximum	90 µm	191 µm	5.2 m ² /litre	
	Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated				
Drying Times	Applied to 60 microns DFT	+10°C	+23°C	+35°C	
	Dust Free		40 min	20 min	10 min
	Hard Dry		6 hr	4 hr	3 hr
	Overcoating	Minimum	2 hr	1 hr	30 min
		Maximum	6 months		
	Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation				
Colours	Red Oxide, Grey, Buff				
Mix Ratio/ Product Code	Base	12110-	4 parts by volume		
	Hardener	12110-ACT	1 part by volume		
Pot Life	8 hours at 23°C				
SG	1.43 kg/lit mixed (varies with colour)				
Storage Conditions	Store in dry, cool conditions and protect from frost				
Shelf Life	Minimum 12 months if stored as above in unopened containers				
Flash Point	23-60°C				

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Surface Preparation	<ul style="list-style-type: none"> All surfaces to be coated should be dry and cleaned as necessary to remove all oil, grease, salts, weld flux or other contamination. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seams Blast clean to Sa2½ (ISO 8501-1:2007), surface profile 50-75 microns 														
Mixing	<p>Mix only in the proportions stated, mixing each component individually then together using a mechanical agitator. Agitate periodically during use to ensure product remains homogeneous.</p>														
Thinner / Cleaner	<p>Axalta Thinner TH500 (formerly called No.5 Thinner)</p>														
Application Conditions	<p>Only apply in conditions of good ventilation which must be maintained during drying and curing. Do not apply when rain, mist, sleet or snow are imminent. During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point. Only apply this product when the above conditions can be maintained throughout the critical application and drying/curing process. Paint temperature should ideally be at a minimum of 15°C.</p>														
Application Methods	<table border="1"> <thead> <tr> <th data-bbox="451 887 692 958">Method</th> <th data-bbox="692 887 940 958">Airless Spray</th> <th data-bbox="940 887 1187 958">Conventional Spray</th> <th data-bbox="1187 887 1339 958">Brush</th> <th data-bbox="1339 887 1490 958">Roller</th> </tr> </thead> <tbody> <tr> <td data-bbox="451 958 692 1016"></td> <td data-bbox="692 958 940 1016">Yes</td> <td data-bbox="940 958 1187 1016">Yes</td> <td data-bbox="1187 958 1339 1016">Yes</td> <td data-bbox="1339 958 1490 1016">Yes</td> </tr> </tbody> </table>					Method	Airless Spray	Conventional Spray	Brush	Roller		Yes	Yes	Yes	Yes
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<ul style="list-style-type: none"> Airless Spray: Output fluid pressure at tip 1800-2500 psi, Tip Size: 11-17 thou (0.28-0.43mm) Conventional Spray: thinning up to 5% may be required. Use 50-60psi pressure and 1.4-2.0mm tip size Brush and roller should only be used for touch-up of small areas Refer to Axalta Coating Systems 'Epoxy Application and Curing Notes' 															
Product Notes	<ul style="list-style-type: none"> Product is very fast drying – ensure that a full continuous wet coat is applied. Care must be taken to prevent dry spray. May be thinned up to 5% to aid application if required Do not apply or cure below 7°C; temperatures above 10°C are recommended and above 15°C is preferred Like all epoxy coatings, this product will chalk on prolonged exterior exposure, the degree of which is subject to atmospheric conditions 														
Health & Safety	<p>Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.</p>														

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