

Bondon 112

Product Description	A two pack epoxy, high solids, undercoat/finish containing MIO pigment.				
Features & Use	• Use as an undercoat or finish coat over Bondon 115 and/or Bondon 116 • Excellent anticorrosive protection • Good chemical and solvent resistance • Use as part of a Bondon system to upgrade conventional coatings to a high performance epoxy/polyurethane system • Can overlap onto aged, sound chlorinated rubber, vinyl or alkyd products				
Approvals/ Certification	Please consult Axalta Coating Systems				
Finish	MIO				
Volume Solids	76 ± 2%				
VOC Content	198 ± 20 g/litre				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Minimum	100 µm	132 µm	7.6 m²/litre	
	Maximum	200 µm	263 µm	3.8 m²/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 125 microns DFT		+10°C	+23°C	+35°C
	Dust Free		4 hr	3 hr	2 hr
	Hard Dry		24 hr	16 hr	12 hr
	Overcoating	Minimum	12 hr	8 hr	4 hr
		Maximum	12 weeks		
	Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation				
Colours	Grey MIO				
Mix Ratio/ Product Code	Base Hardener	12112-MGY 12112-ACT	4 part by volume 1 part by volume		
Pot Life	2 hours at 23°C				
SG	1.85 kg/lt mixed				
Storage Conditions	Store in dry, cool conditions and protect from frost				
Shelf Life	Minimum 6 months if stored as above in unopened containers				
Flash Point	23-60°C				

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Surface Preparation	- This is an undercoat or finish coat which should be applied over a suitable priming system such as Bondon 115 and/or Bondon 116 - All surfaces to be coated should be dry and cleaned as necessary to remove all oil, grease, salts, weld flux or other contamination				
Mixing	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.				
Thinner / Cleaner	Axalta Thinner TH500 (formerly called No.5 Thinner)				
Application Conditions	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.				
Application Methods	Method	Airless Spray	Conventional Spray	Brush	Roller
		Yes	No	Yes	No
	- Airless Spray: Output fluid pressure at tip 2000-3000 psi, Tip Size: 13-21 thou (0.33-0.53mm). - Brush application recommended. Roller application may not give suitable cosmetic finish due to high build structure and MIO pigmentation - Refer to Axalta Coating Systems 'Epoxy Application and Curing Notes'				
Product Notes	- Overcoating - if overcoating with products other than itself or Bondon 168/169 please consult Axalta Coating Systems for advice. For best results, overcoat within 7 days at 23°C. If overcoating after prolonged periods, ensure that the 'rough' MIO surface is completely clean - Extend min/max drying and overcoating times at lower temperatures and for dft's above 125 microns - Do not apply or cure below 5°C. Use Bondon Wintercure Hardener for low temperature applications, consult Axalta Coating Systems for advice - Colour changes can occur in exposed conditions and will occur at elevated temperatures				
Health & Safety	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.				

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