

Bondon 168 -169

Product Description	A two pack polyurethane gloss, or semi-gloss, finish for use on protective systems for steelwork.				
Features & Use	- A tough and durable finish together with excellent gloss and colour retention - Bondon 168 (gloss) approved to UK Highways Agency - Excellent chemical resistance and low temperature curing - Use as a site or shop applied finish - Easily cleaned gloss surface				
Approvals/ Certification	Bondon 168 (gloss) approved to UK Highways Agency Item 168				
Finish	Gloss (Bondon 168) and Semi-gloss (Bondon 169)				
Volume Solids	Bondon 168: 52 ± 2%; Bondon 169: 58 ± 2% (varies with colour)				
VOC Content	Bondon 168: 410 ± 20 g/litre; Bondon 169: 390 ± 20 g/litre (varies with colour)				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Minimum	50 µm	96 µm	10.4 m²/litre	
	Maximum	100 µm	192 µm	5.2 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 50 microns DFT		+10°C	+23°C	+35°C
	Dust Free		2½ hr	1½ hr	1 hr
	Hard Dry		12 hr	8 hr	5 hr
	Overcoating	Minimum	2½ hr	1½ hr	1 hr
		Maximum	4 days	3 days	2 days
	Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation				
Colours	BS and RAL colours and shades to customer specification				
Mix Ratio/ Product Code	Base Hardener	12168- (gloss) or 12169- (semi-gloss) 12168-ACT		4 parts by volume 1 part by volume	
Pot Life	3 hours at 23°C				
SG	1.39 kg/lt mixed, varies with colour				
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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 Issue Date: Oct 2020
 Page 2 of 2

Surface Preparation	- This product is a finish coat and should be applied over an appropriate primer or intermediate coating - All surfaces to be coated should be dry and cleaned as necessary to remove all oil, grease, salts 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 TH600 (formerly called No.6 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	Yes	Yes	Yes
	- Airless Spray: Output fluid pressure at tip 2200-2500 psi, Tip Size: 13-17 thou (0.33-0.43mm) - This product is suitable for application by brush or roller, but due to its fast drying properties intricate structures should be avoided - The addition of 5-10% of TH600 Thinner is recommended for best results when spraying				
Product Notes	- For optimum opacity use a primer/undercoat of a suitable shade - High humidity and condensation will impair gloss if exposed during application and curing Contains isocyanates – refer to Safety Data Sheet				
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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