

Bondon 115

Product Description	A two pack epoxy, high solids, surface tolerant aluminium primer.				
Features & Use	• Use as a rust inhibiting primer on hand prepared steel, or as a high build patch repair primer under most generic coating types • Approved to UK Highways Agency and Norsok • Excellent anticorrosive protection • Excellent ‘wetting’ properties for application to a manually prepared steel surface • Good chemical and solvent resistance • Use to upgrade a conventional system to high performance epoxy/polyurethane system • Can overlap onto aged, sound chlorinated rubber, vinyl or alkyd products				
Approvals/ Certification	• Highways Agency Item 115 • NORSOK M-501 Rev 5 June 2004 System No.1 (contact Axalta Coating Systems for full specification and test report).				
Finish	Sheen				
Volume Solids	80 ± 2%				
VOC Content	168 ± 20 g/litre				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Minimum	125 µm	157 µm	6.4 m²/litre	
	Maximum	200 µm	250 µm	4.0 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		5 hr	3 hr	2½ hr
	Hard Dry		24 hr	12 hr	10 hr
	Overcoating	Minimum	18 hr	15 hr	12 hr
		Maximum	12 weeks		
	Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation				
Colours	Dark Aluminium				
Mix Ratio/ Product Code	Base Hardener	12115-ALU 12115-ACT	4 part by volume 1 part by volume		
Pot Life	2 hours at 23°C				
SG	1.41 kg/lit mixed				
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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Issue Date: Oct 2020
Page 2 of 2

Surface Preparation	- 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 - Where blast cleaning is impractical the surface should be prepared to St2 (ISO 8501-1:2007) taking care to avoid 'polishing' the surface - Can be used as a brush or spray applied primer when water abrasive blast cleaning. Allow to dry and lightly wire brush if powdery deposits form				
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	Yes
	- Airless Spray: Output fluid pressure at tip 2000-3000 psi, Tip Size: 13-21 thou (0.33-0.53mm). - Brush application is preferred over manually prepared bare steel surfaces to assist surface penetration - If applying by roller over blast cleaned steel, there is a tendency to over spread the coating resulting in low film builds. If the film build is too low a second coat should be applied to achieve required film build - Refer to Axalta Coating Systems 'Epoxy Application and Curing Notes'				
Product Notes	- Overcoating - if overcoating with products other than itself or Bondon 116, please consult Axalta Coating Systems for advice. For best results, overcoat within 7 days at 23°C - 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 - Moisture in the can may cause pressure build up				
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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