

Bondon 072

Product Description	A two pack epoxy zinc rich primer for steelwork.				
Features & Use	<ul style="list-style-type: none"> • Conforms to SSPC standard Paint 20 level 1 zinc content composition (90% zinc by weight in dry film) • Excellent resistance to undercutting from damaged areas • Overcoatable with epoxy, chlorinated rubber, vinyl or polyurethane coatings • Suitable for inland, aggressive and coastal environments where long life expectancy is required • Can be used as a holding primer 				
Approvals/ Certification	Please consult Axalta Coating Systems				
Finish	Matt				
Volume Solids	50 ± 2%				
VOC Content	452 ± 20 g/litre				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Minimum	25 µm	50 µm	20.0 m ² /litre	
	Maximum	75 µm	150 µm	6.6 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 50 microns DFT	+10°C	+23°C	+35°C	
	Dust Free	40 min	20 min	15 min	
	Hard Dry	8 hr	4 hr	2 hr	
	Overcoating	Minimum	8 hr	4 hr	2 hr
		Maximum*	7 days	7 days	3 days
	Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation. * See Product Notes				
Colours	Grey				
Mix Ratio/ Product Code	Base	12072-BASE	9 parts by volume		
	Hardener	12072-ACT	1 part by volume		
Pot Life	8 hours at 23°C				
SG	2.41 kg/lit 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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<p>Surface Preparation</p>	<ul style="list-style-type: none"> • Blast clean to Sa2½ (ISO 8501-1:2007), surface profile 50-75 microns • 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 														
<p>Mixing</p>	<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>														
<p>Thinner / Cleaner</p>	<p>Axalta Thinner TH500 (formerly called No.5 Thinner)</p>														
<p>Application Conditions</p>	<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>														
<p>Application Methods</p>	<table border="1"> <thead> <tr> <th>Method</th> <th>Airless Spray</th> <th>Conventional Spray</th> <th>Brush</th> <th>Roller</th> </tr> </thead> <tbody> <tr> <td></td> <td>Yes</td> <td>Yes</td> <td>Yes</td> <td>No</td> </tr> </tbody> </table>	Method	Airless Spray	Conventional Spray	Brush	Roller		Yes	Yes	Yes	No				
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<ul style="list-style-type: none"> • Airless Spray: Output fluid pressure at tip 2000-2500 psi minimum, Tip Size: 13-17 thou (0.33-0.43mm) • Conventional spray will require equipment with an agitated pot and thinning up to 5% • Application by brush will result in a reduced film thickness and is recommended only for small areas of touch up/remedial work • Refer to Axalta Coating Systems 'Epoxy Application and Curing Notes' 															
<p>Product Notes</p>	<ul style="list-style-type: none"> • Best inter-coat adhesion achieved when subsequent coat is applied before the primer coat is fully cured at the overcoating times shown. May be overcoated after prolonged periods, but it may be necessary to roughen the surface to ensure inter-coat adhesion • May be overcoated with products from the ViterShield, ViterThane, ViterSeal, ViterBond, ViterTar and ViterChlor ranges or other non-saponifiable coatings • Zinc based paints tend to scour paint lines of stubborn residues which can result in blockages at the tip • Upon exposure of the dry film to damp/wet conditions, zinc salts will form and these must be removed by through water washing prior to overcoating. Consult Axalta Coating Systems for advice • Do not apply or cure below 5°C, temperatures above 10°C recommended 														
<p>Health & Safety</p>	<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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