

## BONDON 123

### PRODUCT DESCRIPTION

A high solids, low VOC, epoxy glass flake coating with outstanding chemical and abrasion resistance.

### USES

As an intermediate/finish coat for blast cleaned new construction, where maximum water resistance is required, splash zones, subsea, under decks and tidal locations. Will give long life in industrial environments where chemical resistance, high abrasion and impact properties are required.

### TECHNICAL PROPERTIES

<b>Colour</b>	Red Oxide, Grey		
<b>Finish</b>	Subdued Gloss		
<b>Curing Agent</b>	Bondon 123 Curing Agent		
<b>Mix Ratio</b>	3 Base : 1 Curing Agent by volume		
<b>Specific Gravity</b>	1.476		
<b>Volume Solids</b>	89%		
<b>Recommended Film Thickness</b>	280-840µm WFT / 250-750µm DFT		
<b>Theoretical Spreading Rate</b>	1.2-3.6 m <sup>2</sup> /litre		
<b>Application Method</b>	Brush, Spray		
<b>Flash Point</b>	44°C		
<b>VOC</b>	92 g/litre		
<b>Drying Times</b>	<b>10°C</b>	<b>20°C</b>	<b>30°C</b>
Touch Dry	10 hours	6 hours	4 hours
Hard Dry	24 hours	16 hours	12 hours
Full Cure	5 days	3 days	2 days
Minimum Overcoat	1 day	1 day	1 day
Maximum Overcoat*	5 days	3 days	2 days

\*Surface to be dry and free from contaminants. When maximum recoating time is exceeded, the surface must be abraded before overcoating to ensure intercoat adhesion.

### CERTIFICATION/APPROVALS

#### RECOMMENDED SYSTEMS

Not normally specified with any products, but steelwork can be primed with Bondon 110 blast primer and Bondon 123 can be overcoated with Bondon 168 if required.

#### SURFACE PREPARATION

Blast cleaning to SA 2½ is recommended for ultimate performance. Surface profile of 100 microns is recommended for best adhesion. Stripe coat all edges, welds and bolt heads.

## PRODUCT APPLICATION

<b>Mixing</b>	Mix 3.75 litres Base with 1.25 litres Curing Agent. Mix thoroughly (mechanical mixing is recommended). Pot life 45 minutes @ 20°C.
<b>Thinners</b>	Thinner No.5
<b>Brush</b>	Stripe coat and small repairs only.
<b>Roller</b>	Small areas only. Will need multiple coats to reach recommended dry film thickness.
<b>Conventional Spray</b>	Thin up to 10% Thinner No.5, achievable WFT will be reduced and VOC levels increased.
<b>Airless Spray</b>	Use tip 0.48-0.59 mm, 50-80° angle and 2500-3000 psi pressure.
<b>Air Assisted Airless Spray</b>	Use 1500-2000 psi pressure and 1.4-2.0 mm diameter nozzle.
<b>Cleaner</b>	Thinner No.5
<b>Cleanup Considerations</b>	All equipment should be cleaned immediately after use with Thinner No.5 It is advisable that equipment should be cleaned/flushed during the course of application, the frequency of which will depend on the volume of material used and timescale over which applied. Ensure all waste materials (including packaging) are disposed of in accordance with local regulations.

## HEALTH, SAFETY & ENVIRONMENTAL

This product must be used in accordance with the Material Safety Data Sheet supplied by Spencer Coatings Limited. The user must observe local health, safety and environmental regulations when using this product. Consult Spencer Coatings Limited if there are any concerns over the suitability of this product.

## PACK SIZES

5 litre composite packs

## PACK WEIGHTS

5 litre: 7.38 Kg.

## STORAGE CONDITIONS

Store in sealed containers at 10-25°C. Shelf life 18 months (unmixed).

## LIMITATIONS

Do not apply when RH exceeds 85% or the surface is less than 3°C above dew point, or when temperature is lower than 5°C. Please be aware this product has a short pot life, only activate the amount you can use in 45 minutes. Ensure all spray equipment, guns and lines, are thoroughly cleaned before pot life expires.

## DISCLAIMER

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It is the user's responsibility to ensure that this sheet is current prior to using the product.