

BONDON 072

PRODUCT DESCRIPTION

This product is the ultimate in corrosion resistance exhibiting high cathodic protection with 90% metallic zinc in the dry film and high build application Superb as a pre-fabrication primer with excellent durability and as part of the full Bondon system on steel to give many years of life.

USES

Suitable pre-fabrication primer for all steelwork, tanks, containers, superstructures hulls and machinery where maximum Cathodic Protection is required.

TECHNICAL PROPERTIES

Colour	Grey		
Finish	Matt		
Curing Agent	Bondon 072 Curing Agent		
Mix Ratio	4.5 Base : 0.5 Curing Agent by volume		
Specific Gravity	2.35		
Volume Solids	45%		
Recommended Film Thickness	45-135µm WFT / 20-60µm DFT (60µm DFT maximum)		
Theoretical Spreading Rate	7.5– 22.5 m ² /litre		
Application Method	Brush, Spray		
Flash Point	< 25°C		
VOC	450 g/litre		
Drying Times	10°C	20°C	30°C
Touch Dry	40 minutes	20 minutes	15 minutes
Hard Dry	8 hours	4 hours	2 hours
Full Cure	10 days	5 days	4 days
Minimum Overcoat	16 hours	6 hours	4 hours
Maximum Overcoat*	Indefinite	Indefinite	Indefinite

* Best intercoat adhesion achieved when subsequent coat is applied before the preceding coat is fully cured. After prolonged exposure it may be necessary to roughen the surface to ensure intercoat adhesion.

CERTIFICATION/APPROVALS

RECOMMENDED SYSTEMS

Bondon 111, Bondon 112, Bondon 116, Bondon 168

SURFACE PREPARATION

Steel: Oil and grease should be removed by solvent cleaning according to SSPC-SP1. Remove weld spatter and smooth weld seams and sharp edges as applicable. Abrasive blasting to minimum SA2½. Apply Bondon 072 immediately after the steel has been blasted and quality of preparation has been approved.

Repair: Corroded areas should be spot blasted to SA2½ before patch priming with Bondon 072.

PRODUCT APPLICATION

Mixing	Mix 4.5 litres Base with 0.5 litres Curing Agent. Mix thoroughly. Allow 20 minutes Induction time before application. Pot life 8 hours @ 20°C.
Thinners	Thinner No.5
Brush	Small touch up areas only.
Roller	Not suitable.
Conventional Spray	Thin up to 5% Thinner No.5 Use 50-60 psi pressure and 1.2-2.0mm diameter fluid tip.
Airless Spray	Use tip size 13-17thou (0.33-0.43mm)
Air Assisted Airless Spray	Use tip size 13-17thou (0.33-0.43mm)
Cleaner	Thinner No.5
Cleanup Considerations	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: 11.75 Kg.

STORAGE CONDITIONS

Store in sealed containers at 10-25°C and ensure water contamination is avoided. Shelf life 6 months (unmixed).

LIMITATIONS

Do not apply when RH exceeds 85%, the surface is less than 3°C above dew point or surface temperature is below 5°C.

DISCLAIMER

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