

BONDON 111

PRODUCT DESCRIPTION

Two-pack zinc phosphate high build quick drying epoxy blast primer with extended durability.

USES

As a shop or site primer over steelwork for use in industrial locations, chemical plants and general fabrications.

TECHNICAL PROPERTIES

Colour	Red Oxide, Grey		
Finish	Matt		
Curing Agent	Bondon 111 Curing Agent		
Mix Ratio	4 Base : 1 Curing Agent by volume		
Specific Gravity	1.525		
Volume Solids	76%		
Recommended Film Thickness	150-300µm WFT / 114-228µm DFT		
Theoretical Spreading Rate	3-7 m ² /litre		
Application Method	Brush, Spray		
Flash Point	25°C		
VOC	198 g/litre		
Drying Times	10°C	20°C	30°C
Touch Dry	6 hours	4 hours	3 hours
Hard Dry	10 hours	8 hours	6 hours
Full Cure	10 days	7 days	5 days
Minimum Overcoat	8 hours	6 hours	4 hours
Maximum Overcoat*	12 weeks	12 weeks	12 weeks

**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

Highways Agency

RECOMMENDED SYSTEMS

Bondon 112, Bondon 168

SURFACE PREPARATION

- Steel:** Oil and grease must 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 then apply primer immediately.
- Repair:** Corroded areas should be power tool cleaned to ST3 or blast cleaned to SA2 or better. Existing systems must be dry and free from salt, grease and other contaminants. There should be no loose paint and edges of existing coatings should be well feathered and tightly adhering.

PRODUCT APPLICATION

Mixing	Mix 4 litres Base with 1 litre Curing Agent. Mix thoroughly (mechanical mixing is recommended). Pot life 2 hours @ 20°C.
Thinners	Thinner No.5
Brush	Suitable for small area maintenance only.
Roller	Suitable for small area maintenance only.
Conventional Spray	Not recommended.
Airless Spray	Thin up to 5% Thinner No.5 Use tip 0.45-0.59 mm, 60-80° angle and 2000-2500 psi pressure.
Air Assisted Airless Spray	Not recommended.
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: 7.62 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.

DISCLAIMER

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