

BONDON 115

PRODUCT DESCRIPTION

Two-pack epoxy high build aluminium primer for use on hand prepared surfaces. Bondon 115 is highly surface tolerant.

USES

As a maintenance primer applied to hand prepared steelwork and existing aged coatings to improve adhesion. Bondon 115 has excellent corrosion and impact resistance.

TECHNICAL PROPERTIES

Colour	Aluminium
Finish	Matt
Curing Agent	Bondon 115 Curing Agent
Mix Ratio	4 Base : 1 Curing Agent by volume
Specific Gravity	1.35
Volume Solids	80%
Recommended Film Thickness	150-250µm WFT / 120-200µm DFT
Theoretical Spreading Rate	4-7 m ² /litre
Application Method	Brush, Spray
Flash Point	25°C
VOC	168 g/litre

Drying Times	10°C	20°C	30°C
Touch Dry	5 hours	3 hours	2 ½ hours
Hard Dry	24 hours	12 hours	10 hours
Full Cure	10 days	7 days	5 days
Minimum Overcoat	5 hours	4 hours	3 hours
Maximum Overcoat*	Indefinite	Indefinite	Indefinite

* Surface to be dry and free from contamination prior to overcoating. Best intercoat adhesion is achieved when subsequent coat is applied before preceding coat is fully cured. After prolonged exposure it may be necessary to roughen the surface to ensure intercoat adhesion.

CERTIFICATION/APPROVALS

Highways Agency

RECOMMENDED SYSTEMS

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 blast cleaning to minimum SA2½. Power tool cleaning to minimum ST2. Please note that better surface preparation always results in longer lifetime expectations. Apply Bondon 115 immediately after the steel has been blasted and the quality of preparation has been approved.
- Repair:** Existing systems should be roughened and dry and free from loose paint, salt, grease and other contaminants prior to overcoating. Corroded and/or damaged areas should be power tool cleaned to ST2 or better or blast cleaned to SA2.

PRODUCT APPLICATION

- Mixing** Mix 4 litres Base with 1 litre Curing Agent. Mix thoroughly (mechanical mixing is recommended). Pot life 3 hours @ 20°C.
- Thinners** Thinner No.5
- Brush** Suitable. Multiple coats may be required to achieve specified dry film thickness.
- Roller** Suitable. Multiple coats may be required to achieve specified dry film thickness.
- Conventional Spray** Not recommended.
- Airless Spray** Use tip size 13 – 21 thou (0.33-0.53 mm)
- Air Assisted Airless Spray** Use tip size 13 – 19 thou (0.33-0.48 mm)
- 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: 6.75 Kg.

STORAGE CONDITIONS

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

LIMITATIONS

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