



**Industrial
&
Marine
Coatings**



**BOND-PLEX
WATERBASED ACRYLIC COATING**

B71-200 SERIES

PRODUCT INFORMATION

Revised 10/06

PRODUCT DESCRIPTION		RECOMMENDED USES																																	
<p>Bond-Plex WB Acrylic is a single component, waterborne acrylic, adhesion promoting coating formulated for direct application to pre-finished metal siding. Suitable for interior or exterior use.</p> <ul style="list-style-type: none"> Outstanding early moisture resistance Outstanding exterior durability and gloss retention Eliminates the use of a primer over pre-finished siding Suitable for use in USDA inspected facilities (except Aluminum) Fast dry Low odor Very good mar resistance 		<p>For use over pre-finished siding in industrial environments such as:</p> <ul style="list-style-type: none"> Fluorocarbons (Kynar) Polyester Polymers Silicone Polyesters When a low sheen finish is required to match existing coil coated metal siding. <p>For use in markets such as:</p> <ul style="list-style-type: none"> General Industrial Pulp and Paper Food and beverage Pharmaceutical <p>Acceptable for use in high performance architectural applications.</p>																																	
PRODUCT CHARACTERISTICS		PERFORMANCE CHARACTERISTICS																																	
<p>Finish: White & Colors - Low Sheen Aluminum - Gloss</p> <p>Color: Wide range of colors available</p> <p>Volume Solids: (may vary by color) Extra White 41% ± 2% Aluminum 37% ± 2%</p> <p>Weight Solids: 55.0% ± 2% 39.0% ± 2%</p> <p>VOC: (EPA 24) (unreduced) <100 g/L; 0.83 lb/gal <200g/L; 1.67 lb/gal</p> <p>Recommended Spreading Rate:</p> <table border="1"> <thead> <tr> <th></th> <th>White & Colors</th> <th>Aluminum</th> </tr> </thead> <tbody> <tr> <td>Wet mils:</td> <td>4.8—10.0</td> <td>5.0—11.0</td> </tr> <tr> <td>Dry mils:</td> <td>2.0—4.0</td> <td>2.0—4.0</td> </tr> <tr> <td>Coverage, sqft/gal:</td> <td>164—329</td> <td>148—296</td> </tr> </tbody> </table> <p>Drying Schedule @ 5.0 mils wet @ 50% RH:</p> <table border="1"> <thead> <tr> <th></th> <th>50°F</th> <th>77°F</th> <th>120°F</th> </tr> </thead> <tbody> <tr> <td>To touch:</td> <td>1 1/2 hour</td> <td>45 min</td> <td>20 min</td> </tr> <tr> <td>Tack free:</td> <td>6 hours</td> <td>4 hours</td> <td>2 hrs</td> </tr> <tr> <td>To recoat:</td> <td>8 hours</td> <td>4 hours</td> <td>2 hrs</td> </tr> <tr> <td>To cure:</td> <td>14 days</td> <td>7 days</td> <td>5 days</td> </tr> </tbody> </table> <p>Drying time is temperature, humidity, and film thickness dependent.</p> <p>Shelf Life: 36 months, unopened (Aluminum - 12 months, unopened) Store indoors at 40°F to 100°F.</p> <p>Flash Point: >200°F PMCC</p> <p>Reducer/Clean-Up: Water</p>			White & Colors	Aluminum	Wet mils:	4.8—10.0	5.0—11.0	Dry mils:	2.0—4.0	2.0—4.0	Coverage, sqft/gal:	164—329	148—296		50°F	77°F	120°F	To touch:	1 1/2 hour	45 min	20 min	Tack free:	6 hours	4 hours	2 hrs	To recoat:	8 hours	4 hours	2 hrs	To cure:	14 days	7 days	5 days	<p>System Tested (unless otherwise indicated) Substrate: Pre-Finished Siding Surface Preparation: SSPC-SP1 1ct. Bond-Plex WB Acrylic @ 2.0-4.0 mils</p> <p>Adhesion: Method: ASTM D4541 Result: 300 psi minimum</p> <p>Corrosion Weathering: (with 1 ct. DTM Bonding Primer) Method: ASTM D5894, 5 cycles, 1680 hours Result: Rating 10 per ASTM D610 for Rusting Result: Rating 10 per ASTM D714 for Blistering</p> <p>Direct Impact Resistance: Method: ASTM D2974 Result: Direct - 160 in. Lbs. Reverse - 160 in. Lbs.</p> <p>Dry Heat Resistance: Method: ASTM D2485 Result: 200°F</p> <p>Flexibility: Method: ASTM D522, 180° bend, 1/4" mandrel Result: Passes</p> <p>Humidity Resistance: (with 1 ct. DTM Bonding Primer) Method: ASTM D4548, 500 hours Result: Rating 10 per ASTM D610 for Rusting Result: Rating 8 per ASTM D714 for Blistering</p> <p>Pencil Hardness: Method: ASTM D3363 Result: 2B</p> <p>Salt Fog Resistance: (with 1 ct. DTM Bonding Primer) Method: ASTM B117, 500 hours Result: Rating 9 per ASTM D610 for Rusting (field) Result: Rating 10 per ASTM D714 for Blistering</p> <p>Thermal Cycling Method: ASTM D2246, 5 cycles Result: Rating 10 per ASTM D714 for Blistering</p> <p>Provides performance comparable to SSPC-Paint 23.</p>	
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RECOMMENDED SYSTEMS	SURFACE PREPARATION																
<p>Prefinished Siding:</p> <p>Fluorocarbon, Silicon Polyester, Polyester Polymers: 1-2 cts. Bond-Plex WB Acrylic @ 2.0 — 4.0 mils dft/ct or 1 ct. DTM Bonding Primer @2.0 — 5.0 mils dft 1-2 cts. Bond-Plex WB Acrylic @ 2.0 — 4.0 mils dft/ct</p> <p>Previously Painted, Hard, Slick or Glossy Surfaces: 1-2 cts. Bond-Plex WB Acrylic @ 2.0 — 4.0 mils dft/ct or 1 ct. DTM Bonding Primer @ 2.0 — 5.0 mils dft 1-2 cts. Bond-Plex WB Acrylic @ 2.0 — 4.0 mils dft/ct</p> <p>Always check compatibility of the previously painted surface with the new coating by applying a test patch of 2-3 square feet. Allow to dry thoroughly for 1 week before checking adhesion.</p> <p>The systems listed above are representative of the products use, other systems may be appropriate.</p>	<p>Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.</p> <p>Do not use hydrocarbon solvents for cleaning.</p> <p>Refer to product Application Bulletin for detailed surface preparation information.</p> <p>Minimum recommended surface preparation: Prefinished Siding: SSPC-SP1 Previously Painted: SSPC-SP1</p> <tr> <th colspan="2" data-bbox="789 842 1484 886">TINTING</th> </tr> <td data-bbox="789 886 1484 1094"> <p>Tint with EnviroToner Colorants only at 100% strength. Five minutes minimum mixing on a mechanical shaker is required for complete mixing of color.</p> <p>Do not use Blend-A-Color colorants.</p> <p>Do not tint the Aluminum.</p> <tr> <th colspan="2" data-bbox="789 1094 1484 1138">APPLICATION CONDITIONS</th> </tr> <td data-bbox="789 1138 1484 1346"> <p>Temperature: 50°F minimum, 120°F maximum (air, surface, and material) At least 5°F above dew point Relative humidity: 85% maximum</p> <p>Refer to product Application Bulletin for detailed application information.</p> <tr> <th colspan="2" data-bbox="789 1346 1484 1390">ORDERING INFORMATION</th> </tr> <td data-bbox="789 1390 1484 1503"> <p>Packaging: 1 and 5 gallon containers Weight per gallon: 10.9 ± 0.2 lb (white) (may vary with color) 8.6 ± 0.2 lb (aluminum)</p> <tr> <th colspan="2" data-bbox="789 1503 1484 1547">SAFETY PRECAUTIONS</th> </tr> <td data-bbox="789 1547 1484 1724"> <p>Refer to the MSDS sheet before use.</p> <p>Published technical data and instructions are subject to change without notice. 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APPLICATION BULLETIN

Revised 10/06

SURFACE PREPARATION	APPLICATION CONDITIONS
<p>Surface must be clean, dry and in sound condition. Remove all oil, grease, dirt, loose rust, visible contaminants, peeling paint and other contaminants to ensure adequate adhesion.</p> <p>Do not use hydrocarbon solvents for cleaning.</p> <p>Pre-Finished Siding: (Fluorocarbon, Silicone Polyester, and Polyester Polymers) Remove oil, grease, dirt, oxides, and other contaminants from the surface by cleaning per SSPC-SP1 or water blasting per NACE Standard RP-01-72 (caution: excessive blasting pressure may cause warping, use caution). Always check for compatibility of the previously painted surface with the new coating by applying a test patch of 2 - 3 square feet. Allow to dry thoroughly for 1 week before checking adhesion.</p> <p>Previously Painted Surfaces: Remove oil, grease, dirt, oxides, and other contaminants from the surface by cleaning per SSPC-SP1 or water blasting per NACE Standard RP-01-72 (caution: excessive blasting pressure may cause warping, use caution). Always check for compatibility of the previously painted surface with the new coating by applying a test patch of 2 - 3 square feet. Allow to dry thoroughly for 1 week before checking adhesion.</p>	<p>Temperature: 50°F minimum, 120°F maximum (air, surface, and material) At least 5°F above dew point</p> <p>Relative humidity: 85% maximum</p>
	<p style="text-align: center;">APPLICATION EQUIPMENT</p> <p>The following is a guide. Changes in pressures and tip sizes may be needed for proper spray characteristics. Always purge spray equipment before use with listed reducer. Any reduction must be compliant with existing VOC regulations and compatible with the existing environmental and application conditions.</p> <p>Reducer/Clean Up:..... Water</p> <p>Airless Spray Pressure 2400 psi Hose 1/4" - 3/8" ID Tip017" - .019" Filter 60 mesh Reduction As needed up to 10% by volume</p> <p>Conventional Spray Gun Binks 95 Fluid Nozzle 66 Air Nozzle 63PB Atomization Pressure ... 60 psi Fluid Pressure 25 psi Reduction As needed up to 10% by volume</p> <p>Brush Brush Nylon / Polyester Reduction Not recommended</p> <p>Roller Cover 1/4" woven with phenolic core Reduction Not recommended</p> <p>If specific application equipment is not listed above, equivalent equipment may be substituted.</p>



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<p>Surface preparation must be completed as indicated.</p> <p>Mixing Instructions: Mix paint thoroughly by boxing and stirring before use.</p> <p>Apply paint at the recommended film thickness and spreading rate as indicated below:</p> <p>Recommended Spreading Rate:</p> <table border="1"> <thead> <tr> <th></th> <th>White & Colors</th> <th>Aluminum</th> </tr> </thead> <tbody> <tr> <td>Wet mils:</td> <td>4.8 — 10.0</td> <td>5.0 — 11.0</td> </tr> <tr> <td>Dry mils:</td> <td>2.0 — 4.0</td> <td>2.0 — 4.0</td> </tr> <tr> <td>Coverage, sqft/gal:</td> <td>164 — 329</td> <td>148 — 296</td> </tr> </tbody> </table> <p>Drying Schedule @ 5.0 mils wet @ 50% RH:</p> <table border="1"> <thead> <tr> <th></th> <th>50°F</th> <th>77°F</th> <th>120°F</th> </tr> </thead> <tbody> <tr> <td>To touch:</td> <td>1 1/2 hour</td> <td>45 min</td> <td>20 min</td> </tr> <tr> <td>Tack free:</td> <td>6 hours</td> <td>4 hours</td> <td>2 hrs</td> </tr> <tr> <td>To recoat:</td> <td>8 hours</td> <td>4 hours</td> <td>2 hrs</td> </tr> <tr> <td>To cure:</td> <td>14 days</td> <td>7 days</td> <td>5 days</td> </tr> </tbody> </table> <p>Drying time is temperature, humidity, and film thickness dependent.</p> <p>Application of coating above maximum or below minimum recommended spreading rate may adversely affect coating performance.</p>		White & Colors	Aluminum	Wet mils:	4.8 — 10.0	5.0 — 11.0	Dry mils:	2.0 — 4.0	2.0 — 4.0	Coverage, sqft/gal:	164 — 329	148 — 296		50°F	77°F	120°F	To touch:	1 1/2 hour	45 min	20 min	Tack free:	6 hours	4 hours	2 hrs	To recoat:	8 hours	4 hours	2 hrs	To cure:	14 days	7 days	5 days	<p>Stripe coat all crevices, welds, and sharp angles to prevent early failure in these areas.</p> <p>When using spray application, use a 50% overlap with each pass of the gun to avoid holidays, bare areas, and pinholes. If necessary, cross spray at a right angle</p> <p>During the early stages of drying, the coating is sensitive to rain, dew, high humidity, and moisture condensation. Plan painting schedules to avoid these influences during the first 16-24 hours of curing.</p> <p>Spreading rates are calculated on volume solids and do not include an application loss factor due to surface profile, roughness or porosity of the surface, skill and technique of the applicator, method of application, various surface irregularities, material lost during mixing, spillage, overthinning, climatic conditions, and excessive film build.</p> <p>Excessive reduction of material can affect film build, appearance, and adhesion.</p> <p>Do not use hydrocarbon solvents for cleaning. When cleaning the surface per SSPC-SP1, use only an emulsifying industrial detergent, followed by a thorough water rinse.</p> <p>Always check compatibility of the previously painted surface with the new coating by applying a test patch of 2-3 square feet. Allow to dry thoroughly for 1 week before checking adhesion.</p> <p>Refer to Product Information sheet for additional performance characteristics and properties.</p>
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<p>Clean spills and spatters immediately with soap and warm water. Clean hands and tools immediately after use with soap and warm water. After cleaning, flush spray equipment with Mineral Spirits to prevent rusting of the equipment. Follow manufacturer's safety recommendations when using Mineral Spirits.</p>	<p>Refer to the MSDS sheet before use.</p> <p>Published technical data and instructions are subject to change without notice. Contact your Sherwin-Williams representative for additional technical data and instructions.</p>																																
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