

ViterClad Bonding Coat

Product Description	A modified two pack epoxy adhesion and stabilising primer , specially formulated for the maintenance and repair of architectural cladding.					
Features & Use	<ul style="list-style-type: none"> Recommended for the maintenance of Colorcoat HP200* cladding Used as: <ul style="list-style-type: none"> a primer for cladding stripped to the bondcoat or galvanised substrate a patch primer for bare steel areas an adhesion coat over existing cladding coatings, prior to the application of ViterClad PV or ViterClad 50 (see relevant Product Data Sheets) Wide colour range to suit all finishing shades Specially formulated for adhesion to stainless steel, carbon steel, galvanising, aluminium, copper, brass and PVF2, silicone polyester and other cladding types Cures down to 0°C and is tolerant of slight surface moisture during application Suitable for use as a blast/holding primer on blast cleaned cladding substrates 					
Approvals/ Certification	Recommended for the maintenance of Colorcoat HP200* cladding					
Finish	Matt					
Volume Solids	30 ± 2% (may vary with colour)					
VOC Content	581 ± 20 g/litre (may vary with colour)					
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage		
	Typical	15 µm	50 µm	20.0 m ² /litre		
	Maximum	20 µm	66 µm	15.0 m ² /litre		
	Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated					
Drying Times	Applied to 15 microns DFT	+5°C	+10°C	+23°C	+35°C	
	Dust Free	10 min	6 min	4 min	2 min	
	Hard Dry	20 min	15 min	10 min	5 min	
	Overcoating	Minimum	6 hr	4 hr	3 hr	2 hr
		Maximum	Indefinite when the surface is clean and sound			
	Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation					
Colours	Full range of BS, RAL and other colours from in can tinting					
Mix Ratio/ Product Code	Base	3355	3 parts by volume			
	Hardener	4050 059	1 part by volume			
Pot Life	8 hours at 23°C					
SG	1.19-1.23 kg/lit mixed (may vary with colour)					
Storage Conditions	Store in dry, cool conditions and protect from frost					
Shelf Life	Minimum 12 months if stored as above in unopened containers					
Flash Point	23-60°C					



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<p>Surface Preparation</p>	<ul style="list-style-type: none"> Any very shiny or glossy bare metal areas, and all stainless steel, should be abraded to provide a key Stripped bare metal areas must be free from stripper residues, metal salts, rust, debris and metal spatter – use suitable hand, mechanical or blast cleaning methods. Thoroughly degrease preferably using ViterClene ‘C’ bio-degradable degreaser, rinse with clean water and allow to dry before coating. As stripper residues can be difficult to detect, wash surface thoroughly with detergent and rinse with clean water if these may be present For aged/degraded Plastisol, condition diagnosis and correct surface preparation are critical to performance. Please refer to Axalta Coating Systems for advice. ViterClad Bonding Coat can be applied over leather-grain effect HP200* Plastisol, but is not recommended as a full coat over the newer type HPS200* (dimple-effect) Plastisol. When using as a patch primer for bare areas with aged HPS200* cladding, overlap onto sound areas of HPS200* should be kept to a minimum Surfaces should be clean, dry and free from all grease, oil and general contamination 										
<p>Mixing</p>	<p>Mix only in the proportions stated, mixing each component individually then together using a mechanical agitator. Agitate periodically during use to ensure product remains homogeneous.</p>										
<p>Thinner</p>	<p>1031 Thinner Equipment Cleaner 1031 Thinner</p>										
<p>Application Conditions</p>	<p>Only apply in conditions of good ventilation which must be maintained during drying and curing. Do not apply when rain, mist, sleet or snow are imminent. During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point. Only apply this product when the above conditions can be maintained throughout the critical application and drying/curing process. Paint temperature should ideally be at a minimum of 15°C. Do not apply above 40°C. Do not apply over standing or running water or ice.</p>										
<p>Application Methods</p>	<table border="1" data-bbox="459 1133 1506 1263"> <thead> <tr> <th>Method</th> <th>Airless Spray</th> <th>Conventional Spray</th> <th>Brush</th> <th>Roller</th> </tr> </thead> <tbody> <tr> <td></td> <td>Yes</td> <td>Yes</td> <td>Yes</td> <td>Yes</td> </tr> </tbody> </table> <ul style="list-style-type: none"> Airless Spray: Output fluid pressure at tip 1500-2500 psi, Tip Size: 11-15 thou (0.28-0.38mm) For application under cold or hot conditions, up to 5% addition of 1031 Thinner may be necessary Refer to Axalta Coating Systems ‘Epoxy Application and Curing Notes’ 	Method	Airless Spray	Conventional Spray	Brush	Roller		Yes	Yes	Yes	Yes
Method	Airless Spray	Conventional Spray	Brush	Roller							
	Yes	Yes	Yes	Yes							
<p>Product Notes</p>	<ul style="list-style-type: none"> Do not exceed the maximum stated dry film thickness This coating has not been tested to the standard of the new regulation 7(2) of the Building Regulations 2010, which came into force in Dec 2018. <p><i>* Colorcoat HP200 & HPS200 are registered Trade Marks of Tata Steel UK Ltd.</i></p>										
<p>Health & Safety</p>	<p>Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.</p>										

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