

## PROTEGA CLAD BONDING COAT

### DESCRIPTION

A two component, modified epoxy adhesion and stabilising primer, specifically formulated for the maintenance and repair of architectural cladding.

### PRODUCT FEATURES AND RECOMMENDED USES

- ◆ Recommended for the maintenance of Corus Colorcoat HP200\* cladding.
- ◆ Used as a primer for cladding stripped to bondcoat or galvanised substrate; as a patch primer for bare steel areas; where required, as an adhesion coat over existing cladding coatings prior to the application of ProtegaClad PV or ProtegaClad 50 (see relevant Product Data Sheets).
- ◆ Wide colour range to suit all finishing shades.
- ◆ Specifically formulated for adhesion to stainless steel, carbon steel, galvanising, aluminium, copper, brass and PVF2, silicone polyester and other cladding types.
- ◆ Functions as an adhesion bond coat and anticorrosive primer/sealer for metal substrates, stabilising the substrate to receive high performance topcoats and imparting hydrophobic properties
- ◆ 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.

### TECHNICAL DATA

**Volume solids** 30 ± 2% mixed. (ISO 3233)

**Weight solids** 52 ± 2% mixed.

**Specific gravity** 1.19 – 1.23 mixed.

**Product code**

Base	3 parts by volume	3355 series
Activator	1 parts by volume	4050 059
Composite		4825 series

### Recommended film thicknesses and theoretical coverage

Recommended film thicknesses		Theoretical coverage
dry	wet	
15 µm	50 µm	20.0 m <sup>2</sup> /l
20 µm	66 µm	15.0 m <sup>2</sup> /l

Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated.

### Drying time

DFT 15µm		+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	min	6 h	4 h	3 h	2 h
	max	Indefinite** - see product notes			

Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation.

**Finish** Matt

**Colours** BS4800, RAL, NCS, BS5252 and BS381C colours.

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## APPLICATION DETAILS

<b>Surface preparation</b>	<p><b>Stripped bare metal areas</b> 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 ProtegaClene 'C' bio-degradable degreaser, rinse with clean water and allow to dry before coating. Any very shiny or glossy bare metal areas, and all stainless steel, should be abraded to provide a key. As stripper residues can be difficult to detect, wash surface thoroughly with detergent and rinse with clean water if these may be present.</p> <p><b>For aged/degraded Plastisol</b>, condition diagnosis and correct surface preparation are critical to performance. Please refer to Protega Coatings for advice. ProtegaClad 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 within aged HPS200* cladding, overlap onto sound areas of HPS200* should be kept to a minimum.</p> <p>Surfaces should be clean, dry and free from all grease, oil and general contamination.</p>														
<b>Application conditions</b>	<p>Only apply in conditions of good ventilation, which must be maintained during drying. Do not apply in windy conditions where wind is likely to carry spray mist. Do not apply when rain, mist, sleet, or snow are imminent. During application and drying time of the paint coating, the surface must be dry, the relative humidity should not exceed 85% and the surface temperature of steel should remain at least 3°C above the dew point. Do not apply above 40°C. Do not apply over standing or running water or ice.</p>														
<b>Mixing</b>	<p>Mix only in the proportions stated, mixing each component individually then together using a mechanical agitator. Ensure complete homogeneity before use.</p>														
<b>Application</b>	<table border="1"><thead><tr><th>Method</th><th>Airless Spray</th><th>Automatic Spray</th><th>Conventional Spray</th><th>Brush</th><th>Roller</th></tr></thead><tbody><tr><td>Output Fluid Pressure</td><td>1500 – 2500 p.s.i.</td><td rowspan="2">No</td><td rowspan="2">Yes</td><td rowspan="2">Yes</td><td rowspan="2">Yes</td></tr><tr><td>Tip Size</td><td>11 – 15 thou</td></tr></tbody></table> <p>Do not exceed the maximum stated dry film thickness. Certain pale shades and accent colours of topcoat may require extra coats for complete obliteration of primer. For application under cold or hot conditions, up to 5% addition of 1031 Thinner may be necessary.</p>	Method	Airless Spray	Automatic Spray	Conventional Spray	Brush	Roller	Output Fluid Pressure	1500 – 2500 p.s.i.	No	Yes	Yes	Yes	Tip Size	11 – 15 thou
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Output Fluid Pressure	1500 – 2500 p.s.i.	No	Yes	Yes	Yes										
Tip Size	11 – 15 thou														
<b>Thinner</b>	1031 Thinner														
<b>Cleaning of equipment</b>	Remove remaining paint from equipment, flush thoroughly with 1031 Thinner until solvent appears uncontaminated.														
<b>Pot life</b>	12 hours @ 23°C.														
<b>FLASH POINT</b>	Above 32°C														
<b>STORAGE</b>	Store in dry, cool conditions and protect from frost.														
<b>VOC</b>	Volatile Organic Compound content: 581 ± 20 gm/lt, varies with colour.														
<b>HEALTH AND SAFETY</b>	Containers are provided with safety labels, which should be observed. Further information about hazardous influences and protection are detailed in individual health and safety data sheets. A health and safety data sheet is available on request from Protega Coatings Ltd.														
<b>PRODUCT NOTES</b>	**Indefinitely overcoatable when surface is clean and sound. * HP200 & HPS200 are registered Trade Marks of Corus UK Ltd.														

This information is given in good faith for the guidance of users but without warranty or liability. Any queries should be referred to our Technical Department. The above information, based on laboratory tests and practical experience, has been proved valid at the date marked on the product data sheet. When necessary verify the validity of the product data sheet. The quality of the product is ensured by our operational system, based on the requirements of the standards ISO 9001. As a manufacturer we cannot be responsible for any damages caused by using the product against our instructions or for inappropriate purposes. For professional use only.