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ViterClad Bonding Coat

 Recommended for the maintenance of Colorcoat HP200* cladding Used as:	Product Description	A modified two pack epoxy adhesion and stabilising primer, specially formulated for the maintenance and repair of architectural cladding.								
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 Film Thickness Range And Coverage Applied to 15 µm 50 µm 20.0 m²/litre Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated 450°C +10°C +23°C +35°C Drying Times Applied to 15 microns DFT +5°C +10°C +23°C +35°C Drying Times Mait Dry 20 µm 60 µm 10 min 5 min Overcoating Minimum 6h r 4 hr 3 hr 2 hr Overcoating Minimum Indefinite when the surface is clean and sound Drying and recoating times are related to the air and ventilation Sector Overcoating Base 3355 3 parts by volume Indefinite when the surface is clean and sound Drying and recoating times are related to the air and ventilation Sector Sector Sector	Features & Use	 Recommended for the maintenance of Colorcoat HP200* cladding Used as: 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 								
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 m²/litre Maximum 20 µm 66 µm 15.0 m²/litre Practical coverage depends on the application method, painting conditions and roughness of the surface to be coated +30°C +33°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 5 min 10 min 5 min Overcoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation 5 min 2 hr Mix Ratio/ Base 3355 3 parts by volume 5 5 Product Code Full range of BS, RAL and other colours 5 5 5 5 Mix Ratio/ Base 3355 3 parts by vol	Approvals/ Certification	Recommended for the maintenance of Colorcoat HP200* cladding								
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Flash Point 23-60°C	Shelf Life	Minimum 12 months if stored as above in unopened containers								
	Flash Point	23-60°C								

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Surface Preparation	 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 								
Mixing	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.								
Thinner	1031 Thinner Equipment Cleaner 1031 Thinner								
Application Conditions	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.								
Application Methods	Method	Airless Spray	Conventional Spray	Brush	Roller				
		Yes	Yes	Yes	Yes				
	 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' 								
Product Notes	 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. * Colorcoat HP200 & HPS200 are registered Trade Marks of Tata Steel UK Ltd. 								
Health & Safety	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.								

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