

Transpoxy HS Epoxy 1.81 / Bondon 111

Product Description	A two pack epoxy, high solids, zinc phosphate blast primer for steelwork.				
Features & Use	<ul style="list-style-type: none">Complies with the UK Highways Agency coating specifications for bridgesExcellent cure speed and high build propertiesGood resistance to undercutting from damaged areasOvercoatable with most epoxy, acrylic or polyurethane coatings				
Approvals/ Certification	UK Highways Agency Item 111				
Finish	Matt				
Volume Solids	77 ± 2% (varies with colour)				
VOC Content	196 ± 20 g/litre (varies with colour)				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Minimum	100 µm	130 µm	7.7 m²/litre	
	Maximum	300 µm	390 µm	2.5 m²/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 100 microns DFT		+10°C	+23°C	+35°C
	Dust Free		6 hr	4 hr	3 hr
	Hard Dry		10 hr	8 hr	6 hr
	Overcoating	Minimum	8 hr	6 hr	4 hr
		Maximum	12 weeks	12 weeks	12 weeks
	Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation				
Colours	Light Grey, Red Oxide				
Mix Ratio/ Product Code	Base Hardener	12111-12111-ACT	4 parts by volume 1 part by volume		
Pot Life	2 hours at 23°C				
SG	1.5 kg/ltr mixed, varies 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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Surface Preparation	<ul style="list-style-type: none"> Blast clean to Sa2½ (ISO 8501-1:2007), surface profile 50-75 microns All surfaces to be coated should be dry and cleaned as necessary to remove all oil, grease, salts, weld flux or other contamination. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seams 				
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	No.5 Thinner Equipment Cleaner No.5 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.				
Application Methods	Method	Airless Spray	Conventional Spray	Brush	Roller
		Yes	No	Yes	Yes
	<ul style="list-style-type: none"> Airless Spray: Output fluid pressure at tip 2000-2500 psi, Tip Size: 13-21 thou (0.33-0.53mm) Thinning of the coating will reduce the build qualities Application by brush/roller will result in a reduced film thickness and is recommended only for small areas of touch up/remedial work Refer to Axalta Coating Systems 'Epoxy Application and Curing Notes' 				
Product Notes	<ul style="list-style-type: none"> May be overcoated with itself or other products from the ViterShield, ViterSeal or ViterThane range If overcoating with ViterThane PLV or PLS, allow a minimum of 12 hours at 23°C when the primer has been applied to 100 microns dft. Allow longer drying and overcoating times at higher dft's and lower temperatures The compatibility of overcoating should be confirmed prior to application Certain configurations of steelwork may mean that the primer will have to be applied in more than one coat to achieve the higher film thicknesses Whilst this product will display a matt finish at a dry film thickness of 75 microns, application to a dry film thickness above 125 microns will provide a low sheen finish, the degree of which may vary Do not apply or cure below 5°C, temperatures above 10°C recommended Like all epoxy coatings, this product will chalk on prolonged exterior exposure, the degree of which is subject to atmospheric conditions 				
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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