BOND-PLEX®

WATERBASED ACRYLIC COATING

B71W00211 Extra White
B71T00204 Clear Tint Base
B71S00200 Aluminum

As of 02/04/2019, Complies with:			
OTC	Yes	LEED® 09 NC, CI	Yes
OTC Phase II	Yes	LEED® 09 CS	Yes
SCAQMD	Yes	LEED® v4&v4.1 Emissions	No
CARB	Yes	LEED® v4&v4.1 VOC	Yes
CARB SCM 2007	Yes		
Canada	Yes	MPI	N/A

CHARACTERISTICS

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.

Features:
- Outstanding adhesion
- Eliminates the use of a primer over certain pre-fnished siding
- Outstanding application characteristics

For use over properly prepared pre-finished siding:
- Fluorocarbons (Kynar®)
- Polyester Polymers
- Silicone Polyesters

Recommended for:
- Light industrial
- Pre-Finished Siding
- Manufacturing Facilities & New Construction
- Suitable for use in USDA inspected facilities

Tinting with CCE:

Base	oz/gal	Strength
Extra White	0-4	SherColor
Clear Tint Base	10-12	SherColor

Do Not Tint Aluminum

Extra White B71W00211
(may vary by base)

VOC(less exempt solvent) (as per 40 CFR 59.406)	<50 g/L - <.42 lb/gal
Volume Solids:	41 ± 2%
Weight Solids:	55 ± 2%
Weight per Gallon:	10.90 lb/gal
Flash Point:	N/A
Shelf Life:	36 months, unopened
KU	95-105
Finish:	15-25°@85° Low Sheen

Aluminum B71S00200

VOC(less exempt solvent) (as per 40 CFR 59.406)	97g/L - .81 lb/gal
Volume Solids:	42 ± 2%
Weight Solids:	45 ± 2%
Weight per Gallon:	8.62lb/gal
Flash Point:	N/A
Shelf Life:	12 months, unopened
KU	80-90
Finish:	70°@60° Gloss

SPECIFICATIONS

Color: Extra White, Clear Tint Base, Aluminum

Recommended Spread Rate per coat: Extra White B71W00211 (may vary by color)

wet mils:	5.0 -10.0
dry mils:	2.0 - 4.1
coverage:	330- 160 sq ft/gal approximate

Theoretical coverage: 657 sq ft/gal @ 1 mil dry

Drying Schedule @ 5.0 mils wet, 50% RH:

Drying, and recoat times are temperature, humidity, and film thickness dependent.

	@ 50°F/10°C	@ 77°F/25°C	@ 120°F/49°C
To touch:	1.5 hours	45 minutes	20 minutes
To handle:	6 hours	4 hours	2 hours
To recoat:	8 hours	4 hours	2 hours

RECOMMENDED SYSTEMS

Pre-Finished Siding: Fluorocarbon, Silicon Polyester, Polyester Polymers:
1-2cts. Bond-Plex WB Acrylic
Or
1ct. DTM Bonding Primer
1-2cts. Bond-Plex WB Acrylic

Pre-Finished Siding: Fluorocarbon, Silicon Polyester, Polyester Polymers:
1ct. Bond-Plex WB Acrylic
1-2cts. Pro Industrial Acrylic Coatings
Or
1-2cts. Pro Industrial DTM Acrylic

Previously Painted, Hard, Slick or Glossy Surfaces:
1-2cts. Bond-Plex WB Acrylic
Or
1ct. DTM Bonding Primer
1-2cts. Bond-Plex WB Acrylic

Previously Painted, Hard, Slick or Glossy Surfaces:
1cts. Bond-Plex WB Acrylic
1-2cts. Pro Industrial Acrylic Coatings
Or
1-2cts. Pro Industrial DTM Acrylic

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.
The systems listed above are representative of the product's use, other systems may be appropriate. Other primers may be appropriate.

System Tested: (unless otherwise indicated)
Substrate: Pre-Finished Siding
Surface Preparation: SSPC-SP1
System*: 1 ct Bond-Plex WB Acrylic Extra White 2-4 mils (*unless otherwise noted)

Abrasion Resistance:
Method: ASTM D4060, CS17 Wheel, 1000 cycles, 1 kg load
Results: 90.03 mg loss

Adhesion:
Method: ASTM D4541
Results: 1477 psi

Corrosion Weathering[1]:
Method: ASTM D5894, 5 cycle
Results: Rating 8.5 for rusting ; Rating10 for blistering

Direct Impact Resistance:
Method: ASTM D2794
Result: Direct >176 in. lb

Dry Heat Resistance:
Method: ASTM D2485
Result: 200°F/93°C

Flexibility:
Method: ASTM D522, 180° bend, 1/4" mandrel
Result: Pass

Humidity Resistance:
Method: ASTM D4585, 1443 Hours
Result: Rating 10 for rusting ; Rating 10 for blistering

Pencil Hardness:
Method: ASTM D3363
Result: 1.5B

Salt Fog Resistance[1]:
Method: ASTM B117, 274 hours
Result: Rating 8 per for rusting; Rating 8D for blistering

[1]with 1 ct Pro-Cryl & 1 ct Bond-Plex

continued on back

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SURFACE PREPARATION

WARNING! Removal of old paint by sanding, scraping or other means may generate dust or fumes that contain lead. Exposure to lead dust or fumes may cause brain damage or other adverse health effects, especially in children or pregnant women. Controlling exposure to lead or other hazardous substances requires the use of proper protective equipment, such as a properly fitted respirator (**NIOSH** approved) and proper containment and cleanup. For more information, call the National Lead Information Center at **1-800-424-LEAD** (in US) or contact your local health authority.

When cleaning the surface per SSPC-SP1, use only an emulsifying industrial detergent, followed by a water rinse. **Do not use hydrocarbon solvents for cleaning.**

Prefinished Siding Fluorocarbon, Silicon Polyester, 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.

Previously Painted Surfaces - If in sound condition, clean the surface of all foreign material. Smooth, hard or glossy coatings and surfaces should be dulled by abrading the surface. 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. If adhesion is poor, additional abrasion of the surface and/or removal of the previous coating may be necessary. Retest surface for adhesion. If paint is peeling or badly weathered, clean surface to sound substrate and treat as a new surface as above. Recognize that any surface preparation short of total removal of the old coating may compromise the service length of the system.

APPLICATION PROCEDURES

Apply paint at the recommended film thickness and spreading rate as indicated on front page. Application of coating above maximum or below minimum recommended spreading rate may adversely affect coating performance. 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, over thinning, climatic conditions, and excessive film build.

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.

SAFETY PRECAUTIONS

Refer to the SDS sheets before use. **FOR PROFESSIONAL USE ONLY**

Published technical data and instructions are subject to change without notice. Contact your Sherwin-Williams representative for additional technical data and instructions.

PERFORMANCE TIPS

Mix paint thoroughly to a uniform consistency with slow speed power agitation prior to use.

Stripe coat crevices, welds, and sharp angles to prevent early failure in these areas.

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.

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.

APPLICATION

Refer to the SDS sheet before use

Temperature: 50°F/10°C minimum
120°F/38°C maximum
(Air, surface, and material)
At least 5°F above dew point

Relative humidity: 85% maximum

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 compatible with the existing environmental and application conditions. Excessive reduction of material can affect film build, appearance, and adhesion.

Reducer ..... Water
Clean Up ..... Soap & Water

Airless Spray
Pressure ..... 2400 psi
Hose ..... 1/4"-3/8" ID
Tip ..... .017"-.019"
Filter ..... 60 mesh
Reduction ..... As needed up to 10% by volume

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

Brush
Brush ..... Nylon / polyester
Reduction ..... Not recommended

Roller
Cover ..... 1/4" woven solvent resistant core
Reduction ..... Not recommended

If specific application equipment is not listed above, equivalent equipment may be substituted.

CLEANUP INFORMATION

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 compliant cleanup solvent to prevent rusting of the equipment. Follow manufacturer's safety recommendations when using solvents.

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