



TECHNICAL DATA SHEET – FUTURA-BOND 610 HS

Revised: 05/2018

PRODUCT DESCRIPTION

A high solids, two component, urethane primer with outstanding adhesion to properly prepared steel, ductile iron and galvanized substrates. It is specifically formulated to provide excellent anti-corrosive properties and accept fast-set and standard-set high build polyurethane topcoats.

FEATURES

- Excellent adhesion to aged polyurethane and polyurea coatings.
- Very good chemical resistance.
- High flexibility and impact resistance.
- Prevents undercutting.

RECOMMENDED USES

As a primer for properly prepared steel, ductile iron and galvanized metals prior to the application of GEOTHANE or FUTURA-THANE elastomeric topcoats. As an intercoat primer to bond various topcoats to fast set, standard-set and/or aged polyurethane and polyurea elastomers.

TYPICAL PROPERTIES

SOLIDS BY VOLUME	65% ± 2
VOLATILE ORGANIC COMPOUNDS	1.37 lb/gal (164 g/l)
THEORETICAL COVERAGE	1040 ft ² @ 1 mil (2.48 m ² @ 1 mm)
RECOMMEND DFT (DO NOT EXCEED 3 MILS PER COAT)	1 – 3 mils (25 – 75 µ)
NUMBER OF COATS	1
MIX RATIO (BY VOLUME)	0.6"A" : 1"B"
SHELF LIFE @ 60-90°F (16-32°C)	Part A 12 months Part B 12 months
COLOR	Red

ORDERING INFORMATION

PACKAGING	1 ½ gal
SHIPPING WEIGHT:	11.5 lb/gal (5.2 kg/gal)

FUTURA-BOND 61

EPOXY PRIMER



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SURFACE PREPARATION

Remove all oil, grease or other contaminants from the surface to be coated in accordance with SSPC-SP 1.

Steel and Ductile Iron:

- **Non-Immersion:** Abrasive blast to a Commercial Blast in accordance with SSPC-SP 6 and obtain a 1.5-3 mil (38-70 μ) angular anchor pattern.
- **Immersion:** Abrasive blast to a Near White Blast in accordance with SSPC-SP 10 and obtain a 1.5-3 mil (38-70 μ) angular anchor pattern.
- **Galvanized (New):** Scrub vigorously with a 1:1 mix of MEK/Toluene to remove the residual lubricant inherent to the galvanizing process.
- **Galvanized (Aged):** Remove visible rust by sweep blasting or mechanical cleaning.
- **Other:** Contact ITW Polymers Sealants North America, Inc. for specific recommendations.

MIXING

Power mix each component separately, then combine at a ratio of 0.6“A” to 1 “B” by volume and power mix to a smooth consistency.

THINNING

Thinning may be required. Acetone may be added up to 15% by volume. N. Butyl Acetate may be added up to that allowable by local regulations.

POT LIFE

MATERIAL TEMPERATURE	TIME
60°F (15°C)	1-½ - 2 hrs
75°F (24°C)	1-½ hours
90°F (32°C)	45 minutes

APPLICATION CONDITIONS

	NORMAL	MINIMUM	MAXIMUM
MATERIAL	75-90°F (24-32°C)	65°F (18°C)	100°F (38°C)
SURFACE	75-90°F (24-32°C)	45°F (7°C)	110°F (43°C)
AMBIENT	75-90°F (24-32°C)	45°F (7°C)	110°F (43°C)
HUMIDITY	30-50%	0%	85%

*Surface temperature must be 5°F (3°C) above the dewpoint.

CLEAN UP

Use Acetone, MEK or a 1:1 blend of MEK and Toluene.

APPLICATION EQUIPMENT

PUMP RATIO	30:1 min	TIP SIZE	.015 - .019
MATERIAL HOSE	1/4" ID min 100' max	TIP PRESSURE PSI	1800 - 2400

- **Conventional:** Pressure pot with dual regulators, 3/8" I.D. minimum material hose, .070" fluid tip and appropriate air cap.
- **Roller:** Short to medium nap with phenolic core.

CURE TIME

These times are based on a 30-50% RH. Excessive film thickness, cooler temperatures or inadequate ventilation will require longer cure times and could result in premature failure.

SURFACE TEMPERATURE

	50-69°F (10-21°C)	70-89°F (21-32°C)	90-110°F (32-43°C)
SURFACE DRY	2-18 hours	6-10 hours	4-5 hours
HARD FILM	18-24 hours	10-12 hours	4-6 hours
RECOAT (MIN)	18-24 hours	10-12 hours	4-6 hours
RECOAT (MAX)	24 hours	24 hours	24 hours
FULL CURE	5 days	4 days	3 days

If the material has exceeded its maximum recoat time or full cure time contact ITW Polymers Sealants North America, Inc. for recommended recoating procedures.

SAFETY INFORMATION

- Read the Safety Data Sheet (SDS) and container labels for detailed health and safety information.
- Do not apply material in enclosed areas without adequate air exchange and ventilation.
- All application personnel must use respirators rated for organic vapors, or in confined spaces wear fresh air respirators or fresh air hoods.
- Wear protective clothing, gloves and eye protection.
- Breathing fumes or contact with the skin may cause severe allergic reactions.
- This product contains flammable solvents! Keep away from all sparks, flames and hot surfaces.

This product is intended for industrial use by properly trained professional applicators only.

STORAGE CONDITIONS

Coatings need to be protected from moisture contamination. Store drums and pails in a dry location at 55-80°F (11-27°C). Materials must be kept above 50°F (10°C).

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