TECHNICAL DATA SHEET – FUTURA-BOND 61

Revised: 05/2018

PRODUCT DESCRIPTION

A two-component, phenalkamine-cured epoxy primer formulated to provide outstanding adhesion to concrete, masonry, steel and ductile iron substrates.

FEATURES

- Complies with NSF/ANSI Standard 61
- Convenient 3:1 by volume mixing ratio
- High solids
- Low VOC
- Exceptional adhesion to steel, ductile iron, concrete and masonry
- Brush, spray and roller application

RECOMMENDED USES

Futura-Bond 61 is recommended for use as a primer for fast-set polyurethane, polyurea and hybrid urethane/polyurethane coatings on concrete, masonry, and other recommended surfaces. Futura-Bond 61 primer complies with ANSI/NSF Standard 61 for use as a primer in potable water tanks and pipes with FuturaThane 5061 PW. See the NSF listings to get the up-to-date size/application information, www.nsf.org.

TYPICAL PROPERTIES

SOLIDS BY VOLUME	75% ±2
THEORETICAL COVERAGE	0.37 lb/gal (45 g/l)
RECOMMENDED WFT	
CONCRETE:	1203 ft2 @ 1 mil
STEEL:	(2.8 m2 @ 1 mm)
RECOMMENDED DFT	
CONCRETE:	4.0 – 7.0 mils (100-175 µ)
STEEL:	3.0 – 6.0 mils (75-150 µ)
MIX RATIO (BY VOLUME)	3 “A” : 1 “B”
FLASH POINT (PMCC)	Part A 68° F (20°C) Part B 108° F (42°C)
SHELF LIFE @ 60-90°F (16-32°C)	12 Months
COLOR	Red

TYPICAL SYSTEMS

Please consult the appropriate systems guide, the project specifications or your ITW Sealants North America, Inc. technical representative for proper systems and uses for this product. Systems must be selected considering the particular environment involved.

ORDERING INFORMATION

PACKAGING	1 gal and 4 gal kits
SHIPPING WEIGHT:	11 and 44 lb/kit

FUTURA-BOND 61

EPOXY PRIMER

ITW Polymers Sealants North America

SURFACE PREPARATION

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

- ***Steel:*** Abrasive blast to an SSPC SP-10 Near White Metal Blast in accordance with and obtain a 2.5-3.5 mil (62-88µ) angular anchor pattern.
- ***Concrete:*** Must be cured a minimum of 28 days at 70°F (21°C) and 50% RH, or equivalent. Remove fins and other protrusions by stoning or grinding. Abrasive blast in accordance with NACE No. 6/SSPC-SP 13, ICRI 310.2 CSP 3-5 or ASTM D4258 to open surface voids and remove incompatible curing agents, hardeners, laitance and other foreign materials. Blow or vacuum off abrasive and dust
- ***Concrete Surface Repair:*** Patch or fill all holes, voids corroded or worn areas using RezRok 105 Epoxy Patching Compound.
- ***Galvanizing and Other Miscellaneous Surfaces:*** Contact ITW Polymer Coatings North America for specific recommendations

MIXING

Power mix each component separately, then combine at a ratio of 3 parts "A" to 1 part "B" by volume and power mix to a smooth uniform consistency. Scrape bottom and sides of the container to blend in any unmixed material. Continue mixing until both components are well dispersed – typically a minimum of 3 minutes. Pour into a clean container and mix again for 2 minutes.

NOTE: *It is strongly recommended that mixing be limited to full kits only.*

DO NOT THIN FOR NSF APPLICATIONS. Consult ITW Sealants North America, Inc. for specific reduction recommendations for non-NSF applications.

POT LIFE

MATERIAL TEMPERATURE	TIME
60°F (15°C)	6 hours
75°F (24°C)	3 hours
90°F (32°C)	1 hour

**Listed times are based on one gallon sample. Large batch mixes will produce shorter times.*

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%

**Application to concrete and masonry when the surface temperature is falling will help minimize pinholing caused by outgassing. Surface temperature must be 5°F (3°C) above the dew point.*

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.
- ***Airless:*** Use airless spray followed by back rolling or squeegee to work the primer into pinholes.
- ***Brush:*** Use industrial grade brush suitable for epoxy coatings.
- ***Roller:*** Short to medium nap with high-quality phenolic core, 3/8" to ¾" nap.

NOTE: *Open or porous surfaces can require more material for additional film build.*

CURE TIME

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

SURFACE TEMPERATURE

	50-69°F (10-21°C)	70-89°F (21-32°C)	90-110°F (32-43°C)
SURFACE DRY	10 hours	5 hours	2 hours
HARD FILM	24 hours	12 hours	5 hours
RECOAT (MIN)	24 hours	12 hours	5 hours
RECOAT (MAX)	6 days	72 hours	36 hours
FULL CURE	14 days	7 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 is intended for industrial use by properly trained professional applicators only.

STORAGE CONDITIONS

Store pails in a dry location at 55-90°F (11-32°C).

ITW POLYMERS SEALANTS NORTH AMERICA, INC.
111 S. Nursery Road, Irving, TX 75060 • Tel: +1 972-438-9111
Fax +1 972-554-3939 • info@itwsealants.com • futuracoatings.com