



## TECHNICAL DATA SHEET – FUTURA-BOND 610 HS

Revised: 11/2018

### 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 <sup>2</sup> @ 1 mil (2.48 m <sup>2</sup> @ 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)

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## 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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