

# Endura-Clad Coatings, Inc

## BOND-ALL Metal Bonding Primer

Tintable Primer Sealer for New or Previously Painted Metal Substrates

Distributed by: All From 1 Supply, Inc

### DESCRIPTION AND USES

Bond-All Bonding Primer is an environmentally friendly, high performing 100% acrylic water-based primer. Bond-All provides outstanding adhesion and water resistance when applied to properly prepared surfaces. Bond-All was designed for priming pre-painted metal surfaces, aluminum, steel, galvanized metal and other non-porous surfaces. Bond-All is a low VOC formulation allowing use in states with very stringent VOC requirements.

Bond-All is suitable for use on most metal surfaces. It is also recommended for properly prepared silicone modified polyester (SMP) coated steel. When priming silicone-modified polyester (SMP) use test patches in at least two areas to verify adhesion.

Bond-All is not recommended for below grade applications. Not suitable for porous surfaces. Glossy surfaces should be abraded to improve adhesion. Application to aluminum should be preceded by a solvent wipe to remove oxidation film which could prevent proper adhesion of the coating.

For drywall, wood, masonry, cement composition panels, concrete and other porous non-metal surfaces use Primer X4 - Multi-Purpose Primer & Stain Blocker instead of Bond-All.

When used in exterior applications, Bond-All Bonding Primer can be top-coated with BITMAP, Endura-Crylic or other 100% Acrylic exterior grade paint.

### FEATURES

- **Excellent Metal Bonding Properties Outstanding Adhesion**
- **Good Corrosion Resistance**
- **Superior Water & Moisture Resistance Hi-Solids/Low VOC**
- **Interior/Exterior Surfaces**
- **Very Good Chemical & Solvent Resistance.**

### PRODUCTS

Bond-All Primer is available in white and tinted colors, in 1 and 5 gallon pails.

### PRODUCT APPLICATION

**SURFACE PREPARATION:** Remove dust, dirt, chalk, wax, silicone, polish, grease, oil, flaking paint and other contaminants. Clean with Zap-It Chalk & Grime Buster or other suitable cleaner, rinse and allow to dry. Surfaces must be clean and dry prior to applying Bond-All for proper adhesion. Glossy or smooth hard slick surfaces should be dulled and/or abraded using silicon carbide sandpaper, Scotch-Brite® or other abrading medium to de-gloss and create a surface profile to obtain maximum adhesion.

**WARNING:** Scraping, sanding, or removing old lead-based paints may release lead dust. LEAD IS TOXIC AND LEAD DUST CAN CAUSE SERIOUS ILLNESS, INCLUDING BRAIN DAMAGE, ESPECIALLY IN CHILDREN. Before starting a job where lead paint may be involved contact the National Lead Information Hotline at 1-800-424-LEAD or log on to [www.epa.gov/lead](http://www.epa.gov/lead).

**GENERAL:** Apply Bond-All using conventional, airless or assisted-airless spray, brush or roller.

**CONDITIONS:** 40°F-100°F surface temperature and surrounding air. Do not apply if the application surface or ambient temperature is below 35°F (2°C) or above 110°F (43°C), or if the atmospheric temperature is within 5°F of the dew point. Relative humidity should be below 90%. Don't apply when there is a risk of rain or freezing temperatures within 12 hours after application. Don't apply within 2 hours of sunset if the temperature is below 60 degrees

### PRODUCT APPLICATION (cont.)

**SPREADING RATE:** (@ 3.5 mil wet / 1 mil dry, unreduced): 593 square feet per gallon theoretical with no loss and no reduction.

**RECOMMENDED FILM THICKNESS:** 1 mil (3.5 wet, unreduced).

Adjust accordingly when reducing to insure minimum 1 mil dry. **BARE**

**FERROUS METALS:** Remove rust and scale prior to application.

**GALVANIZED ALUMINUM SURFACES:** All loose, powdery or scaling must be removed. Thoroughly clean all surfaces with Zap-It Chalk & Grime Buster to remove dirt, grease, oil, wax or other foreign matter.

**PAINTED SURFACES:** Be sure all loose and peeling paint is completely removed, and the surface is clean. Remove excess chalkiness by thoroughly cleaning the surface with Zap-It Chalk & Grime Buster. Glossy or smooth hard slick surfaces should be dulled and/or abraded using silicon carbide sandpaper, ScotchBrite® or other abrading medium to de-gloss and create a surface profile to obtain maximum adhesion.

**BARE WOOD, DRYWALL OR MASONRY:** Use Prime X4 instead.

**MIXING:** Mix thoroughly before use and/or after thinning.

**EFFECT OF FREEZING:** Product will not recover from freezing.

**SHELF LIFE:** Six months.

**TINTING:** Bond-All Primer can be tinted with up to 4 ounces of universal colorant

**THINNING:** Ready to spray as packaged, but if thinning is necessary,

use water. Do not overthin; sagging may result. **APPLICATION:** Apply using conventional application methods and equipment. **DRY TIMES** (@ 77°F) 50% RH: **DRY-TO-TOUCH:** 30— 45 minutes; **RECOAT** with Water based coatings: 2 hours; **RECOAT** with solvent based materials: 12 hours. **FULL CURE:** 7-10 days.

**CLEAN-UP:** Clean spills and drips with warm soapy water. Do not allow splatters to dry. Clean applicators, brushes and rollers immediately after use with soapy water. Clean spray equipment immediately after according to manufacturer instructions. Dispose of unused product according to applicable local laws. **SHELF LIFE:** Shelf Life is 3 years from the date of manufacture when stored at temperatures not exceeding 120°F.

### PHYSICAL CHARACTERISTICS:

Weight per gallon:	10.35
% Solids by Weight:	50.03
%Solids by Volume:	37.07
Spread Rate:	593 sq. ft. @ 1 mil
Coating VOC (-water):	.59 lb /gal

### Performance Characteristics:

Chemical resistance @ 72 hrs

Scale 1-5 with 5 showing no effect. Chemical spot test for 4 hours then wiped dry

Gasoline	5
Motor Oil	5
Transmission Fluid	5

7 day Water Submersion Pass

8 Hour Propylene Glycol Pass

Submersion

\*Salt Spray x 230 hrs Pass

Block Resistance 2psi x 1 hr Pass

Direct Impact @ 60" Pass

Indirect Impact @ 60" Pass

Mandrell bend @ 180 degrees Pass

Recoat ability Pass

Storage Test Pass