



**SHERWIN
WILLIAMS.**

Bond-Plex®

Waterbased Acrylic Coating

B71W00211 Extra White, B71T00204 Clear Tint Base, B71S00200 Aluminum

CHARACTERISTICS

Bond-Plex Waterbased Acrylic Coating 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 bonding primer over certain pre-finished siding or other hard, slick, glossy surfaces
- Outstanding application characteristics
- Suitable for use in USDA inspected facilities

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

Finish: 15-25 @ 85° Low Sheen
Aluminum 70° @ 60° Gloss

Color: Many Colors

Recommended Spreading Rate per coat:

(Extra White B71W00211 (may vary by color))

Wet mils: 5.0-10.0
Dry mils: 2.4-4.1
Coverage: 160-328 sq. ft. per gallon
Theoretical Coverage: 657 sq. ft. per gallon @ 1 mil dry

Approximate spreading rates are calculated on volume solids and do not include any application loss.

Note: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.

Drying Schedule @ 5.0 mils wet, @ 50% RH:

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

	@50°F	@77°F	@120°F
To touch	1.5 hours	45 minutes	20 minutes
Tack free	6 hours	4 hours	2 hours
To recoats	8 hours	4 hours	2 hours

Tinting with CCE only:

Base	oz. per gallon	Strength
Extra White	0-4	SherColor
Deep Base	10-12	SherColor

Do Not Tint Aluminum

Extra White B71W00211

(may vary by color)

V.O.C. (less exempt solvents):

less than 50 grams per litre; 0.42 lbs. per gallon

Aluminum 102 grams per litre; 0.85 lbs. per gallon

As per 40 CFR 59.406

Volume Solids: 39 ±2%

Weight Solids: 55 ±2%

Weight per Gallon: 10.90 lbs

Flash Point: N/A

Vehicle Type: Acrylic

Shelf Life: 36 months, unopened

Aluminum 12 months

COMPLIANCE

As of 12/19/2022, Complies with:

OTC	Yes
OTC Phase II	Yes
S.C.A.Q.M.D.	Yes
CARB	Yes
CARB SCM 2007	Yes
CARB SCM 2020	Yes
Canada	Yes
LEED® v4 & v4.1 Emissions	No
LEED® v4 & v4.1 V.O.C.	Yes
EPD-NSF® Certified	No
MIR-Manufacturer Inventory	No
MPI®	No

APPLICATION

Temperature:
minimum 50°F / 10°C
maximum 120°F / 49°C
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.

Reducer: Water

Airless Spray:

Pressure 2400 p.s.i.

Hose 1/4-3/8 inch I.D.

Tip .017-.019 inch

Filter 60 mesh

Conventional Spray:

Gun Binks 95

Fluid Nozzle 66

Air Nozzle 63 PB

Atomization Pressure 60 p.s.i.

Fluid Pressure 25 p.s.i.

Reduction: As needed up to 10% by volume

Brush: Nylon-polyester

Roller Cover: 1/2 inch woven-small surfaces only

If specific application equipment is listed above, equivalent equipment may be substituted. Consult spray manufacturer for more information on equipment variations.

Apply paint at the recommended film thickness and spreading rate as indicated. 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 loss during mixing, spillage, over thinning, climatic conditions, and excessive film build.

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 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.

SPECIFICATIONS

Pre-Finished Siding: Fluorocarbon, Silicone

Polyester, Polyester Polymers:

1-2 coats Bond-Plex Waterbased Acrylic

Previously Painted, Hard, Slick, Glossy

Surfaces:

1-2 coats Bond-Plex Waterbased Acrylic

Pre-Finished Siding: Fluorocarbon, Silicone

Polyester, Polyester Polymers:

1 coat Bond-Plex Waterbased Acrylic

1-2 coats of Acceptable topcoat

Previously Painted, Hard, Slick, Glossy

Surfaces:

1 coat Bond-Plex Waterbased Acrylic

1-2 coats of Acceptable topcoat

Acceptable Topcoats:

- Pro Industrial Acrylic
- Pro Industrial DTM Primer/Finish
- Pro Industrial Multi-Surface Acrylic
- Pro Industrial Waterbased Acrolon 100
- Pro Industrial Waterbased Alkyd Urethane Enamel
- Pro Industrial Pre-Catalyzed Waterbased Urethane

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.

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SURFACE PREPARATION

WARNING! If you scrape, sand or remove old paint, you may release lead dust. LEAD IS TOXIC. EXPOSURE TO LEAD DUST CAN CAUSE SERIOUS ILLNESS, SUCH AS BRAIN DAMAGE, ESPECIALLY IN CHILDREN. PREGNANT WOMEN SHOULD ALSO AVOID EXPOSURE. Wear a NIOSH-approved respirator to control lead exposure. Clean up carefully with a HEPA vacuum and a wet mop. Before you start, find out how to protect yourself and your family by contacting the National Lead Information Hotline at 1-800-424-LEAD or log on to www.epa.gov/lead.

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.

Remove all surface contamination by washing with an appropriate cleaner, rinse thoroughly and allow to dry. Existing peeled or checked paint should be scraped and sanded to a sound surface. Glossy surfaces should be sanded dull. Stains from water, smoke, ink, pencil, grease, etc. should be sealed with the appropriate primer-sealer. Recognize that any surface preparation short of total removal of the old coating may compromise the service length of the system.

Pre-Finished Siding Fluorocarbon, Silicone 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 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 Surface:

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.

SURFACE PREPARATION

Mildew:

Prior to attempting to remove mildew, it is always recommended to test any cleaner on a small, inconspicuous area prior to use. Bleach and bleaching type cleaners may damage or discolor existing paint films. Bleach alternative cleaning solutions may be advised.

Mildew may be removed before painting by washing with a solution of 1 part liquid bleach and 3 parts clean water. Apply the solution and scrub the mildewed area. Allow the solution to remain on the surface for 10 minutes. Rinse thoroughly with clean water and allow the surface to dry before painting. Wear protective eyewear, waterproof gloves, and protective clothing. Quickly wash off any of the mixture that comes in contact with your skin. Do not add detergents or ammonia to the bleach-water solution.

PERFORMANCE

B71W00211 Bond-Plex @ 4.0 mils D.F.T.
(unless otherwise noted)

Abrasion Resistance:

Method: ASTM D4060, CS17 Wheel, 1000 cycles, 1kg load
Result: 90.03 mg loss

Adhesion:

Method: ASTM D4541
Result: 1477 p.s.i.

Corrosion Weathering*:

Method: ASTM D5894, 8 cycles
Result: Rating 8.5 for rusting
Rating 10 for blistering

Direct Impact Resistance:

Method: ASTM D2794
Result: greater than 176 inch pound

Dry Heat Resistance:

Method: ASTM D2485
Result: 200°F/93°C

Flexibility:

Method: ASTM D522, 180° bend, 1/4 inch 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*:

Method: ASTM B117, 274 hours
Result: Rating 8 for rusting
Rating 8D for blistering

*1 coat Pro Industrial Pro-Cryl Primer
1 coat Bond-Plex

SAFETY PRECAUTIONS

Before using, carefully read **CAUTIONS** on label.

Refer to the Safety Data Sheets (SDS) 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.

CLEANUP INFORMATION

Clean spills, spatters, hands and tools immediately after use with soap and warm clean water. After cleaning, flush spray equipment with compliant cleanup solvent to prevent rusting of the equipment. Follow manufacturer's safety recommendations when using solvents.

HOTW	12/19/2022	B71W00211	27	45
HOTW	12/19/2022	B71T00204	22	48
HOTW	12/19/2022	B71S00200	21	102