**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 primer over certain pre-finished siding
- Outstanding application characteristics
- Suitable for use in USDA inspected facilities

**For use over properly prepared pre-finished siding:**
- Fluorocarbons (Kynar®)
- Polyester Polymers
- Silicone Polymers

**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:**

<table>
<thead>
<tr>
<th>Color</th>
<th>5.0-10.0</th>
<th>2.0-4.1</th>
</tr>
</thead>
<tbody>
<tr>
<td>Wet mils</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Dry Coverage</td>
<td>160-328 sq.ft per gallon</td>
<td></td>
</tr>
<tr>
<td>Theoretical Coverage</td>
<td>657 sq. ft per gallon</td>
<td>@ 1 mil dry</td>
</tr>
</tbody>
</table>

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

- @ 50°F to 77°F to 120°F
- To touch: 1.5 hrs. 45 minutes 20 minutes
- To handle: 6 hrs. 4 hrs. 2 hrs.
- To recoat: 8 hours 4 hrs. 2 hrs.

**Tinting with CCE:**

<table>
<thead>
<tr>
<th>Base</th>
<th>oz. per gallon</th>
<th>Strength</th>
<th>Extra White</th>
<th>Clear Tint Base</th>
<th>Do Not Tint Aluminum</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>0-4</td>
<td>SherColor</td>
<td>10-12</td>
<td>12-12</td>
<td></td>
</tr>
</tbody>
</table>

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

- less than 50 grams per litre; 0.42 lbs. per gallon
- Aluminium 97 grams per litre; 0.81 lbs. per gallon

**Storage:**

- As per 40 CFR 59.406

<table>
<thead>
<tr>
<th>Volume Solids:</th>
<th>41 ± 2%</th>
</tr>
</thead>
<tbody>
<tr>
<td>Weight Solids:</td>
<td>55 ± 2%</td>
</tr>
<tr>
<td>Weight per Gallon:</td>
<td>10.90 lb</td>
</tr>
<tr>
<td>Flash Point:</td>
<td>N/A</td>
</tr>
<tr>
<td>Vehicle Type:</td>
<td>Acrylic</td>
</tr>
<tr>
<td>Shelf Life:</td>
<td>36 months, unopened</td>
</tr>
</tbody>
</table>

**Application:**

- Temperature: minimum 50°F / 10°C maximum 120°F / 49°C
- Air, surface, and material Relative humidity: at least 5°F above dew point

**Reduction:**
- Water
- Airless Spray:
  - Pressure: 2400 p.s.i.
  - Flow 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:**
- 1/4 inch woven

**Acceptable topcoat:**
- If specific application equipment is listed above, equivalent equipment may be substituted.

**Applying paint:**

- Mix paint thoroughly to a uniform consistency with slow speed power agitation prior to use.
- 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 lost during mixing, spillage, over thinning, climatic conditions, and excessive film build.

**Checking adhesion:**

- 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.

**Acceptable topcoats:**
- Pro Industrial Acrylic
- Pro Industrial DTM Primer/Finish
- Pro Industrial Multi-Surface Acrylic
- Bond-Plex WB Acrylic
- Metalex Semi-Gloss
- Sher-Cryl HPA

### COMPLIANCE

As of 06/29/2020, Complies with:

- OTC
- OTC Phase II
- SCAQMD
- CARB
- CARB SCM 2007
- Canada
- LEED® v4 & v4.1 Emissions
- LEED® v4 & v4.1 V.O.C.
- EPD-NSF® Certified
- MIR-Product Lens Certified
- MPI®

### SPECIFICATIONS

**Pre-Finished Siding:** Fluorocarbon, Silicon polyester, Polyester Polymers:
- 1-2 coats Bond-Plex Waterbased Acrylic
- 1-2 coats Bond-Plex Waterbased Acrylic

**Previously Painted, Hard, Slick or Glossy Surfaces:**
- 1-2 coats Bond-Plex Waterbased Acrylic
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The systems listed above are representative of the product's use, other systems may be appropriate.

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### Bond-Plex
Waterbased Acrylic Coating

#### SURFACE PREPARATION

**WARNING!** Removal of old paint by sanding, scraping or other means may generate dust or fumes that contain lead. Exposure to lead dust or fumes may cause brain damage or other adverse health effects, especially in children or pregnant women. Controlling exposure to lead or other hazardous substances requires the use of proper protective equipment, such as a properly fitted respirator (NIOSH approved) and proper containment and cleanup. For more information, call the National Lead Information Center at 1-800-424-LEAD (in US) or contact your local health authority.

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.

**Previously Painted Surfaces** - 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.

### PERFORMANCE

#### Abrasion Resistance:

<table>
<thead>
<tr>
<th>Method</th>
<th>Results</th>
</tr>
</thead>
<tbody>
<tr>
<td>ASTM D4060, CS17, wheel, 1000 cycles</td>
<td>1 kg load 90.03 mg loss</td>
</tr>
</tbody>
</table>

#### Adhesion:

<table>
<thead>
<tr>
<th>Method</th>
<th>Results</th>
</tr>
</thead>
<tbody>
<tr>
<td>ASTM D4541</td>
<td>1477 p.s.i.</td>
</tr>
</tbody>
</table>

#### Corrosion Weathering:

<table>
<thead>
<tr>
<th>Method</th>
<th>Results</th>
</tr>
</thead>
<tbody>
<tr>
<td>ASTM D5894, 5 cycle</td>
<td>Rating 8.5 for rusting; Rating 10 for blistering</td>
</tr>
</tbody>
</table>

#### Direct Impact Resistance:

<table>
<thead>
<tr>
<th>Method</th>
<th>Results</th>
</tr>
</thead>
<tbody>
<tr>
<td>ASTM D2794</td>
<td>greater than 176 in. lb</td>
</tr>
</tbody>
</table>

#### Dry Heat Resistance:

<table>
<thead>
<tr>
<th>Method</th>
<th>Results</th>
</tr>
</thead>
<tbody>
<tr>
<td>ASTM D2485</td>
<td>200°F/93°C</td>
</tr>
</tbody>
</table>

#### Flexibility:

<table>
<thead>
<tr>
<th>Method</th>
<th>Results</th>
</tr>
</thead>
<tbody>
<tr>
<td>ASTM D522, 180° bend, 1/4&quot; mandrel</td>
<td>Pass</td>
</tr>
</tbody>
</table>

#### Humidity Resistance:

<table>
<thead>
<tr>
<th>Method</th>
<th>Results</th>
</tr>
</thead>
<tbody>
<tr>
<td>ASTM D4585, 1443 Hours</td>
<td>Rating 10 for rusting; Rating 10 for blistering</td>
</tr>
</tbody>
</table>

#### Pencil Hardness:

<table>
<thead>
<tr>
<th>Method</th>
<th>Results</th>
</tr>
</thead>
<tbody>
<tr>
<td>ASTM D3563</td>
<td>1.5B</td>
</tr>
</tbody>
</table>

#### Salt Fog Resistance:

<table>
<thead>
<tr>
<th>Method</th>
<th>Results</th>
</tr>
</thead>
<tbody>
<tr>
<td>ASTM B117, 274 hours</td>
<td>Rating 8 per for rusting; Rating 8D for blistering</td>
</tr>
</tbody>
</table>

#### CAUTIONS

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 water. Apply the solution and scrub the mildewed area. Allow the solution to remain on the surface for 10 minutes. Rinse thoroughly with 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.

### CLEANUP INFORMATION

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

### 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.

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1 with 1 coat Pro-Cryl & 1 coat Bond-Plex

The information and recommendations set forth in this Product Data Sheet are based upon tests conducted by or on behalf of The Sherwin-Williams Company. Such information and recommendations set forth herein are subject to change and pertain to the product offered at the time of publication. Consult your Sherwin-Williams representative or visit www.paintdocs.com to obtain the most current version of the PDS and/or an SDS.