

technical data sheet

## marathon primabond II

1. Identification of Product	
Product code:	9311-X-XXXX
Product Description:	Two pack etch primer
Features:	Excellent adhesion Direct to galvanised surfaces Long pot life Thin film Overcoat with most paints
Recommended use:	Galvanised/metallic sprayed surfaces Aluminium Other difficult substrates that require high adhesion properties

2. Product Information				
Film thickness range and coverage:		Dry film thickness	Wet film thickness	Theoretical coverage
	Typical	20 µm	50 µm	-
	Maximum	25 µm	62 µm	-
Weld through operation apply 12 – 15 microns				
Spraying viscosity:	Up to 15% thinners			
Spraying equipment:	Conventional	: 1.4 - 1.8mm tip @ 3.5 – 4.2 bar		
	Suction feed HVLP	: 1.8mm tip @ 0.7 bar (max)		
	Pressure pot HVLP	: 1.0 - 1.4 mm tip @ 0.7 bar		
	Airless	: 11 - 21 thou		
	Air assisted airless	: 11 - 15 thou		
	Electrostatic	: On request to equipment manufacturers recommendations		
Colours:	Various			
Finish:	Matt			
VOC:	Typically 670 grams/litre			
Coverage capacity:	Approximately 10 – 12 sq metres per litre @ 20µ DFT			
Pack Availability:	5 litre cans & 20 litre pails			
Specific gravity:	Typically 1.1			
Storage conditions:	2 years, in an unopened, original container from date of manufacture. Storage should be in accordance with the instructions in section 7 of the relevant MSDS			
Health and Safety:	Observe advice given both in Health & Safety Data and on the container. Product contains a small amount of phosphoric acid. Wear suitable goggles, face masks and gloves. Before using this product, read the label on the can and refer to Safety Data Sheet Marathon Primabond II.			
Surface preparation:	Aluminium, galvanised & Mild steel: Surfaces must be clean, dry and free from dust, grease, oil, millscale, etc. For best results blast clean to SA2.			
Mixing:	Must be mixed thoroughly by using a mechanical agitator before use. Agitate periodically to ensure paint remains homogeneous.			

### 3. Application Information.

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Film thickness and spreading rate:	Recommended film thicknesses		Theoretical coverage		
	Dry	Wet			
	Minimum: 25 Maximum: 75 Typical: 50	Minimum: 63 Maximum: 185 Typical: 125	Minimum: 16 Maximum: 12 Typical: 8		
Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated.					
Drying/ Overcoating Times:	Applied to 60 microns DFT		+20°C	+23°C	+35°C
	Touch dry:		10-15 Minutes	-	-
	Hard dry:		up to 6 hours (dependent on conditions)	-	-
	Force dry:	Flash off for 10-15 minutes then stove between 60-80 °C for 30 mins			
	Overcoating:	Over coat after 12 hrs, preferably overnight (times dependent on conditions, can be force dried to reduce over coating times)			
Drying times:	Practical drying times may vary to those stated. A significant difference in substrate temperature compared to ambient temperature may affect the drying characteristics of the coating, as will factors such as inconsistent ambient temperature, air flow and relative humidity.				
Mixing:	Must be mixed thoroughly by using a mechanical agitator before use. Agitate periodically to ensure paint remains homogeneous.				
Thinner/Cleaner:	Not required				
Equipment cleaner:	Not required				

This information is given in good faith for the guidance of users but without warranty or liability. Any queries should be referred to our Technical Department. The above information, based on laboratory tests and practical experience has been proved valid at the date marked on the product data sheet. When necessary verify the validity of the product data sheet. The quality of the product is ensured by our operational system, based on the requirements of the standards ISO 9001. As a manufacturer we cannot be responsible for any damages caused by using the product against our instructions or for inappropriate purposes. This product is for professional use only

**DISTRIBUTED BY:**

Elmbridge Supplies Company UK Ltd

Unit 20 | Spinnaker Road | Hempsted | Gloucester | GL2 5FD

T: 01452 525757 | F: 01452 300312 |

E: sales@elmbridgesuppliesuk.com | W: www.elmbridgesuppliesuk.com

