

BONDERITE O-PC 100

January 2019

PRODUCT DESCRIPTION

BONDERITE O-PC 100 provides the following product characteristics:

Technology	Organic Coating
Product Type	Water-based Anti-corrosion Coating
Application	On Metals

BONDERITE O-PC 100 is based on a copolymer of vinyl acrylic, and polyvinylidene chloride plus a combination of carbon black pigment, fillers and an anti-corrosive pigment.

BONDERITE O-PC 100 is a water based coating of exceptional corrosion protection.

When applied at 30 to 70 microns over zinc phosphate pretreated metal or over shot blasted steel substrates, corrosion protection of 500 to 1,000 hours ASTM B117 can be achieved.

Performance depends on the conditions of each line and substrate and has to be confirmed by initial trial.

BONDERITE O-PC 100 is completely free of lead, and free of toxic chromate anti-corrosive pigments.

BONDERITE O-PC 100 avoids the dangers of fire hazard and harmful solvents as used in solvent based systems.

Application Areas:

BONDERITE O-PC 100 will give an exceptionally high degree of corrosion protection to steel and cast iron.

BONDERITE O-PC 100 is especially suited to the needs of the automotive industry.

Components that cannot withstand the baking processes of powder or electrophoretic coating can meet the highest automotive corrosion tests with this product.

This air dry force dry coating means that expensive stoving processes can be reduced or eliminated.

Makers of rubber-metal anti-vibration mountings, components with temperature sensitive seals such as propeller shafts, steering racks, shock absorbers etc. will all benefit from BONDERITE O-PC 100.

TECHNICAL DATA

Color	black
Solids, % w/w	55.0
Specific Gravity	1.37

Theoretical coverage at 50 microns DFT, m ² /L	7.7
Supply Viscosity BS B4 cup at 25 °C, sec	29 to 33

DIRECTIONS FOR USE

Preliminary Statement:

Prior to use it is necessary to read the **Material Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.

Application:

- Stir well before use.
- BONDERITE O-PC 100 can be applied by conventional pneumatic spray and by dipping.
- Use as supplied for maximum corrosion protection.
- Dilute approximately 10 % with demineralized water to reduce the film build to approximately 25 microns dry film thickness.

Caution:

Addition of more than 10 % water will rapidly over thin this product.

Steel surfaces should be free of grease, dirt and rust. For maximum performance apply over a light zinc phosphate surface (approximately 2 g/m²) or on shot blast steel, blast to Swedish standard Sa 2½.

Drying:

BONDERITE O-PC 100 is supplied as an air dry/force dry product. It is best dried at 50 to 80 °C for 20 minutes at metal temperature.

A flash off time of at least 10 minutes is required where force drying is used.

BONDERITE O-PC 100 has a minimum film forming temperature of 10 °C.

It is advisable to ensure a minimum ambient temperature of 15 °C however, or uneven appearance (greying of the film) may occur.

Alternatively BONDERITE O-PC 100 responds well to infra red heating, when drying is achieved in around 5 minutes.

Post hardening for a further 7 days will provide the coating's full resistance.

Do not overbake BONDERITE O-PC 100.

Air drying to handle is achieved normally in 30 to 60 minutes depending on film thickness applied, temperature and relative humidity.

Remarks:

Most paints thicken on standing. BONDERITE O-PC 100 is manufactured to the viscosity specification of 29 to 33 sec. BS B4 cup at 25 °C.



However, on standing the viscosity will increase. The product must always be mixed prior to use, preferably by stirring.

The longer the product is mixed, the closer to the original viscosity it will become.

The increase in viscosity will also be minimized by correct stock rotation.

If, after stirring, the viscosity is still too high for use, the product may be thinned by the addition of a small quantity of water.

Classification:

Please refer to the corresponding **Material Safety Data Sheets** for details on:

Hazards identification

Transport information

Regulatory information

Storage:

Recommended Storage Temperature, °C	>5
Shelf life, months (in unopened original packaging)	24

ADDITIONAL INFORMATION

Disclaimer

Note:

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

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Reference 0.3