



# TECHNICAL DATA

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## FUTURA-BOND 610 HS LOW VOC URETHANE PRIMER

### Product Description

A high solids, two component, urethane primer with outstanding adhesion to properly prepared steel, ductile iron and galvanized substrates. It is specifically formulated to provide excellent anti-corrosive properties and accept fast-set and standard-set high build polyurethane topcoats.

### Features

- Excellent adhesion to aged polyurethane and polyurea coatings.
- Very good chemical resistance.
- High flexibility and impact resistance.
- Prevents undercutting.

### Recommended Uses

As a primer for properly prepared steel, ductile iron and galvanized metals prior to the application of GEOTHANE or FUTURA-THANE elastomeric topcoats. As an intercoat primer to bond various topcoats to fast-set, standard-set and/or aged polyurethane and polyurea elastomers.

### Typical Properties

<b>Solids by Volume</b>	65% ± 2
<b>Volatile Organic Compounds</b>	0.83 lb/gal (99 g/l)
<b>Theoretical Coverage</b>	1040 ft <sup>2</sup> @ 1 mil (2.48 m <sup>2</sup> @ 1 mm)
<b>Recommend DFT</b> (Do not exceed 3 mils per coat)	1 – 3 mils (25 – 75 μ)
<b>Number of Coats</b>	1
<b>Mix Ratio</b> (by volume)	0.6”A” : 1”B”
<b>Shelf Life</b> @ 60-90°F (16-32°C)	Part A 12 months Part B 12 months
<b>Color</b>	Red

### Ordering Information

<b>Packaging:</b>	1 ½ gal & 8 gallon kits
<b>Shipping Weight:</b>	11.5 lb/gal (5.2 kg/gal)

# APPLICATION INFORMATION

## FUTURA-BOND 610 HS

### Surface Preparation

Remove all oil, grease or other contaminants from the surface to be coated in accordance with SSPC-SP 1.

#### **Steel and Ductile Iron:**

**Non-Immersion:** Abrasive blast to a Commercial Blast in accordance with SSPC-SP 6 and obtain a 1.5-3 mil (38-70 μ) angular anchor pattern.

**Immersion:** Abrasive blast to a Near White Blast in accordance with SSPC-SP 10 and obtain a 1.5-3 mil (38-70 μ) angular anchor pattern.

**Galvanized (New):** Scrub vigorously with a 1:1 mix of MEK/Toluene to remove the residual lubricant inherent to the galvanizing process.

**Galvanized (Aged):** Remove visible rust by sweep blasting or mechanical cleaning.

**Other:** Contact ITW Futura Coatings for specific recommendations.

### Mixing

Power mix each component separately, then combine at a ratio of 0.6“A” to 1 “B” by volume and power mix to a smooth consistency.

### Thinning

Thinning may be required. Acetone may be added up to 15% by volume. N. Butyl Acetate may be added up to that allowable by local regulations.

### Pot Life

Material Temperature	Time
60°F (15°C)	1 ½ - 2 hrs
75°F (24°C)	1 ½ hours
90°F (32°C)	45 minutes

### Application Conditions

	Normal	Minimum	Maximum
<b>Material</b>	75-90°F (24-32°C)	65°F (18°C)	100°F (38°C)
<b>Surface</b>	75-90°F (24-32°C)	45°F (7°C)	110°F (43°C)
<b>Ambient</b>	75-90°F (24-32°C)	45°F (7°C)	110°F (43°C)
<b>Humidity</b>	30-50%	0%	85%

Surface temperature must be 5°F (3°C) above the dew point.

### Clean Up

Use Acetone, MEK or a 1:1 blend of MEK and Toluene.

### Application Equipment

#### **Airless:**

Pump Ratio	30:1 min	Tip Size	.018 - .021"
Material Hose	3/8" ID min 100' max	Tip Pressure psi	2500 - 2800

**Conventional:** Pressure pot with dual regulators, 3/8" I.D. minimum material hose, .070" fluid tip and appropriate air cap.

**Roller:** Short to medium nap with phenolic core.

### Cure Time

These times are based on a 30-50% RH. Excessive film thickness, cooler temperatures or inadequate ventilation will require longer cure times and could result in premature failure.

#### Surface Temperature

	50-69°F (10-21°C)	70-89°F (21-32°C)	90-110°F (32-43°C)
<b>Surface dry</b>	12-18 hours	6-10 hours	3-5 hours
<b>Hard Film</b>	18-24 hours	10-12 hours	4-6 hours
<b>Recoat (min)</b>	18-24 hours	10-12 hours	4-6 hours
<b>Recoat (max)</b>	24 hrs	24 hours	24 hours
<b>Full cure</b>	5 days	4 days	3 days

- If the material has exceeded its maximum recoat time or full cure time contact ITW Futura Coatings for recommended recoating procedures.

### Safety Information

- Read the Material Safety Data Sheet (MSDS) and container labels for detailed health and safety information.
- Do not apply material in enclosed areas without adequate air exchange and ventilation.
- All application personnel must use respirators rated for organic vapors, or in confined spaces wear fresh air respirators or fresh air hoods.
- Wear protective clothing, gloves and eye protection.
- Breathing fumes or contact with the skin may cause severe allergic reactions.
- This product contains flammable solvents! Keep away from all sparks, flames and hot surfaces.
- **This product is intended for industrial use by properly trained professional applicators only.**

### Storage Conditions

- Coatings need to be protected from moisture contamination. Store drums and pails in a dry location at 55-80°F (11-27°C).
- Materials must be kept above 50°F (10°C).

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