



# TECHNICAL DATA

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## FUTURA-BOND 415 WATER-BORNE EPOXY PRIMER

### Product Description

A two component, water-borne epoxy primer with outstanding adhesion to most concrete, masonry, and wood surfaces, including damp concrete.

### Features

- Convenient 1:1 mixing ratio.
- High solids.
- Low VOC.
- Low Odor.
- Water Borne technology.
- Exceptional adhesion to damp concrete and masonry.
- Excellent for applications on wood which may contain more than trace levels of moisture.
- Spray and roller application.

### Recommended Uses

As a primer for concrete, masonry, wood and other recommended surfaces prior to the application of polyurethane and polyurea products.

### Typical Properties

<b>Solids by Volume</b>	70% ±2
<b>Volatile Organic Compounds</b>	0.7 lb/gal (84 g/l)
Thinned 10% with Isopropyl Alcohol	1.4 lb/gal (162 g/l)
Thinned 15% with Isopropyl Alcohol	1.6 lb/gal (196 g/l)
<b>Theoretical Coverage @ 70% (SBV)</b>	1123 ft <sup>2</sup> @ 1 mil (2.7 m <sup>2</sup> @ 1 mm)
<b>Recommend DFT</b>	2 – 5 mils (50 – 100 μ)
<b>Number of Coats</b>	Normally 1
<b>Mix Ratio</b> (by volume)	1 "A" : 1 "B"
<b>Flash Point</b> (PMCC)	Part A 53° F (12°C) Part B >200 °F (93°C)
<b>Shelf Life @ 60-90°F (16-32°C)</b>	12 months
<b>Color</b>	Yellow (only)

### Ordering Information

<b>Packaging:</b>	2 gal & 10 gal kits
<b>Shipping Weight:</b>	11 lb/gal (5 kg/gal)

# APPLICATION INFORMATION FUTURA-BOND 415

## Surface Preparation

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

**Concrete:** Must be cured a minimum of 28 days at 70°F (21°C) and 50% RH, or equivalent. Remove fins and other protrusions by stoning or grinding. Abrasive blast in accordance with SSPC-SP 13 or ASTM D4258 to open all surface voids and remove all form oils, incompatible curing agents, hardeners, laitance, other foreign materials and produce a angular surface texture similar to that of medium grit sandpaper. Blow or vacuum off abrasive and dust. To fill holes, voids and to repair corroded or worn areas use FUTURA-BOND 320 GEL.

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

## Mixing

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

## Thinning

Required for spray applications. Use Isopropyl Alcohol per the following guidelines.

Application	Isopropyl Alcohol	Water*
Squeegee	0-10%	0-10%
Roller / Brush	10%	0-10%
Airless Spray	15%	NR
Conventional Spray	15%	NR

\*Use only in areas where solvents cannot be used, thinning with clean potable water is acceptable but will require longer cure times.

## Pot Life

Material Temperature	No Thinner	Thinned 15% with Isopropyl Alcohol
60°F (15°C)	2 hrs	2 ½ hrs
75°F (24°C)	80 min	2 hrs
90°F (32°C)	30 min	50 min

Listed times are based on a lab sample. Batch mixes may produce shorter times.

## 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%

Note: Application to concrete and masonry when the surface temperature is falling and not rising will help minimize pinholing caused by outgassing. Use airless spray followed by back rolling or squeegee to work the primer into pinholes.

## Application Equipment

### **Airless:**

Pump Ratio	30:1 min	Tip Size	.024 - .031"
Material Hose	3/8" ID min 100' max	Tip Pressure psi	2800 - 3600

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

**Brush:** Use industrial grade brush suitable for water borne coatings.

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

## Clean Up

Use Isopropyl Alcohol.

## Cure Time

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

	<u>Surface Temperature</u>		
	50-69°F (10-21°C)	70-89°F (21-32°C)	90-110°F (32-43°C)
<b>Surface dry</b>	7 hours	3 ½ hours	2 hours
<b>Hard Film</b>	24 hours	8 hours	5 hours
<b>Recoat (min)</b>	20 hours	6 hours	4 ½ hours
<b>Recoat (max)</b>	48 hrs	24 hours	16 hours
<b>Full cure</b>	6 days	72 hours	48 hours

- 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 is intended for industrial use by properly trained professional applicators only.**

## Storage Conditions

- Store drums and pails in a dry location at 55-90°F (11-32°C).
- Materials **must** be kept above 50°F (10°C).
- DO NOT ALLOW TO FREEZE.**

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