

## PROTEGABOND ST200

### DESCRIPTION

A two component, high solids, surface tolerant epoxy aluminium primer.

### PRODUCT FEATURES AND RECOMMENDED USES

- ◆ Approved to Highways Agency (Item 115) and Network Rail (Item 7.1.5) requirements.
- ◆ EPA compliant as a primer.
- ◆ Used for upgrading a system from conventional to epoxy, vinyl, chlorinated rubber or polyurethane.
- ◆ Suitable for blast cleaned or hand prepared steel, providing excellent substrate "wetting" properties.
- ◆ When applied as a patch coat, can overlap aged chlorinated rubber, vinyl or alkyd.
- ◆ Good chemical and solvent resistance, with high film build from brush or spray.
- ◆ One to one mix ratio, both components structured for easy mixing.
- ◆ Can be used as a single coat under insulation.
- ◆ Used as a primer coat with ProtegaBond WG500 or WG600 series epoxy intermediate/finish to provide 220 microns in two coats.

### TECHNICAL DATA

**Volume solids** 80 ± 2% mixed. (ISO 3233)

**Weight solids** 87 ± 2% mixed.

**Specific gravity** 1.28 – 1.32 mixed.

**Product code**

Paint	1 part by volume	3332 001
Activator	1 part by volume	4056 006
Composite		4853 001

**Pot life** 2 hours @ 23°C.

### Recommended film thicknesses and theoretical coverage

Recommended film thicknesses		Theoretical coverage
dry	wet	
125 µm	157 µm	6.4 m <sup>2</sup> /l
200 µm	250 µm	4.0 m <sup>2</sup> /l

Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated.

### Drying time

DFT 125 µm		+10°C	+23°C	+35°C
Dust Free		10 h	4 h	2 h
Hard Dry		24 h	16 h	8 h
Overcoating	min	*see Product Notes	*24 h	*16 h
	max	*Indefinite		

Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation.

\*Refer to Product Notes over.

**Finish** Semi-gloss

**Colours** Dark Aluminium.

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## APPLICATION DETAILS

### Surface preparation

Degrease steel where necessary to SSPC-SP1 solvent cleaning to remove weld flux and general contamination prior to blasting. All sharp edges should be ground and weld spatter removed. Blast clean to Swedish Standard SIS 05 5900 Sa 2½ or British Standard 7079 equivalent by dry or wet blasting techniques. Maximum profile 75 microns. Should blast cleaning be impractical, degrease according to SSPC-SP1 solvent cleaning and prepare to Swedish Standard St2 minimum, avoid polishing of the surface when using mechanical tools. Can be used as a brush or spray applied primer when water abrasive blast cleaning. Allow to dry before application, and lightly wire brush if powdery rust deposits form. Surfaces should be clean and dry and free from oil, grease, salts, dirt and general contamination.

### Application conditions

Only apply in conditions of good ventilation which must be maintained during drying. Do not apply when rain, mist, sleet or snow are imminent. During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point.

### Mixing

Mix only in the proportions stated, mixing each component individually then together using a mechanical agitator. Ensure complete homogeneity before using.

### Application

Method	Airless Spray	Automatic Spray	Conventional Spray	Brush	Roller
Output Fluid Pressure	2000 – 3000 p.s.i.	No	No	Yes	No
Tip Size	19 – 27 thou				

Refer to Protega Epoxy Application/Curing notes.  
When brush applying to blast cleaned steel, ensure that the product is not brushed off the peaks. Brush application is recommended for St2 surfaces, to 'work' primer into the substrate profile.

### Thinner

1031 Thinner.

### Cleaning of equipment

Remove remaining paint from equipment, flush thoroughly with 950 Thinner until solvent appears uncontaminated.

### FLASH POINT

32 - 55°C

### STORAGE

Store in dry, cool conditions and protect from frost.

### VOC

Volatile Organic Compound content: 173 ± 20 gm/lt

### HEALTH AND SAFETY

Containers are provided with safety labels, which should be observed. Further information about hazardous influences and protection are detailed in individual health and safety data sheets. A health and safety data sheet is available on request from Protega Coatings Ltd.

### PRODUCT NOTES

**\*Overcoating:** Indefinitely overcoatable when clean, sound and free from chalking, when overcoated with itself or other ProtegaBond products.  
When overcoating with **conventional, chlorinated rubber or vinyl**, ideally overcoat between 24-48 hours (at 23°C), absolute maximum 7 days (at 23°C), otherwise abrade.  
When overcoating with **conventional** (e.g. alkyd) products, starting with ProtegaLac AM-series MIO is recommended for good intercoat adhesion.  
For **two pack epoxy or polyurethane** – maximum overcoating time is 3 months (at 23°C). Minimum overcoating time with polyurethane is 24 hours at 23°C.  
Extend minimum drying and overcoating times at lower temperatures and for dft's of ProtegaBond ST200 above 125 microns.  
Whilst the product will not fully cure effectively below 10°C, **overcoating by spray with itself or ProtegaBond WG500 or WG600** after 16 hours at 5°C minimum is acceptable.  
  
Do not apply or cure below 5°C.  
Colour changes can occur in exposed conditions.  
Product will chalk, the degree to which is subject to atmospheric conditions.  
Moisture in the can may cause pressure build up.

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. For professional use only.