

BONNFLOON

BONNFLOON SR (Soil Release)

No.3

Metal Materials Coating System

Standard Specifications of BONNFLOON HB M-15 SR Coating System

[Applicable materials] General structural steel, steel lumber [Applicable category] New construction coating

[Application category] Class 1 scraping

Process	Material to be used	Composition ratio Main agent: Hardener (kg)	Dilution (%)	Standard needed quantity (kg/m ²)	Dried film thickness (μ/time)	Times of coating	Coating interval (23°C)	Coating method
Surface preparation	Class 1 scraping Blasting preparation SSPC-SP 10 (SIS 2.5 or higher)							
Undercoat-1	Bonnzinc #20ZHB (Thick coating film type organic zincrich coat)	22.5 : 2.5	0~4 Exclusively used thinner	0.45	50	1	1 days or more, within 7 days	Airless
Secondary surface preparation	1. Wash the coated surface finished in the factory and remove the adhered saline matter, then dry it completely. 2. For welded parts jointed at the site and undercoat film damaged parts that may cause coat film defectiveness, repairing coating shall be done after thorough surface preparation. 3. The rust generated on the coated surface shall be completely removed with power tools, etc. Fats and oils, dust, etc. shall also be removed by using a thinner or adequate methods.							
Repairing coat	Bonnzinc #20ZHB (Thick coating film type organic zincrich coat)	22.5 : 2.5	0~2 Exclusively used thinner	—	—	(1)	1 day or more, within 7 days	Brush
Undercoat-2	Bonn Epocoat #30HB (Epoxy polymer zinc phosphate based coat)	12.8 : 3.2	0~2 Exclusively used thinner	0.15	30	1	1 day or more, within 7 days	Roller Brush Airless
Intermediate coat	Eporime MC (Epoxy polymer Mica based coat)	11.2 : 4.8	0~2 Exclusively used thinner	0.20	40	1	1 day or more, within 7 days	Roller Brush Airless
Finishing coat-1	Bonnflon #2000 Surfacer (Poly urethane based coat)	15 : 1	30~40 Exclusively used thinner	0.15	30	1	16 hours or more, within 7 days	Roller Brush Airless
Finishing coat-2	Bonnflon #2000SR Topcoat (Fluoropolymer based coat)	12.5 : 2.5	20~30 Bonnflon thinner	0.15	30	1	—	Roller Brush Airless

(Note 1) The needed quantity differs in specifications under special conditions such as seaside and/or chemical environment.

Inorganic zincrich (Bonnzinc #10QC) is also available.

(Note 2) When using shop primers: After the blasting preparation, immediately coat Bonnzinc #20Z by airless spray (0.20 ~0.25kg/m²μ).

Metal Materials Coating System

Standard Specifications of BONNFLOON HB M-30 SR Coating System

[Applicable materials] General structural steel, steel lumber [Applicable category] Recoating at site

[Application category] Class 3 scraping when the old coated surface (active film) remain.

Process	Material to be used	Composition ratio Main agent: Hardener (kg)	Dilution (%)	Standard needed quantity (kg/m ²)	Dried film thickness (μ/time)	Times of coating	Coating interval (23°C)	Coating method
Surface preparation	Class 3 scraping Remove deteriorated film and rust manually or by powered tools (electric sander grinder, scraper, wire wheels, etc.). Scrape the rust generated portions until the steel exposed							
Undercoat	Bonn Epocoat #15MP (Epoxy polymer coat)	12.8 : 3.2	0~5 Exclusively used thinner	0.19~0.25	60	1	16 hours or more, within 7 days	Roller Brush Airless
Intermediate coat-1	Eporime MC (Epoxy polymer mica based coat)	11.2 : 4.8	0~5 Exclusively used thinner	0.19~0.25	50	1	16 hours or more, within 7 days	Roller Brush Airless
Intermediate coat-2	Bonnflon #2000 Surfacer	15 : 1	30~50 Exclusively used thinner	0.13	25	1	16 hours or more, within 7 days	Roller Brush Airless
Finishing coat	Bonnflon #2000SR Topcoat	12.5 : 2.5	20~30 Bonnflon thinner	0.14~0.17	30	1	—	Roller Brush Airless

(Note 1) Bonn Epocoat #15MP can be applied onto the old coated surfaces (active film condition) such as alkyd, polyvinyl, epoxy, urethane based coat

(Note 2) Brushes and rollers can be used as the coating method.

But care should be taken that the dilution ratio and the needed quantity differ from those of airless.