

Metal Materials Coating System

Standard Specifications of BONNFLON HB M-50 SR Coating System

[Applicable materials] Galvanized steel sheet (chemical treated), aluminum (chemical treated), stainless steel, bonderized steel sheet iron
 [Applicable category] Recoating at site [Application category] Newly coating

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	Decreasing, cleaning Remove adhered dust, greases by an appropriate method.							
Undercoat	Bonn Epocoat #30HB (Epoxy polymer zinc phosphate based coat)	12.8 : 3.2	0~5 Exclusively used thinner	0.20	40	1	1 day or more, within 7 days	Roller Brush Airless
Intermediate coat	Bonnflon #2000 Surfacer	15 : 1	30~50 Bonnflon thinner	0.13	25	1	16 hours or more	Roller Brush Airless
Finishing coat	Bonnflon #2000SR Topcoat	12.5 : 2.5	20~30 Bonnflon thinner	0.15	30	1	—	Roller Brush Airless

(Note 1) When coating in locations such as seaside, industrial area and indoor pool where corrosion environment are severe, apply Eporime MC (0.25kg/m², 50μ) on the 2nd layer for 4 layer specifications.

(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.

(Note 3) If the galvanized steel was before 1 year after steel was galvanized, apply Epocoat 35HB instead of Epcoat 30HB Epocoat 35HB (0.3kg/m², 60μ).

Standard Specifications of BONNFLON HB M-60 SR Coating System

[Applicable materials] Galvanized steel sheet (chemical treated), aluminum (chemical treated), stainless steel, bonderized steel sheet iron
 [Applicable category] Recoating at site [Application category] Newly coating

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.) Remains the active films.							
Undercoat	Bonn Epocoat #55MP (Epoxy polymer zinc phosphate based coat)	12.8 : 3.2	0~5 Exclusively used thinner	0.17	40	1	1 day or more, within 7 days	Roller Brush Airless
Intermediate coat	Bonnflon #2000 Surfacer	15 : 1	30~50 Bonnflon thinner	0.13	25	1	16 hours or more	Roller Brush Airless
Finishing coat	Bonnflon #2000SR Topcoat	12.5 : 2.5	20~30 Bonnflon thinner	0.15	30	1	—	Roller Brush Airless

(Note 1) When coating in locations such as seaside, industrial area and indoor pool where corrosion environment are severe, apply Eporime MC (0.25kg/m², 50μ) on the 2nd layer for 4 layer specifications.

(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.

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