

# APPLICATION GUIDE



## ROKOAT TechShield Bonding Primer

### Overview

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This is designed for Professional and non professional use.

ROKOAT reserves the right to remove all warranties and guarantees on this product if not applied according to this guide.

### Safety Notes

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Use in well ventilated areas. Use vapour filters on masks.

Protective gloves and safety glasses must be worn at all times.

Health, safety and environmental information are provided for this product in the Materials Safety Data Sheet (MSDS). This gives details of potential hazards, precautions and First Aid measures, together with environmental effects and disposal of used products.

### Application Methods

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Brush / Roller

Spray

Micro-Fibre

Applicator Pad

### Surface Preparation

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Although the unique properties of ROKOAT TechShield Bonding Primer enables it to bond almost anything to almost any substrate, it is always preferable where possible, to ensure the application surface is clean, dry and free from oils and other contaminants.

Where possible, for metal alloy and composite substrate surfaces, create a light profile (through sanding) aiding in the physical bond.

Mask-up and / or protect surfaces that are NOT to be treated. TechShield Bonding Primer has extreme adhesion properties and will require a high level of abrasive to remove.

### Product Preparation

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Gentle agitate the product.

\* DO NOT use thinners.

### Application Methodology

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Spray using a fine tip (0.08) or similar applying 2 – 3  $\mu\text{m}$ .  
Brush / Roll or wipe ensuring a thin, even coverage.

Apply top or final coating within 3 minutes – wet on wet is preferable.

\* For example, if spraying, one person can spray ROKOAT TechShield Bonding Primer closely followed behind by a second spray person applying the final coat (paint / ROKOAT product etc.)

If TechShield Bonding Primer dries, simply reapply lightly which will cause the surface to open.

TechShield Bonding Primer can be applied to substrates where concerns around adhesion exist. I.e. Silicone, hard anodizing processes etc.

TechShield Bonding Primer can be used over any cured ROKOAT product enabling recoating due to damage.

NOTE : Any overspray and equipment must be cleaned immediately with acetone, toluene, xylene or MEK.

## Curing & Secondary Coatings

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N/A

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## Properties

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<b>Colour</b>	Colourless liquid
<b>Viscosity</b>	1.0 cps@23°C (74°F) (ASTM D1084B)
<b>Percent of Solids</b>	<38%
<b>Odour (liquid)</b>	Slight Solvent
<b>Odour (cured)</b>	NONE
<b>V.O.C.</b>	Exempt per CFR 51.1 / regulation 8
<b>RoHS</b>	Compliant
<b>REACH</b>	Compliant
<b>Thermal Stability (cured)</b>	<648.8°C (1200°F)
<b>Conical Bond (0.3175 cm mandrel)</b>	Passed (ASTM D522-93a)
<b>Crosscut adhesion</b>	5B (ASTM D3359)
<b>Specific Gravity</b>	0.810 (ASTM D891-09)
<b>Average applied dry film thickness</b>	1 to 3 µm
<b>Estimated Coverage Rate (3 µm)</b>	130 m <sup>2</sup> / L (5160 sq feet / US Gallon)
<b>Dry time before top coat (@ Ambient 18-21°C)</b>	5-10 minutes (average)
<b>Dry time (time @ 49°C)</b>	30 seconds
<b>Cleaning</b>	Acetone, Toluene, Xylene or MEK

## ASTM Test Battery

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