



P O BOX 8323  
HALFWAY HOUSE 1685  
TEL: +27 (011) 728-7415  
FAX: +27 (011) 728-0691

## **SOLID MEGA BOND 3 in 1**

### **GENERAL INTRODUCTION**

Solid Mega Bond 3 in 1 finish paint is available in a high quality range of quick drying colours. Solid Mega Bond 3 in 1 is a self priming, high gloss finish which takes the place of primer, under coat and top coat, to give excellent corrosion protection. An attractive pattern is produced which gives the effect of metal when applied by brush or sprayer

### **APPLICATION**

On iron or steel: formulated to give a highly decorative yet corrosion, resistant finish to metalwork, with minimal preparation and painting time. It is suitable for use on interior and exterior iron and steelwork in many different situations including railings, bridges, fire escapes, steel structures, lampposts, furniture and construction equipment. It is particularly good for transforming rusted metal on an attractive finish, which sheds dirt and water.

On wood: Solid Mega Bond's attractive finish particularly good for giving interior wood and medium density fibreboard, the appearance of metal is used as such by the designer council.

On plastic: Solid Mega Bond 3 in 1 may be used on many types of plastic but some experimentation is required to ensure that solvents in the product will not attack the plastic.

Galvanised surfaces and aluminium alloys: may require abrading. Remove dust, apply an appropriate primer. Follow manufacturers instructions carefully.

### **DESCRIPTION**

Solid Mega Bond 3 in 1 is Specially formulated from high quality base resins, pigments and aluminium particles carried by fast drying solvent.

The action of modified silicone and particle metal produces the pattern effect of Solid Mega Bond 3 in 1, which forms as the product dries. Solid Mega Bond 3 in 1 adheres tightly to the surface of the rusted metal to prevent further rust corrosion whilst the lamellar aluminium particles orientate themselves to form a further barrier to moisture penetration. The special resins give the product a gloss, which together with the silicone rich surface helps the finish to resist dirt and water. Solid Mega Bond 3 in 1 finish becomes touch dry in 15 minutes making it ideal for use in areas where the public may soon come into contact with the coated surface.



## PERFORMANCE

Weathering : Excellent

Solid Mega Bond 3 in 1 is especially resistant to weathering. Accelerated corrosion tests such as salt spray to ASTM B117 continuous salt spray, have shown and endured in excess of 1000 hours. These tests involve spraying of a 5% salt solution at a temperature of 35°C. 1000 hours relates to approximately 7 years of exposure to the elements. Performance is related to the degree of preparation of the substrate and quality of painting. Attention is drawn to the minimum thickness, which must be adhered to where corrosion resistance is required.

Impact resistance - Good  
Adhesion - Excellent  
Chemical Resistance - Good

Solid Mega Bond 3 in 1 is resistant to dilute acid and common building materials.

## EXTREME CONDITIONS

Where extreme conditions are encountered the application of Finnegan's No 1 metal primer prior to Solid Mega Bond 3 in 1 will ensure improved protection.

## TECHNICAL DATA

Form of supply	- ready for brush application
Gloss level	- high gloss
Specific gravity	- 1.0
Recommended	
Dry film thickness	- 100 microns, 004
Covering capacity	- 6.9m squared per litre depending on substrate
Temperature resistance	- 300°C to 150°C maximum
Drying time at 20°C	- touch dry 15 minutes - tack free 30 minutes
Flash point	- 150°C
Flash point (thinners)	- non flammable
Shelf life	- minimum 12 months when stored at 20°C

## SITE WORK COSTINGS

Time savings will be significant when compared to conventional painting system where primer, under coat and topcoat are applied. As labour usually represents up to 90% of the cost painting. Solid Mega Bond 3 in 1 can produce significant savings in the cost of the job.

## PLANNING

Painting must be planned so that subsequent coats are applied within one to four hours of the previous coat to ensure multi-coats are applied in the same working day, as after this time, Solid Mega Bond 3 in 1 begins a six week curing period, during which re-coating may result in wrinkles as solvents attack the partially cured coating.



#### SURFACE PREPARATION

Solid Mega Bond 3 in 1 require minimal preparation, however, the following points will provide for improved results.

1. Loose paint and rust should be removed with a wire brush or similar.
2. Bright new metal or smooth painted substrates should be abraded with medium to coarse grado of emery prior to painting.
3. The substrate must be bone dry and free from wax grease and oil.

#### TEMPERATURE AND HUMIDITY

Ideal Solid Mega Bond 3 in 1 should be applied at temperatures between 15°C to 21°C (60°C to 70°C). If the temperature is below 10°C (50°C) the pattern may be poorly defined.

#### BEFORE PAINTING

It is essential that no metal pigment remains settled at the bottom of the container. A thorough stirring is required, shaking is not sufficient.

#### BRUSH APPLICATION

A large brush should be used to cover the area quickly and thickly. The paint should be evened out and excess paint should be removed, but over brushing should be avoided particularly when the paint has started to dry. A film thickness of 1000um is necessary, two generous brush applied coats will ensure freedom pinholes, for applications exposed to elements. It is not recommended to brush large areas where an even finish is required, as it is difficult to maintain a wet edge due to the speed with the product dries. It is suggested that the large panels be laid and have Solid Mega Bond 3 in 1 poured onto them to be quickly spread with a brush. Spraying gives a more even finish than brushing.

#### ROLLER APPLICATION

A roller may be used on large areas when a spray gun is not available. The edges should be brushed and the rest o the area should be filled in, using a cheap plastic roller wit 2 coats 10 minutes apart.

#### THINNING

Solid Mega Bond 3 in 1 should be thinned only with mega bond thinners. The solid bond system requires a viscous product and thinning should be avoided. When the product is being applied from open containers, a drop of solid bond thinners may be added to replace solvent lost by evaporation.

#### SPRAY APPLICATION

Spray application is recommended to give the most oven pattern but will require more coats than by brush, to give the film thickness of 100um (004)

#### AIRLESS SPRAY

Thinning up to 15% by volume may be required, depending on equipment and temperature. Typical details and

Fluid pressure	2500-3000 p.s.i.
Nozzle size	0.013-0.015



#### THINNING

Only solid bond thinners should be used as cellulose or other thinners may cause the product to gel in the gun. Solid Mega Bond 3 in 1 should be thinned with 1 part thinners to 2 parts, by volume, and should be well mixed. The ratio may be adjusted to suit the equipment and temperature. The mixture should be shaken before and during spraying to ensure dispersal of pigment.

#### SPRAYING

2 to 4 thin coats in quick succession should be applied to cover well. The final coat should be heavy to allow to a smooth gloss finish. If an even deeper finish is required, further coats should be applied after 1 hour or with 12 hours.

#### HEALTH AND SAFETY PRECAUTIONS

Flammable : Harmful

Contains Trichlorethylene and Xylene

Harmful by inhalation, in contact with skin and if swallowed

Keep container tightly closed.

In case of contact with eyes, rinse immediately with water.]

Remove splashes from skin with soap and water or a recognised skin cleaner.

Do not breathe vapour/ spray.

In case of insufficient ventilation, wear suitable respiratory equipment.

Keep out of reach of children

#### STORAGE

Solid Mega Bond 3 in 1 should be stored in its original containers in a cool dry place. Like all paint products it should be protected from frost and direct sunlight.

#### PACKAGE SIZE

Solid Mega Bond 3 in 1 – 5Litre Containers

Mega Bond 3 In 1 –400ml Aerosol Spray cans