

IES™ SECURE-BOND II

Solvent Base Urethane Bonding Agent/Primer

For use with INTER-LINER Coatings

Secure-Bond II is a solvent base, moisture cure, bonding agent used to increase adhesion between INTER-LINER coatings and various other substrates, including: properly prepared; steel, galvanized steel, aluminum, painted / primed surfaces, PVC, EDM, wood and concrete.

Secure-Bond II can be used to increase the bond between layers of aromatic/aliphatic polyurethane bedliner type coatings (example: spraying new bedliner over an existing, aged bedliner)

Secure-Bond II is a ready to use product. Do not thin further as optimal adhesion will be compromised. May be applied using a brush, roller or one-component spray equipment. Use appropriated safety equipment when applying this product.

Directions

1. Thoroughly clean all surfaces with soap and water using a stiff brush then rinse with clean water. Repeat if necessary.
2. Thoroughly dry all surfaces to be coated. If any moisture is left in seams or cracks you will run into foaming and blistering problems. Any previous applied coatings or liners that have areas that are damaged and may be lifting or peeling, those areas need to be removed and the edges cut back and beveled. If coating over an existing bed-liner bevel all edges of the existing bedliner, this will help to hide the old bedliner and leave nice clean edges on the new bedliner.
3. Mask all areas that don't need to be sprayed, using wire trim tape where appropriate. When coating over an existing bed-liner, be sure to mask a 1/8 inch to 1/4 inch past the edge of the old bed-liner to hide the old bed-liner edge and insure a good bond at the edge of the new bed-liner.
4. Using a clean cloth apply IES #1700 or IES 1780 solvent base cleaner to remove any waxes or silicones that may be still on the surface.
5. Existing coatings will need to be sanded (120 to 180 grit sandpaper) to remove any oxidation and to roughen the surface. Any damaged areas need to be feathered out, otherwise the edges of the damaged area will show through in the new coating. If the damaged area is extreme it may need to apply Inter-Liner Repair compound to the area and feather.
6. Use compressed air or a vacuum to remove the dust and debris from the surfaces. Wipe surface again with IES #1700 or IES 1780 solvent base cleaner to remove any surface debris.
7. The surfaces can now be coated with Secure Bond II Bonding agent. Shake the container or stir for 30 seconds. Apply a thin coat with a brush, roller or standard automotive paint gun. Please allow 30 to 45 minutes for the bonding agent to cure, or when the surface is tack-free. A thicker coating may require additional time to cure. Secure-Bond II must be coated within 4 hours to insure optimal adhesion.
8. You are now ready to apply the new INTER-LINER Coating.

NOTE: When spraying, air-supplied respirators must be used. To avoid breathing vapors when brushing or rolling, use an organic vapor particulate approved NIOSH/MSHA respirator in a proper, well ventilated area.

Typical Properties*

| Property | Value |
|--------------------------|---------------------|
| Viscosity at 25°C, mPas | 18 |
| Specific Gravity at 25°C | 0.88 |
| Flash Point, PMCC | 20°C (68°F) |
| Vapor Pressure 1mm at | 22°C |
| VOC, % by volume | 75.2 |
| Appearance | amber, clear liquid |

Thinning

IES™ Secure-Bond II is a ready-to-use product and has been pre-diluted to the correct level. Do not thin further as optimal adhesion will be compromised.

Surface Preparation

Surface to be primed must be clean, dry, and structurally sound. All grease, oil, laitance, loose rust, and dust must be removed from the surface prior to applying the primer.

| Substrate | Minimum | Recommended |
|--|------------------------------|---|
| Ferrous Steel or Aged Galvanized Steel | SSPC SP2 | SSPC Sp6 to 2 mil surface profile |
| Concrete - ICRI CSP 1-6 | SSPC Sp13 | SSPC Sp13, no loose aggregate or residual dust |
| PVC, EDM and granulated modified bitumen sheet goods | Powerwash minimum 3,500 psi. | Powerwash with detergent minimum 3,500 psi., dust free when dry |

Processing Conditions

IES™ Secure-Bond II can be applied using brush, roller, or one component spray equipment to dust-free, clean, and sound surfaces. It is essential to apply the material evenly and within the recommended coverage rates. Passes should be overlapped slightly to ensure total uniform coverage of the substrate. Once applied, the IES™ Secure-Bond II must be allowed to sufficiently moisture cure based on the cure and recoat guidelines outlined in the chart that follows:

| | |
|--------------------------|--|
| Ambient Air Temperature: | 45 – 120°F (7 – 49°C) |
| Cure Time: | 15 min. to 3 hours depending on ambient temperature and humidity |
| Typical Walk On Time: | Minimum 15 minutes |
| Typical Recoat | 15 minutes to 4 hours depending on temperature and humidity |

NOTE: The ideal time to topcoat this product is when it becomes tack free. If IES™ Secure-Bond II is allowed to totally cure overnight, depending on the substrate, it may be necessary to scuff the surface before topcoating.

Spray equipment used for water based coatings or primers should be flushed with an organic solvent such as mineral spirits or acetone prior to use with the IES™ Secure-Bond II since residual water can react in the pumps and lines, potentially clogging the machinery.

Recommended Coverage Rates:

| | |
|--|------------------------------------|
| Steel | 500 -800 ft ² / gallon |
| Concrete | 400 - 800 ft ² / gallon |
| PVC, EPDM, and granulated modified bitumen sheet goods | 300 - 500 ft ² / gallon |

Porous substrates may allow primer to soak in quickly. A second coat of primer can be applied over the first cured coat to further seal the surface and limit pinholes in the final top coating.

Adhesion Testing

Concrete – ICRI CSP 5ASTM D412 >300 psi.

Storage and Handling

IES™ Secure-Bond II is sensitive to moisture. Original containers must be kept tightly closed to prevent contamination with moisture and foreign materials, which can adversely effect processing. A desiccant dryer cartridge is recommended when using product in drums. Recommended storage temperature is 50 – 86°F (10 – 30°C). Shelf life is 6 months when stored in closed, original containers at 77°F (25°C).

Health and Safety Information

Appropriate literature has been assembled which provides information concerning the health and safety precautions that must be observed when handling IES™ Secure-Bond II. Before working with this material, you must read and become familiar with the available information concerning the hazards, proper use and handling. This cannot be overemphasized. Information is available in several forms, e.g., material safety data sheets and product labels. MSDS are available online at www.useies.com.

Product Availability

- #8704 - 1 Quart
- #8705 - 1 Gallon
- #8706 - 5 Gallons