

# CHEM-O-GARD PRIMER GRAY

## High Solids Epoxy Polyamide Coating



### Technical Data

#### PRODUCT DESCRIPTION

A two-component, high solids, high film build epoxy polyamide primer or intermediate designed for application over steel and for application over self-cured inorganic zinc coatings. Primer offers excellent adhesion and corrosion protection.

#### FEATURES

- High solids
- Excellent corrosion resistance
- Excellent sag resistance
- Excellent adhesion
- Can be over coated with wide range of topcoats
- High-performance general maintenance coating for new and old steel
- Successful use of the light coat - full coat application techniques over inorganic zinc

#### PRODUCT DATA

Description	Results
Vehicle Type .....	Epoxy / Polyamide
Color .....	Gray
Gloss .....	10 - 20
VOC (mixed w/33523) .....	227 g/L (1.9 lbs/gal)
Weight/Gallon (mixed) .....	12.9 pounds
Solids by Weight (mixed) .....	84.13%
Solids by Volume (mixed) .....	71.37%
Viscosity (mixed) .....	1,500 cps
Flash Point .....	84°F Hardener, 92°F Resin
Dry Heat Resistance .....	250°F continuous, 350°F intermittent
Packaging .....	2 gallons unit, 10 gallons unit

#### APPLICATION DATA

Description	Results
Application .....	Conventional and Airless Spray, Brush or Roll
Mix Ratio .....	1:1 by Volume
Resin .....	33522
Hardener .....	33523
Recommended Thickness .....	4 - 6 mils/coat (dry)
Dry Time @ 77°F and 50% R.H.	
No Accelerator	Spray/Brush/Roll
Recoat .....	5 hours min., 3 months max.
Tack Free .....	3 hours
Handle .....	7 - 8 hours
With 3 fl oz/gal	
Recoat .....	3 hours min., 3 months max.
Tack Free .....	1.5 hours
Handle .....	4 - 5 hours
Pot Life @ 75°F, 50% R.H.	
No Accelerator	
2X Viscosity .....	3 hours
Gel Time .....	5 hours
With 3 fl oz/gal	
2X Viscosity .....	2 hours
Gel Time .....	3.5 hours
Coverage .....	1145 sf/gal at 1 mil DFT

Thinner	
Airless Spray .....	Not required
Conventional Spray .....	Not required
Brush/Roll .....	Not required
Clean Up .....	Xylene, MEK, 21092 or 21064 thinner

The above product and application data for this technical data sheet are based on product 33522/33523.

#### CURED FILM PERFORMANCE

Description	Test Method	Results
Adhesion to Steel	ASTM D4541	1,200 psi
Hardness	ASTM D2240	60
Impact Resistance	ASTM D2794	24 in. lbs - reverse 70 in. lbs - direct
Corrosion Resistance 3,000 hours salt spray	ASTM B117	No face blistering
Tensile Strength	ASTM D638	1,317 psi
Tensile Elongation	ASTM D638	39%

#### EQUIPMENT RECOMMENDATIONS

Listed below are general equipment guidelines for the application of this product. Job site conditions may require modifications to these guidelines to achieve the desired results.

**BRUSH:** Use a good quality solvent resistant, natural or synthetic.

**ROLLER:** Use a good quality natural or synthetic 1/4" short-nap roller cover with phenolic core.

**SPRAY APPLICATION (General):** The following spray equipment has been found suitable and is available from manufacturers such as Binks, DeVilbiss and Graco.

##### AIR ATOMIZED SPRAY:

Model	Air Cap	Fluid Head	Fluid Delivery	Atomizing Pressure
Binks 18	68 PB	68	20 oz/min	65 - 75 psi
DeVilbiss MBC-510	MB-4039-62HD	AV-650-AC	20 oz/min	65 - 75 psi

##### AIRLESS SPRAY:

Model	Pump Ratio	Fluid Tip	Fluid Pressure	Filter Mesh
Graco	30:1 or Larger	0.017 - 0.021	1,800 - 2,400 psi	60
Binks	30:1 or Larger	0.017 - 0.021	1,800 - 2,400 psi	60

#### GENERAL SURFACE PREPARATION

All surfaces must be sound, dry, clean and free of oil, dirt, grease, wax, mildew, loose or flaking paint and other surface contaminants.

Remove loose, peeling, flaking or scaling paint by scraping, sanding or wire brush.

For good results, an SSPC-SP 5 (NACE No. 1) white metal blast with a 3 - 4 mils profile or SSPC-SP 10 (NACE No. 2) near-white metal blast with a 2 - 4 mils dense, sharp

anchor profile free of peening. For moderate exposure, an SSPC-SP 6 (NACE No. 3) commercial blast should be used.

## DIRECTIONS FOR USE

TINTING: Do not tint.

THINNING: None required.

Note: Always know local VOC restrictions for coatings applications in your area before thinning this product. Thinning recommendations meet Federal VOC restrictions for architectural coatings. This product and other referenced products may not meet VOC restrictions for your application and may not be available in your area. Carefully read and observe warning thinner labels.

APPLICATION: Apply by spray, brush or roller. APPLY ONLY when air and surface temperatures are between 50 - 110°F and the surface temperature of the steel substrate is at least 5°F above dew point.

For use over inorganic zinc, apply unthinned at wet film thickness of 5 - 6 mils. Allow to flash-off solvents 10 - 15 minutes, then apply a full wet coat to achieve specified dry film thickness.

DRYING TIME: Under normal conditions, dries to touch in 5 - 8 hours. Recoat time is 5 hour minimum and 3 months maximum. Low temperature, high humidity, poor ventilation and thick films will retard drying time. Recoating time is highly dependent upon actual surface temperatures. Higher surface temperature will shorten the maximum recoat window. Surface temperature should be monitored, especially on heated surfaces.

CLEAN UP: Clean up skin, clothing, paint tools or spills immediately with recommended thinner or cleaner, carefully observing cautions on paint, thinner and cleaner labels. Dried paint may be removed by scraping.

## HEALTH AND SAFETY

Read the Material Safety Data Sheet (MSDS) and container labels for detailed health and safety information. This product is intended for industrial use by properly trained professional applicators only.

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