



Technical Data

PRODUCT DESCRIPTION

CHEM-O-PON™ HS is a low VOC epoxy/modified polyamide coating formulated for topcoat, direct-to-metal or concrete applications. CHEM-O-PON™ HS possesses excellent corrosion and chemical resistance.

FEATURES

- Low VOC
- Good impact resistance
- Tough/hard finish
- Excellent corrosion and humidity resistance
- Direct-to-metal application with 99970 CHEM-O-PON™ HS Low gloss catalyst
- Full gloss topcoat with 99972 CHEM-O-PON™ HS Gloss Catalyst
- Resistant to chemical splash/spillage

PRODUCT DATA

Description	Results
Vehicle Type	Epoxy Modified Polyamide
Colors	Available in a Variety of Colors
Gloss	High and Satin Gloss
V.O.C.	
Base	341 g/l (2.84 lbs/gal)
Mixed (99970)	276 g/l (2.31 lbs/gal)
Mixed (99972)	317 g/l (2.64 lbs/gal)
Weight/Gallon (mixed)	10.9 - 12.6 pounds
Solids by Weight	
Base	78.2%
Mixed (99970)	81.8%
Mixed (99972)	75.3%
Solids by Volume	
Base	60.7%
Mixed (99970)	68.1%
Mixed (99972)	63.2%
Viscosity	2,500 - 3,500 cps
Flash Point	57°F
Dry Heat Resistance	250°F
Freight Classification	Flammable
Packaging	1 Gallon & 5 Gallons

APPLICATION DATA

Description	Results
Application	Spray, Brush or Roll
Mix Ratio	1:1 by Volume
Catalyst	99970 or 99972
Recommended Thickness	2.0 - 4.0 mils DFT
Dry Time @ 77° F, 50% RH	Spray Brush/Roll
To Touch	5 hours 5 hours
To Handle	7 hours 7 hours
To Recoat	2 hours 11 hours
Pot Life	4 hours
Coverage	338-364 sf/gal at 3 mils DFT
Thinner	
Brush/Roller	21067 @ 2 - 4 fl oz/gal

Air Atomized Spray	21064 up to 10%
	21067 up to 3%
Airless Spray	21064 up to 10%
	21067 up to 3%
Clean Up	Aliphatic or Aromatic Solvent

The above product and application data for this technical data sheet are based on product 39030 White.

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 & ROLLER (General): Multiple coats may be required to achieve desired appearance, hiding and recommended dry film thickness. Avoid excessive rebrushing or rerolling.

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 Tip	Fluid Delivery	Atomizing Pressure
Pressure	Binks #18	63 pb	66	16 oz/min	45 - 60 psi
Pressure	DeVilbiss MBC-510	704	fx	16 oz/min	45 - 60 psi

AIRLESS SPRAY:

Model	Pump Ratio	Fluid Tip	Fluid Pressure	Filter Mesh
Graco Bulldog	30:1	.013 - .019	1800 - 2200	100
Binks B 8D	35:1	.013 - .019	1800 - 2200	100

AIR ASSISTED AIRLESS SPRAY:

Model	Pump Ratio	Fluid Tip	Fluid Pressure	Atomizing Pressure
Kremlin MVX A. A. Gun	10:1	.013 - .016	400 - 800	10 - 15 psi

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 old paint, coatings, mill scale and rust by sandblasting. If sandblasting is not practical, clean surfaces with power tools, hand scraping and wire brushing.

DIRECTIONS FOR USE

TINTING: Use tint base and HS Colorant specified in the formula when tinting the desired custom color.

THINNING: This product has been formulated to be applied without the need of additional thinning. However, application with certain equipment and under various conditions may be enhanced by reduction with the thinners specified. Please note that additional reduction will increase VOC content of the mixed coating.

APPLICATION: Mix 1 part CHEM-O-PON™ HS to 1 part 99970 or 99972 catalyst. Thoroughly mix and add 21064 CHEM-O-PON™ thinner (for spray application) up to 10%. When temperature is over 70°F or to reduce orange peel and dry spray, use 21067 CHEM-O-PON™ Roller Retarder. For brush/roll applications, use 21067 CHEM-O-PON™ Roller Retarder at 2-4 fl oz/gal. For best results in humid conditions (over 65% RH), allow 30 minutes "sweat-in" time prior to application. Do not apply if surface temperature is or is expected to drop within 5°F of dew point or if relative humidity exceeds 85%.

Pot life is approximately 4 hours after mixing. Mix only the amount of material that can be used in 4 hours. Pot life is decreased with an increase in temperature. Mixed material should be kept in as cool a place as possible. Flush mixed material from pot and lines immediately after use.

Note: Always know local VOC restrictions for coating applications in your area before thinning this product. Thinning recommendations meet Federal VOC restrictions for floor 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 on thinner labels.

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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