

CHEM-O-PON™ PRIMER

High Build, High Solids, Low VOC Epoxy Primer



Technical Data

PRODUCT DESCRIPTION

A two-component, 3:1 ratio, high solids, high build, low VOC epoxy primer for industrial maintenance which dries faster than normal polyamide epoxy primers. Offers excellent resistance to corrosion and exceptional adhesion to ferrous metal substrates. Resists solvents, dilute acids and alkali attack.

FEATURES

- High solids, low VOC
- Excellent adhesion
- High build
- Fast drying
- Corrosion resistant
- Chromate free

PRODUCT DATA

| Description | Results |
|-------------------------------|------------------------------------|
| Vehicle Type | Epoxy Polyamide |
| Color | 33304 Light Gray |
| Gloss | < 5 on 60° meter |
| VOC (mixed)..... | 385 g/L (3.21 lbs/gal) |
| Weight/Gallon..... | 12.3 pounds |
| Solids by Weight (mixed)..... | 73.8% |
| Solids by Volume (mixed)..... | 54.5% |
| Viscosity (mixed) | 3,000 cps (Brookfield #4 @ 20 rpm) |
| Flash Point | 51°F |
| Dry Heat Resistance | 250°F |
| Freight Classification | Paint Flammable |
| Packaging..... | 1 Gallon (mixed Unit) |

APPLICATION DATA

| Description | Results |
|----------------------------|--|
| Application..... | Conventional or Airless Spray |
| Mix Ratio | 3:1 by Volume |
| Catalyst | 99953 Neutral CPN1057 Red CPN3063 Tan CPN8073 Beige |
| Recommended Thickness..... | 2 - 3 mils DFT |
| Dry Time @ 77° F, 50% RH | |
| Tack Free..... | 1 hour |
| To Handle | 6 hours |
| To Recoat | 4 hours |
| Pot Life | |
| 2X Viscosity | 8 hours |
| Gell Time | 16 hours |
| Coverage..... | 437 sf/gal at 2 mils DFT |
| Thinner | 21064 CHEM-O-PON™ Thinner 21092 Medium Spray Reducer |
| Clean Up | 21064 CHEM-O-PON™ Thinner |

The above product and application data for this technical data sheet are based on product 33304 Light Gray.

CURED FILM PERFORMANCE

| Description | Test Method | Results |
|--|-------------|--------------------------|
| Adhesion to Steel | ASTM D4541 | > 500 psi |
| Hardness | ASTM D3363 | 2H |
| Impact Resistance | ASTM D2794 | 160 lbs direct |
| Corrosion Resistance 2,500 Hours Salt Fog | ASTM B117 | few #6, no under-cutting |

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.

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 | 20 oz/min | 45 - 60 psi |
| Pressure | DeVilbiss MBC-510 | 704 | fx | 20 oz/min | 45 - 60 psi |

AIRLESS SPRAY:

| Model | Pump Ratio | Fluid Tip | Fluid Pressure | Filter Mesh |
|---------------|------------|-------------|----------------|-------------|
| Graco Bulldog | 30:1 | .011 - .013 | 1800 - 2200 | 100 |
| Binks B 8D | 35:1 | .011 - .013 | 1800 - 2200 | 100 |

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 best results, an SSPC-SP 5 (NACE No. 1) white metal blast is minimum for severe exposure. For moderate exposure (non-immersion), an SSPC-SP 6 (NACE No. 3) commercial blast should be used.

DIRECTIONS FOR USE

TINTING: Do not tint.

THINNING: Thin with 21064 CHEM-O-PON™ Thinner; 10-15% if local VOC regulations allow. National EPA/IM VOC compliance will not be exceeded with these levels of thinner. Alternate reducer 21092 may be used as universal thinner. Reduce viscosity with approved thinner only.

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: Thoroughly mix 3 parts epoxy resin to 1 part 99953 catalyst. May use alternate catalyst 99957 for red color, 99963 for tan color or 99973 for beige color. Apply by spray only. APPLY ONLY when air and surface temperatures are between 44 - 100°F and the surface temperature is at least 5°F above the dew point.

DRYING TIME: Under normal conditions, dries to touch in 1 hour and to recoat in 4 hours. Low temperature, high humidity, poor ventilation and thick films will retard drying. CHEM-O-PON™ Accelerator 99026 can be added at the rate of 1 oz per mixed gallon to facilitate faster cure in colder temperature.

CLEAN UP: Clean up skin, clothing, paint tools or spills immediately with recommended thinner, carefully observing cautions on paint and thinner labels. Dried paint may be removed by scraping. See Technical Data for ACRYLITHANE™ for recommended Engineered Systems.

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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