

# CHEM-O-PON™ PRIMER

## High Build, High Solids Epoxy Primer



### Technical Data

#### PRODUCT DESCRIPTION

A two-component, 3:1 ratio, high solids, high build 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
- 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	ASTM B117	few #6, no under-cutting
2,500 Hours Salt Fog		

#### 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. 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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