

**15090: Base 15099: Curing Agent 95045**

<b>Description:</b>	CHEM-O-PON™ EPOXY PRIMER is a two component polyamide cured, high solids, and high build epoxy primer. Offers excellent resistance to corrosion and exceptional adhesion to ferrous, galvanized, and non-ferrous substrates. Resists solvents, diluted acids and alkali attack.
<b>Recommended use:</b>	Industrial OEM and maintenance applications requiring a fast drying epoxy primer with a smooth finish that does not require sanding. Can be used direct to metal or as an intermediate coat over zinc rich primers. Offers excellent extended recoatability.
<b>Features:</b>	High solids Extended recoatability Fast drying Corrosion resistant Smooth finish
<b>Service temperatures:</b>	Maximum dry heat exposure to 250°F
<b>Availability:</b>	Not included in Group Assortment. Availability subject to confirmation.

**PHYSICAL CONSTANTS:**

Shade no. / Color.:	16690 (formerly JB 33304) Light Grey; See REMARKS overleaf
Finish:	Flat
Volume solids, %:	55 ± 1
Theoretical spreading rate:	8.64 m <sup>2</sup> /litre – 63 microns 352 sq. ft./US gallon – 2.5 mils DFT
Flash point:	77°F / 25°C
Specific gravity:	1.46 kg/litre - 12.3 lbs/US gallon
Dry to touch:	1 hour at 20°C/68°F
Through dry to handle	6 hours
Viscosity	20 – 30" Zahn #4 cup
VOC content:	383 g/litre [3.2 lbs/US gallon]

*The physical constants stated are nominal data according to the approved formulas.*

**APPLICATION DETAILS:**

<b>Version, mixed product</b>	<b>15090</b>		
Mixing ratio:	BASE: 15099 : CURING AGENT 95045 3 : 1 by volume		
Application method:	<u>Airless spray</u>	<u>Air spray</u>	<u>Brush</u>
Thinner (max.vol.):	083JB or 08320 (0-5%)	083JB or 08320 (5-15%)	08DJB (5%)
Pot life:	HEMPEL 08450 Reducer; 0832 Medium Reducer, 08DJB Brush & Roll Reducer		
Nozzle orifice:	8 hours at 20°C/68°F 0.015"-0.019"		
Nozzle pressure:	138 bar [2,000 psi] <i>(Airless spray data are indicative and subject to adjustment)</i>		
Cleaning of tools:	CHEM-O-PONTM THINNER 083JB or MEDIUM REDUCER 08320		
Indicated film thickness, dry:	63 – 90 microns / 2.5 – 3.5 mils (see REMARKS overleaf)		
Indicated film thickness, wet:	115 - 162 microns / 4.6 – 6.4 mils		
Overcoat interval, min:	2 hours (20°C/68°F)		
Overcoat interval, max:	6 weeks (20°C/68°F) See REMARKS overleaf		
<b>Safety:</b>	Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult Safety Data Sheets and follow all local or national safety regulations.		

SURFACE PREPARATION:	<p>Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Abrasive blasting to Sa 2½ (ISO 8501-1:2007) or SSPC-SP 10 with a sharp-edged surface profile corresponding to Keane-Tator Comparator, 2.0 G/S, 2 S, or ISO Comparator, Medium (G).</p> <p><b>Repair and maintenance:</b> Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Clean damaged areas thoroughly by power tool cleaning to minimum St 2 (spot-repairs) or by abrasive blasting to min. Sa 2, preferably to Sa 2½ (ISO 8501-1:2007) or SSPC-SP 10. Improved surface preparation will improve the performance of the product. As an alternative to dry cleaning, water jetting to sound, well adhering coat and/or to steel. Intact coat must appear with roughened surface after the water jetting. By water jetting to steel, cleanliness shall be: Wa 2 - Wa 2½ (atmospheric exposure) / minimum Wa 2½ (immersion) (ISO 8501-4). Acceptable flash-rust degree before application: maximum M (atmospheric exposure), preferably L (immersion) (ISO 8501-4). Feather edges to sound and intact areas. Dust off residues. Touch up to full film thickness. On pit corroded surfaces, excessive amounts of salt residues may call for high pressure water jetting, wet abrasive blasting or, alternatively, dry abrasive blasting, high pressure fresh water hosting, drying, and finally dry abrasive blasting again</p>
APPLICATION CONDITIONS:	<p>Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Use only where application and curing can proceed at temperatures above: 7°C / 44°F. The temperature of the paint itself should be: 15-25°C/59-77°F. In confined spaces provide adequate ventilation during application and drying.</p>
PRECEDING COAT:	<p>According to specification, or recommended systems are: ALUMINUM ADHESION PROMOTER; CHEM-O-PLEX ADHESION PROMOTER; CHEM-O-Z HS2 ORGNIC ZINC RICH PRIMER; OR CHEM-O-Z QUICK DRY ORGANIC ZINC RICH PRIMER</p>
SUBSEQUENT COAT:	<p>ACRYLITHANE POLYURETHANE ENAMELS</p>
REMARKS:	
Mixing:	<p>Power stir the base, then add hardener to base and power stir for 3 minutes. CHEM-O-PON EPOXY PRIMER may be accelerated with 99AJB Epoxy Accelerator in cooler temperatures to shorten drying times. One ounce added to a catalysed gallon will normally result in 25% faster drying. Two ounces added to a catalysed gallon will normally result in 50% faster drying.</p>
Thinning:	<p>Thinning may be necessary in the case of very long spray hoses and/or paint temperatures below: 15°C/59°F. This will cause lower film build and longer drying time. Alternate reducers such as Acetone may be used to reduce product without adding VOC's.</p>
Overcoating:	<p>Under normal conditions, dries to touch in 1 hour and dries for overcoat in 2 hours. Low temperature, high humidity, poor ventilation and thick films will retard drying. Can be overcoated without sanding up to 6 weeks after application. Longer times require pressure washing or sanding.</p>
Shade no. / Color.:	<p>CHEM-O-PON EPOXY PRIMER also has other color options with several pigmented curing agents. Red 95EJB (150905L018); Tintable Neutral 95HJB (150900000); and Tan 95LJB (150906L010) can be used in place of 95045 to offer color shaded films. Use mix ratio of 3:1.</p>

Note: **CHEM-O-PON™ EPOXY PRIMER is for professional use only.**

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This Product Data Sheet supersedes those previously issued.

For explanations, definitions and scope, see "Explanatory Notes" available on [hempel.com](http://hempel.com). Data, specifications, directions and recommendations given in this data sheet represent only test results or experience obtained under controlled or specially defined circumstances. Their accuracy, completeness or appropriateness under the actual conditions of any intended use of the Products herein must be determined exclusively by the Buyer and/or User.

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