

Kit Code: 154JB; Base 154J9; Curing Agent 95045

Formerly Jones-Blair 33314

Description: Chem-O-Pon Low VOC Epoxy Primer is a polyamide cured, high solids, high build epoxy primer. Offers excellent resistance to corrosion and exceptional adhesion to ferrous, galvanized, and non-ferrous substrates. Resists solvents, dilute acids and alkali attack.

Recommended use: 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.

Features:

- High solids.
- Extended recoatability.
- Low VOC.
- Fast drying.
- Corrosion resistant.

Service temperatures: Maximum dry heat exposure: 250°F/121°C

Physical constants:

Color/Shade code: Light Gray/1L071 (other colors available)
Finish: Flat
Volume solids: 51% ± 2
Theoretical spreading rate: 818 ft²/US gallon [20.4 m²/liter] – 1 mils [25 micron]
Flash point: 72°F/22°C
Specific gravity: 11.96 lbs/US gallon [1.43 kg/liter]
Viscosity: 20" – 30", Zahn 4
Touch dry: 1 hour, 68°F/20°C
Dry to handle: 6 hours, 68°F/20°C
VOC content: 310 g/liter [2.59 lbs/US gallon]
The physical constants stated are nominal data according to the Hempel Group's approved formulas. VOC may be dependent on color.

Application details:

Product / Mix ratio: Base 154J9 : Curing agent 95045 / 3 : 1 by volume
Application method: Airless spray / Air spray / Brush
Thinner (max. vol.): 083JB or 08320 (0-5%) / 083JB or 08320 (5-15%) / 08DJB (5%)
Pot life: 8 hours, 68°F/20°C
Nozzle orifice: 0.015" – 0.019"
Nozzle pressure: 2,000 psi [138 bar]
(Airless spray data are indicative and subject to adjustment)
Cleaning of tools: 083JB Chem-O-Pon Thinner or 08320 Medium Reducer
Indicated film thickness, dry: 2.5 – 3.5 mils [63 – 90 microns]
Indicated film thickness, wet: 4.9 – 6.9 mils [124 – 176 microns]
Overcoat interval, min: 2 hours, 68°F/20°C
Overcoat interval, max: See Overcoating on Page 2

Surface preparation, new build:

- 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.
- Surface profile: Medium (G) (ISO 8503-2).

Application conditions:

- Surface must be completely clean and dry at the time of application.
- Ensure adequate ventilation.
- Air and surface temperature must be above the dew point to avoid condensation.
- Paint temperature should be between 59°F – 77°F [15°C – 25°C] for best performance.
- Minimum temperature for curing is 44°F/7°C.

- Preceding coat:** According to specification.
- Subsequent coat:** According to specification. Recommended systems are: Acrylithane polyurethanes.
- Overcoating:** Can be overcoated without sanding up to 6 weeks after application. Longer times require pressure washing or sanding.
- Repair/maintenance:**
- Remove oil and grease etc. thoroughly with suitable detergent.
 - Remove salts and other contaminants by high pressure fresh water cleaning.
 - Remove dust, blast media, and loose materials.
 - Clean damaged areas by power tool cleaning to minimum St 2 (spot-repairs), or by abrasive blasting to minimum Sa 2, preferably to Sa 2½ (ISO 8501-1:2007) or SSPC-SP 10.
 - Water jetting to steel: Minimum Wa 2 or Wa 2½, (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.

Additional information:

- Mixing/stirring:** Power stir the base, then add curing agent to base and power stir for 3 minutes
- Additives:**
- Jones-Blair numbers and names in parentheses*
- Accelerator (99AJB) may be added at the rate of 1.0 fl oz per mixed gallon to facilitate faster cure in colder temperatures.
- Storage/shelf life:**
- Store in a cool area to ensure full shelf life. Recommended temperature: 75°F/23°C.
 - Shelf life: 154J9 and 95045, 3 years.
- Safety:** Handle with care. Use with adequate ventilation. Before and during use, observe all safety labels on packaging and paint containers, consult product Safety Data Sheets and follow all local or national safety regulations.

Note: Chem-O-Pon Low VOC Epoxy Primer is for professional use only.

Issued by: Hempel (USA) – 154JB

This Product Data Sheet ("PDS") relates to the supplied product ("Product") and is subject to updating from time-to-time. Accordingly, the buyer/applicator should have regard to the PDS supplied together with the relevant batch of the Product (and not an earlier version). In addition to the PDS, the buyer/applicator may receive some or all of the following specifications, statements and/or guidelines as listed below or as are available from the Hempel website under 'Products' at www.hempel.com (the "Additional documents"):

No.	Document description	Location/comments
1.	Technical Statement	One-off specific advice provided on request for specific projects
2.	Specification	Only issued for specific projects
3.	PDS	This document
4.	Explanatory Notes to the PDS	Available at www.hempel.com and contain relevant information about the Product testing parameters
5.	Application Instruction	Where available, at www.hempel.com
6.	Generic technical guidelines (e.g. on application and surface preparation)	Where available, at www.hempel.com

In the event of a conflict of information between the PDS and the Additional documents, the order of priority of information shall be in the order as set out above. In such event you should also contact your representative at Hempel for clarification. Furthermore, the buyer/applicator must have full regard to the relevant Safety Data Sheet provided with each Product and which can also be downloaded from www.hempel.com.

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