

CHEM-O-PON™ MASTIC

High Build, 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. Offers excellent resistance to corrosion and exceptional adhesion to ferrous metal substrates. Resists solvents, dilute acids and alkali attack.

FEATURES

- High solids, very low VOC
- Excellent adhesion
- High build
- May be applied by brush or roller
- Corrosion resistant
- Chromate free

PRODUCT DATA

Description	Results
Vehicle Type	Epoxy Polyamide
Color	39025 White, 39549 Gray & 39910 Aluminum
Gloss	10 - 20 on 60° meter
VOC (mixed w/99959)	276 g/l (2.30 lbs/gal)
Weight/Gallon (mixed)	13.3 pounds
Solids by Weight (mixed)	83.2%
Solids by Volume (mixed)	68.2%
Flash Point	57°F
Dry Heat Resistance	250°F
Freight Classification	Paint Flammable
Packaging	1 Gallon Mixed Units

APPLICATION DATA

Description	Results
Application	Conventional or Airless Spray, Brush or Roll
Mix Ratio	3:1 by Volume
Catalyst	99959
Recommended Thickness	5 - 8 mils DFT
Dry Time @ 77° F, 50% RH	
Tack Free	2 hour
To Handle	6 hours
To Recoat	4 hours
Pot Life	
2X Viscosity	8 hours
Gell Time	16 hours
Coverage	218 sf/gal at 5 mils DFT
Thinner	21064
Clean Up	Xylene

The above product and application data for this technical data sheet are based on product 39025 White.

CURED FILM PERFORMANCE

Description	Test Method	Results
Adhesion to Steel	ASTM D4541	> 500 psi
Hardness	ASTM D3363	4H
Impact Resistance	ASTM D2794	40 lbs direct
Corrosion Resistance	ASTM B117	few #6, no undercutting
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.

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	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	.013 - .017	1800 - 2200	100
Binks B 8D	35:1	.013 - .017	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: None required for brush or roll. For spray application, thin with 21064 CHEM-O-PON™ Thinner; 5-10% if local VOC regulations allow. National EPA AIM VOC compliance will not be exceeded with these levels of thinner. A non VOC thinner such as Acetone (up to 5%) may be used to reduce product without adding VOC.

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 CHEM-O-PON™ Mastic to 1 part 99959. Apply by spray, brush or roller. **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 2 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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