

RUST-OLEUM®

9300 SYSTEM EPOXY PRIMER

DESCRIPTION AND USES

The 9300 System Epoxy Primers are rust-inhibitive two-component, polyamide converted epoxy primers formulated with a convenient 1:1 mix ratio. These high solids primers are formulated to meet low VOC requirements and offer extended recoat times for epoxy coating systems. These primers are suitable for application to clean, abrasive blasted, or sound rusted surfaces.

These products are available by **SPECIAL ORDER ONLY**.

PRODUCTS

SKU	Description
9360402	Red Primer (1-Gallon)
9360300	Red Primer (5-Gallon)
9370402	Buff Primer (1-Gallon)
9370300	Buff Primer (5-Gallon)
9304402	Activator (1-Gallon)
9304300	Activator (5-Gallon)

PACKAGING

Base: 1 gallon and 5 gallon containers

Activator: 1 gallon and 5 gallon containers

RECOMMENDED TOPCOATS

9700 System

9800 System

9400 System (The VOC of the 9400 System Finishes are higher than the VOC of the 9300 System Primers)

PRODUCT APPLICATION

SURFACE PREPARATION

ALL SURFACES: Remove all dirt, grease, oil, salt and chemical contaminants by washing the surface with Pure Strength® Cleaner/Degreaser item #3599402, commercial detergent or other suitable cleaner. Mold and mildew areas must be cleaned with a chlorinated cleaner or bleach solution. Rinse thoroughly with fresh water and allow to fully dry. All surfaces must be dry at time of application.

STEEL: Hand tool (SSPC-SP-2) or power tool (SSPC-SP-3) clean to remove all loose rust, mill scale, and deteriorated previous coatings. Abrasive blasting to a minimum Commercial Grade (SSPC-SP-6, NACE3) with a 1-2 mil (25-50µ) surface profile is recommended for optimal performance. Abrasive blast clean steel requires two coats of primer.

PREVIOUSLY COATED: Previously coated surfaces must be sound and in good condition. Smooth, hard, or glossy finishes should be scarified by sanding or sweep blasting to create a surface profile. The 9300 System Primers are compatible with most coatings, but a test patch is suggested.

GALVANIZED METAL: Remove oil, dirt, grease and other chemical deposits with Pure Strength® Cleaner/Degreaser item #3599402 or other suitable cleaner. Remove loose rust, white rust or deteriorated old coatings by hand or power tool cleaning or brush off blasting. Rinse thoroughly with fresh water and allow to fully dry.

PRODUCT APPLICATION (cont.)

APPLICATION

Apply only when the air and surface temperatures are between 55-100°F (13-38°C) and the surface temperature is at least 5°F (3°C) above the dew point.

EQUIPMENT RECOMMENDATIONS

(Comparable equipment also suitable).

BRUSH: Use a good quality natural or synthetic bristle brush.

ROLLER: Use a good quality natural or synthetic cover.

AIR-ATOMIZED SPRAY:

Method	Fluid Tip	Fluid Delivery	Atomization Pressure
Pressure	0.055-0.070	16 oz./min.	25-60 psi
Siphon	0.050-0.070	—	40-60 psi

AIRLESS SPRAY:

Fluid Pressure	Fluid Tip	Filter Mesh
2,000-3,000	0.017-0.021	60
1,600-2,400	0.018-0.021	60

HOT SPRAY: 120-140°F (49-60°C); pot life is reduced 4-5 hours

MIXING

Both the base components and the activator are pigmented and should be mixed separately before combining them together. Combine the base and activator at a 1:1 ratio by volume and mix thoroughly. Power mixing is preferred. Observe the published induction time and do not activate more material than can be applied within the published pot life.

THINNING

BRUSH/ROLLER: 160 Thinner: Normally not required.

AIR-ATOMIZED SPRAY: 160 Thinner or 333 Thinner: As needed.

AIRLESS SPRAY: 160 Thinner or 333 Thinner: Normally not needed.

NOTE: To maintain VOC compliance at <340 g./l., do not use more than 10% of 160 Thinner. If thinning of more than 10% is needed, use 333 Thinner to maintain VOC compliance of <340 g./l. (333 is VOC-exempt). Do not use 333 Thinner for brush or roller application.

CLEAN-UP

160 Thinner or xylene.

PERFORMANCE CHARACTERISTICS

Tested with 9370 Buff Primer with 9700 System finish.

Recoat time: 60 days

CYCLIC PROHESION

Rating 1-10, 10=best

METHOD: ASTM D5894, 1,008 hours, 3 cycles

RESULT: 10 per ASTM D714 for blistering

RESULT: 10 per ASTM D1654 for corrosion



PHYSICAL PROPERTIES

Resin Type		Polyamide Converted Epoxy
Pigment Type		Calcium Borosilicate, Iron Oxides, Titanium Dioxide, Magnesium Silicate
Solvents		Isopropyl Alcohol, Methyl Isobutyl Ketone, Xylene
Weight*	Per Gallon	12.0-12.5 lbs.
	Per Liter	1.44-1.50 kg
Solids*	By Weight	84.3-85.0%
	By Volume	73.4-73.9%
Volatile Organic Compounds*		<340 g/l (2.8 lbs./gal.)
Recommended Dry Film Thickness (DFT) Per Coat		3.0-5.0 mils (75-125µ)
Wet Film to Achieve DFT (unthinned material)		4.5-7.5 mils (112.5-187.5µ)
Theoretical Coverage at 1 mil DFT (25µ)		1177-1185 sq. ft./gal. (29.0-29.2 m ² /l)
Practical Coverage at Recommended DFT (assumes 15% material loss)		200-335 sq. ft./gal. (4.9-8.2 m ² /l)
Mixing Ratio		1:1 base to activator by volume (9304) activator
Induction Period		15 minutes; 30 minutes when temperature is between 55-65°F (13-18°C)
Pot Life at 70-80°F (21-27°C) and 50% Relative Humidity		3-5 hours
Dry Times at 70-80°F (21-27°C) and 50% Relative Humidity	Tack-free	4-6 hours
	Handle	10-13 hours
	Recoat	16 hours to 30 days
Force Cure		20 minutes at 225°F (dry to handle after cooling)
Dry Heat Resistance		300°F (149°C)
Shelf Life		3 years
Safety Information		FLAMMABLE LIQUID AND VAPOR. HARMFUL IF INHALED. MAY AFFECT BRAIN OR NERVOUS SYSTEM CAUSING DIZZINESS, HEADACHE OR NAUSEA. CAUSES NOSE, THROAT, EYE AND SKIN IRRITATION. FOR INDUSTRIAL USE ONLY. KEEP OUT OF REACH OF CHILDREN. SEE THE PRODUCT SAFETY DATA SHEET (SDS) AND LABEL WARNINGS FOR ADDITIONAL SAFETY INFORMATION.

* Activated material
 Calculated values are shown and may vary slightly from the actual manufactured material

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