125.21

Kem Bond® HS

Universal Metal Primer

B50NZ0003 Red Oxide, B50WZ0004 Off White, B50AZ0008 Gray

CHARACTERISTICS

KEM BOND HS is a fast drying, higher solids, rust inhibitive, universal, phenolic alkyd metal primer. Kem Bond HS can be topcoated with alkyd, acrylic, and high performance coatings. Also suitable as a "barrier" coat over conventional coatings which would normally be attacked by strong solvents in high performance coatings.

For use on properly prepared: Steel

Features:
- High film build to protect sand blasted steel
- Good corrosion and rust protection
- Universal, can be topcoated with epoxies and urethanes
- Exterior-interior metal primer
- Suitable for use in USDA inspected facilities

Recommended for use in:
- Marine application
- Maintenance primer
- Structural steel
- Machinery
- Steel pipe
- Hand rail
- Tanks
- Bar joists

Color: Red Oxide, Off White, Gray

Recommended Spreading Rate per coat:
(B50NZ0003 varies by base) as mixed

Wet mils:	3.0-8.0
Dry mils:	1.8-4.8
Coverage sq. ft. per gallon:	200-534
Theoretical coverage: sq. ft. per gallon @ 1 mil dry	962

Approximate spreading rates are calculated on volume solids and do not include any application loss. Note: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.

Drying Schedule @ 4.0 mils wet, @ 50% RH:

	@40°F	@77°F	@120°F
To touch :	1 hour	30 min.	10 min.
Tack handle:	3 hours	1 hour	15 min.
To recoat: with itself and alkyds	6 hours	2 hours	1 hour
To recoat:*	24 hours	24 hours	6 hours
To recoat: with acrylic latex paints	48 hours	24 hours	6 hours
Cure time	5 days	2 days	1 day

* Recoat with hot solvent urethane or epoxies or high performance coatings.

Drying, and recoat times are temperature, humidity, and film thickness dependent.

Tinting: **Do Not Tint**

Finish: **Flat**

Red Oxide B50NZ0003
(may vary by color)

V.O.C. (less exempt solvents): As mixed
336 grams per litre; 2.81 lbs. per gallon
As per 40 CFR 59.406

Volume Solids:	60 ± 2%
Weight Solids:	79 ± 2%
Weight per Gallon:	13.17 lb
Flash Point:	71°F TCC
Shelf Life:	36 months, unopened

COMPLIANCE

As of 07/12/2021, Complies with:

OTC	Yes
OTC Phase II	No
S.C.A.Q.M.D.	No
CARB	No
CARB SCM 2007	No
CARB SCM 2020	No
Canada	Yes
LEED® v4 & v4.1 Emissions	No
LEED® v4 & v4.1 V.O.C.	No
EPD-NSF® Certified	No
MIR-Manufacturer Inventory	No
MPI®	Yes

APPLICATION

Temperature:

minimum	40°F / 4.4°C
maximum	120°F / 49°C
	air, surface, and material
	At least 5°F above dew point
Relative humidity:	85% maximum

The following is a guide. Changes in pressures and tip sizes may be needed for proper spray characteristics. Always purge spray equipment before use with listed reducer. Any reduction must be compatible with the existing environmental and application conditions.

Reducer:	No reduction in restricted areas Xylene,R2K4
Airless Spray:	
Pressure	1800 p.s.i.
Hose	1/4-3/8 inch I.D.
Tip	.017-.019 inch
Reduction	As needed up to 3% by volume
Conventional Spray:	Not recommended
Brush	Natural Bristle
Roller Cover	1/4-3/8 inch woven with solvent resistant core

If specific application equipment is listed above, equivalent equipment may be substituted.

Apply paint at the recommended film thickness and spreading rate as indicated on front page. Application of coating above maximum or below minimum recommended spreading rate may adversely affect coating performance. Spreading rates are calculated on volume solids and do not include an application loss factor due to surface profile, roughness, or porosity of the surface, skill, and technique of the applicator, method of application, various surface irregularities, material lost during mixing, spillage, over thinning, climatic conditions, and excessive film build.

Mix paint thoroughly to a uniform consistency with slow speed power agitation prior to use. Stripe coat crevices, welds, and sharp angles to prevent early failure in these areas. When using spray application, use a 50% overlap with each pass of the gun to avoid holidays, bare areas, and pinholes. If necessary, cross spray at a right angle.

Not recommended for immersion service or exposure to acids, alkalis, or strong solvents. Intimate contact with the steel surface and primer is necessary for adequate rust inhibition and adhesion.

According to American Institute of Steel Construction (AISC), shop coat primers are intended for protection for only a short period of exposure in ordinary atmospheric conditions, and is considered a temporary and provisional coating.

SPECIFICATIONS

Steel:
1 coat Kem Bond HS
2 coats Topcoat

Acceptable Topcoats:
Acrolon 218 HS Polyurethane
Hi-Solids Polyurethane
Industrial Enamel
Macropoxy 646 Epoxy
Macropoxy HS Epoxy
Metalatex Semi-Gloss Enamel
Pro Industrial Acrylic
Pro Industrial Waterbased Epoxy
Pro Industrial Waterbased Alkyd-Urethane
Pro Industrial Multi-Surface Acrylic
Pro Industrial Pre-Catalyzed Epoxy & Urethane
Pro Industrial Urethane Alkyd Enamel
Pro Industrial Waterbased Acrolon 100
Sher-Cryl
Silver-Brite Aluminum
Steel Master 9500
Tile-Clad HS Epoxy

The systems listed above are representative of the product's use, other systems may be appropriate. Other primers may be appropriate.

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Universal Metal Primer

SURFACE PREPARATION

WARNING! Removal of old paint by sanding, scraping or other means may generate dust or fumes that contain lead. Exposure to lead dust or fumes may cause brain damage or other adverse health effects, especially in children or pregnant women. Controlling exposure to lead or other hazardous substances requires the use of proper protective equipment, such as a properly fitted respirator (**NIOSH** approved) and proper containment and cleanup. For more information, call the National Lead Information Center at **1-800-424-LEAD** (in US) or contact your local health authority.

Remove all surface contamination by washing with an appropriate cleaner, rinse thoroughly and allow to dry. Existing peeled or checked paint should be scraped and sanded to a sound surface. Glossy surfaces should be sanded dull. Stains from water, smoke, ink, pencil, grease, etc. should be sealed with the appropriate primer-sealer. Recognize that any surface preparation short of total removal of the old coating may compromise the service length of the system.

Iron & Steel- Minimum surface preparation is Hand Tool Clean per SSPC-SP2. Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1. For better performance, use Commercial Blast Cleaning per SSPC-SP6/ NACE 3, blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (2 mils). Prime any bare steel within 8 hours or before flash rusting occurs.

Previously Painted Surfaces - If in sound condition, clean the surface of all foreign material. Smooth, hard or glossy coatings and surfaces should be dulled by abrading the surface. Apply a test area, allowing paint to dry one week before testing adhesion. If adhesion is poor, additional abrasion of the surface and/ or removal of the previous coating may be necessary. Retest surface for adhesion. If paint is peeling or badly weathered, clean surface to sound substrate and treat as a new surface as above. Recognize that any surface preparation short of total removal of the old coating may compromise the service length of the system.

Other substrates may or may not be appropriate. If a specific substrate is not listed above, consult your Sherwin-Williams representative for more information.

SURFACE PREPARATION

Mildew - Prior to attempting to remove mildew, it is always recommended to test any cleaner on a small, inconspicuous area prior to use. Bleach and bleaching type cleaners may damage or discolor existing paint films. Bleach alternative cleaning solutions may be advised. Mildew may be removed before painting by washing with a solution of 1 part liquid bleach and 3 parts water. Apply the solution and scrub the mildewed area. Allow the solution to remain on the surface for 10 minutes. Rinse thoroughly with water and allow the surface to dry before painting. Wear protective eyewear, waterproof gloves, and protective clothing. Quickly wash off any of the mixture that comes in contact with your skin. Do not add detergents or ammonia to the bleach-water solution.

PERFORMANCE

Off White B50WZ0004

System Tested: (unless otherwise indicated)
Substrate: Steel
Surface Preparation: SSPC-SP6-NACE 3
Primer: 1 coat Kem Bond HS @ 4.5-5 Mils W.F.T.

Adhesion:
Method: ASTM D3359
Result: 4B

Corrosion Resistance:
Method: ASTM D5894, 1008
Result: Pass

Dry Heat Resistance
Method: ASTM D2485
Result: 200°F

Flexibility:
Method: ASTM D522, 1/4 inch mandrel
Result: Pass

Fineness of grind[1]:
Method: Hegman
Result: 4 Hegman minimum

Sag Test[1]**:**
Method: ASTM D4400
Result: 12 mils minimum

Viscosity[1]**:**
Method: Krebs Units
Result: 95-105 KU

Water Resistance:
Result: Pass

[1] Standard test based on Certificate of Analysis

SAFETY PRECAUTIONS

Before using, carefully read **CAUTIONS** on label. Refer to the Safety Data Sheets (SDSs) before use.

FOR PROFESSIONAL USE ONLY.

Published technical data and instructions are subject to change without notice. Contact your Sherwin-Williams representative for additional technical data and instructions.

CLEANUP INFORMATION

Clean spills, spatters & tools with compliant cleanup solvent. After cleaning, flush spray equipment with compliant cleanup solvent to prevent rusting of the equipment. Follow manufacturer's safety recommendations when using solvents.

DANGER: Rags, steel wool, other waste soaked with this product, and sanding residue may spontaneously catch fire if improperly discarded. Immediately place rags, steel wool, other waste soaked with this product, and sanding residue in a sealed, water-filled, metal container. Dispose of in accordance with local fire regulations.

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