

RUST-OLEUM®**HS9300 SYSTEM
EPOXY PRIMER****DESCRIPTION AND USES**

Two-component, low VOC polyamine converted epoxy primer.

Designed as primers for clean, abrasive-blasted or slightly rusted steel, masonry or concrete for topcoating with 9400 System High Gloss Polyester Urethane.

APPEARANCE

HS9369 Flat Red

HS9381 Flat Gray

PACKAGING

1-gallon short-filled base component with HS9303 activator in a separate 1-pint container.

RECOMMENDED TOPCOATS

9400 System High Gloss Polyester Urethane (activate with 9401 or HS9401)

PRODUCT APPLICATION**SURFACE PREPARATION**

ALL SURFACES: Remove all dirt, grease, oil, salt or other contaminants by washing surface with 3599 Industrial Pure Strength® Cleaner/Degreaser, commercial detergent or other suitable cleaner. Rinse thoroughly with fresh water and allow to fully dry. Thoroughly cured previous coatings or new metal surfaces which are very smooth may require scuff sanding to maximize adhesion.

STEEL – SEVERE EXPOSURES: Abrasive blast to a minimum SSPC-SP-6 Commercial Grade (NACE 3). Two coats of primer must be used.

STEEL – MODERATE EXPOSURES: Scrape and wirebrush or power tool clean to remove loose rust, scale and deteriorated previous coatings.

CONCRETE AND MASONRY SURFACES: After cleaning, repair surface defects and remove deteriorated previous coatings. Abrasive blast or acid etch smooth dense concrete using 108 Cleaning & Etching Solution followed by thoroughly rinsing with fresh water. Allow new concrete and masonry to cure at least 30 days before coating. Any concrete surface must be protected from moisture transmission from uncoated areas.

APPLICATION

Mix the base component well before adding HS9303 Activator. Continue to mix while adding activator. Allow a 30 minute induction period before using. The container is short-filled to allow for addition of activator. Do not activate more material than can be used in an 8 hour period. Apply only when air and surface temperatures are between 60-100°F (16-38°C) and surface is at least 5° above dew point.



TECHNICAL DATA

HS9300 SYSTEM EPOXY PRIMER

PRODUCT APPLICATION (cont.)

EQUIPMENT RECOMMENDATIONS

(Comparable equipment also suitable).

BRUSH: Natural or synthetic bristle recommended.

ROLLER: Epoxy compatible lamb's wool or synthetic cover recommended.

AIR-ATOMIZED SPRAY:

Method	Fluid Tip	Fluid Delivery	Atom. Pressure
Pressure	0.055-.070	16 oz./min.	25-60 psi
Siphon	0.055-.070	—	25-60 psi

AIRLESS SPRAY:

Fluid Pressure	Fluid Tip	Filter Mesh
1,800-2,400 psi	0.017-0.021	60

THINNING

BRUSH/ROLLER: Normally not required. 333 Thinner not recommended.

AIR-ATOMIZED SPRAY: 333 Thinner: Use 15-20% or as needed (approximately 1.5 pints per gallon).

AIRLESS SPRAY: 333 Thinner: Normally not required: Use 5-10% if needed (approximately 1.5 pints per gallon).

CLEAN-UP

333 Thinner or acetone.

NOTE: Use 333 Thinner to maintain VOC compliance. Use 160 Thinner where VOC compliance is not required. 333 Thinner will lower the flashpoint of coatings to which it is added.

PHYSICAL PROPERTIES

Resin Type		Polyamine converted epoxy
Pigment Type		Calcium borosilicate, brown iron oxide, black iron oxide, titanium dioxide, magnesium silicate
Solvents		Xylene, propylene glycol methyl ether
Weight*	Per Gallon	12.0-12.5 lbs.
	Per Liter	1.44-1.50 kg.
Solids*	By Weight	72%
	By Volume	53%
Volatile Organic Compounds		HS9369: 403 g./l. (3.36 lbs./gal.); HS9381: 398 g./l. (3.31 lbs./gal.)
Recommended Dry Film Thickness (DFT) Per Coat		1.5-2.5 mils (37.5-62.5µ)
Wet Film to Achieve DFT (unthinned material)		3-5 mils (75-125µ)
Theoretical Coverage at 1 mil DFT (25µ)		835 sq. ft./gal. (19.9 m²/l.)
Practical Coverage at Recommended DFT (assumes 15% material loss)		275-475 sq. ft./gal. (6.5-11.3 m²/l.)
Mixing Ratio		7:1 Base to activator by volume (HS9303 activator)
Induction Period		30 minutes
Pot Life at 70-80°F (21-27°C)		8-16 hours
Dry Times at 70-80°F (21-27°C) and 50% rel. hum.	Tack-free	1-2 hours
	Handle	3-4 hours
	Recoat	Anytime after 1 hour
Force Cure		10 minutes at 225°F (107°C) (dry to handle after cooling)
Dry Heat Resistance		300°F (149°C)
Shelf Life		5 years
Safety Information	Flash Point	88°F (31°C) Setaflash
	Contains	No lead has been deliberately added
	Warning!	CONTAINS XYLENE, PROPYLENE GLYCOL METHYL ETHER AND EPOXY AND POLYAMINE RESINS. WARNING! FLAMMABLE LIQUID AND VAPOR. HARMFUL IF INHALED MAY AFFECT BRAIN OR NERVOUS SYSTEM CAUSING DIZZINESS, HEADACHE OR NAUSEA. CAUSES RESPIRATORY TRACT, EYE AND SKIN IRRITATION. MAY CAUSE ALLERGIC SKIN REACTION. FOR INDUSTRIAL OR COMMERCIAL USE ONLY. KEEP OUT OF REACH OF CHILDREN. SEE THE PRODUCT MATERIAL SAFETY DATA SHEET (MSDS) 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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Rust-Oleum Corporation
11 Hawthorn Parkway
Vernon Hills, Illinois 60061
An RPM Company

Phone: 847•367•7700
www.rustoleum.com

Form: 2023990
Rev.: 05/06
Printed in USA