

RUST-OLEUM®

HIGH PERFORMANCE

**ROCEPOXY HIGH SOLIDS
EPOXY PRIMER HS9300****DESCRIPTION AND USES**

ROCEpoxy High Solids Epoxy Primer HS9300 is a fast drying, two-component product designed to be part of a coating system for superior corrosion protection. This high solids, rust-inhibitive primer can be applied to clean, abrasive blasted steel or slightly rusted steel, masonry, or concrete. It can be top-coated with several Rust-Oleum High Performance products including **ROCEpoxy Direct-to-Metal Epoxy Mastic 9100**, **ROCThane Fine Finish Urethane 9400** and **ROCThane Direct-To-Metal Urethane Mastic 9800**.

PRODUCT FEATURES AND BENEFITS

- High Solids, Fast Drying Epoxy Primer for Long Term Surface Protection
- Excellent Adhesion on Multiple Substrates
- Smooth Finish Compatible with Several Rust-Oleum Topcoats
- Fast Drying and Can be Top Coated in 1 Hour
- Extended pot life from 8-16 hours
- Two-Component System Comes in Pre-Measured Containers
- Five Year Rust-Proof Guarantee*

PRODUCTS

SKU	DESCRIPTION
HS9369407	Flat Red
HS9381407	Flat Gray
HS9303604	Activator

COMPATIBLE PRODUCTS**COMPATIBLE TOPCOATS**

ROCEpoxy Direct-to-Metal Epoxy Mastic 9100
ROCThane Fine Finish Urethane 9400
ROCThane Direct-To-Metal Urethane Mastic 9800

SOLVENTS

Professional Solutions Acetone Thinner
 Professional Solutions Xylene Solvent Blend

RUST PROOF GUARANTEE*

*Submitting the Five-Year Rust-Proof Guarantee form located on the **ROCEpoxy High Solids Epoxy Primer HS9300** web page completely filled out, signed and with proof of purchase attached, no later than 30 days after project completion for projects using up to 50 gallons is required to qualify for the rust-proof guarantee. For projects larger than 50 gallons, please contact Rust-Oleum Technical Service Department at: Rust-Oleum Technical Service Department, 11 Hawthorn Pkwy, Vernon Hills, IL 60061, or email to: technicalservice@rustoleum.com

PRODUCT APPLICATION**SURFACE PREPARATION**

ALL SURFACES: (SSPC-SP-1) Remove all dirt, grease, oil, salt, and chemical contaminants by washing the surface with Krud Kutter® PRO Cleaner Degreaser. 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 wire brush 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.

WARNING! If you scrape, sand, or remove old paint, you may release lead dust. **LEAD IS TOXIC. EXPOSURE TO LEAD DUST CAN CAUSE SERIOUS ILLNESS, SUCH AS BRAIN DAMAGE, ESPECIALLY IN CHILDREN. PREGNANT WOMEN SHOULD ALSO AVOID EXPOSURE.** Wear a NIOSH-Approved respirator to control lead exposure. Clean up carefully with a HEPA vacuum and a wet mop. Before you start, find out how to protect yourself and your family by contacting the National Lead Information Hotline at 1-800-424-LEAD or log on to www.epa.gov/lead.

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.

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**ROCEPOXY HIGH SOLIDS
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(Comparable equipment also suitable)

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

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

AIR-ATOMIZED SPRAY

Method	Fluid Tip	Fluid Delivery	Atomized Pressure
Pressure	0.055-0.070	16 oz./min.	25-60 psi
Siphon	0.055-0.070	--	25-60 psi

AIRLESS SPRAY

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

Caution: Protect surrounding surfaces from over spray. Over spray can be wet or dry depending on height of work, weather, environmental conditions, and application equipment. Wet over spray can adhere to unwanted surfaces. Dry over spray may be removed by wiping or washing. Always clean dry over spray from hot surfaces before fusing occurs as surface temperatures can be higher than the air temperature.

THINNING

BRUSH/ROLLER: Normally not required. Professional Solutions Acetone Thinner not recommended.

AIR-ATOMIZED SPRAY: Professional Solutions Acetone Thinner: Use 15-20% or as needed.

AIRLESS SPRAY: Professional Solutions Acetone Thinner: Normally not required: Use 5-10% if needed.

CLEAN-UP

Professional Solutions Acetone Thinner.

NOTE: Use Professional Solutions Acetone Thinner to maintain VOC compliance. Use Professional Solutions Xylene Solvent Blend where VOC compliance is not required. Professional Solutions Acetone Thinner will lower the flashpoint of coatings to which it is added.

PRIMER	TECHNICAL DATA	RO-207
	ROCEPOXY HIGH SOLIDS EPOXY PRIMER HS9300	

PHYSICAL PROPERTIES

ROCEPOXY HIGH SOLIDS EPOXY PRIMER		
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*		<450 g/l (3.76 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)
Practical Coverage at Recommended DFT (assumes 15% material loss)		275-475 sq. ft./gal. (6.5-11.3 m ² /l)
Mixing Ratio		7:1 Base to activator by volume
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% Relative Humidity	Tack-free	1-2 hours
	Handle	3-4 hours
	Recoat	Any time 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		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 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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