

Pro Industrial™**Kem Bond HS® Universal Metal Primer**

B50NZ0013 Red Oxide, B50WZ0014 Off White, B50AZ0018 Gray

**SHERWIN
WILLIAMS.****CHARACTERISTICS**

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

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

For use over properly prepared:

Steel

Recommended for use in:

•Maintenance Primer •Handrail •Structural Steel
•Storage Tanks •Machinery •Bar Joists •Steel Pipe •Marine Applications

Finish

Flat

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: 200-534 sq. ft. per gallon

Theoretical Coverage: 962 sq. ft. per gallon @ 1 mil dry

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:

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

	@40°F	@77°F	@120°F
To touch	1 hour	30 minutes	10 minutes
Tack handle	3 hours	1 hour	15 minutes
To recoat	6 hours	2 hours	1 hour

with itself and alkyds

To recoat* 24 hours 24 hours 6 hours

To recoat 48 hours 24 hours 6 hours

with acrylic latex paints

To cure 5 days 2 days 1 day

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

Tinting:**Do Not Tint****Red Oxide B50NZ0013**

(may vary by color)

V.O.C. (less exempt solvents): As mixed

335 grams per litre; 2.79 lbs. per gallon

As per 40 CFR 59.406

Volume Solids: 60 ±2%**Weight Solids:** 79 ±2%**Weight per Gallon:** 13.24 lbs**Flash Point:** 71°F TCC**Shelf Life:** 36 months, unopened**COMPLIANCE**

As of 2/16/2024, 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 complaint solvent. Any reduction must be compatible with the existing environmental and applications conditions.

Reducer:

Xylene, R2K4

No reduction in restricted areas that are less than 340 g/L. Confirm compliance with national, state, and local air quality rules before use.

Airless Spray:

Pressure 1800 p.s.i.

Hose ¼-3/8 inch I.D.

Tip .017-.019 inch

Conventional Spray: Not recommended**Reduction:** As needed, up to 3% by volume

No reduction in restricted areas that are less than 340 g/L. Confirm compliance with national, state, and local air quality rules before use.

Brush:

Natural Bristle

Roller Cover:

¼-3/8 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. 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 loss 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 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.

www.sherwin-williams.com

SPECIFICATIONS**Steel:**

1 coat Pro Industrial Kem Bond HS

2 coats Topcoat

Acceptable Topcoats:

Acrolon 218 HS Polyurethane

Hi-Solids Polyurethane

Macropoxy 646 Epoxy

Macropoxy HS Epoxy

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

Pro Industrial Sher-Cryl

Pro Industrial Silver-Brite Aluminum

Pro Industrial Industrial Enamel

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

Pro Industrial™

Kem Bond HS® Universal Metal Primer

SURFACE PREPARATION

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.

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 and 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 Surface - 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, or if this product attacks the previous finish, 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.

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 clean water. Apply the solution and scrub the mildewed area. Allow the solution to remain on the surface for 10 minutes. Rinse thoroughly with clean 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 B50WZ0014

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.

Dry Heat Resistance:

Method: ASTM D2485

Result: 200°F

Adhesion:

Method: ASTM D3359

Result: 4B

Flexibility:

Method: ASTM D522, 1/4 inch mandrel

Result: Pass

Corrosion Resistance:

Method: ASTM D5894, 1008

Result: Pass

Fineness of grind¹:

Method: Hegman

Result: 4 Hegman minimum

Sag Test¹:

Method: ASTM D4400

Result: 12 mils minimum

Viscosity¹:

Method: Krebs Units

Result: 95-105 KU

Water Resistance:

Result: Passed

¹ standard test based on Certificate of Analysis

SAFETY PRECAUTIONS

Before using, carefully read **CAUTIONS** on label.

Refer to the Safety Data Sheets (SDS) 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.

HOTW 2/16/2024 B50NZ0013 43 335

HOTW 2/16/2024 B50WZ0014 36 329

HOTW 2/16/2024 B50AZ0018 25 316