



CHEM-PRIME H.S. SERIES 37H

PRODUCT PROFILE

GENERIC DESCRIPTION Phenolic Alkyd

COMMON USAGE Lead- and chromate-free, fast-drying, corrosion-resistant primer that accepts a variety of high-performance topcoats. Ideally suited for steel fabricators, OEM's and field applications where "dry-fall" characteristics are desired. **Note:** Not recommended for immersion.

COLORS 77 Red, 77W White, 78 Gray

PERFORMANCE CRITERIA Extensive test data available. Contact your Tnemec representative for specific test results.

COATING SYSTEM

TOPCOATS Series 2H, 6, 23, 27, 28, 29, 30, 66, N69, 73, 113, 114, 161, 175, 180, 181, 1074, 1075.
Note: Some systems are not recommended for frequently sweating or continually wet conditions. Reference the applicable topcoat data sheet for additional information. Also, an additional coat of 37H is suggested before applying Series 6, 180 or 181. Contact Tnemec Technical Services for details.

SURFACE PREPARATION

STEEL **Enclosed or Protected:** SSPC-SP3 Power Tool Cleaning
Weather-Exposed: SSPC-SP6/NACE 3 Commercial Blast Cleaning

CAST/DUCTILE IRON Contact your Tnemec representative or Tnemec Technical Services.

ALL SURFACES Must be clean, dry and free of oil, grease and other contaminants.

TECHNICAL DATA

VOLUME SOLIDS 58.0 ± 2.0% †

RECOMMENDED DFT 2.0 to 3.5 mils (50 to 90 microns) per coat.

CURING TIME **Temperature:** 75°F (24°C)
To Handle: 2 hours
To Recoat With Series:

2H, 23, 180, 181	27•, 66•, 161•	28, 29, 30	N69, 73, 113, 114, 175, 1074, 1075
12 hours	48 hours	7 days	30 days

Curing time varies with surface temperature, air movement, humidity and film thickness.
Note: Allow 37H to cure 14 days if 27, 66 or 161 is to be used as an intermediate coat and topcoated with 73, 175, 1074 or 1075. Then allow 27, 66 or 161 to cure an additional 24 hours before topcoating.
Water Tank Exteriors: Five days or more curing required before filling.

VOLATILE ORGANIC COMPOUNDS **Unthinned:** 2.91 lbs/gallon (348 grams/litre)
Thinned 4%: 3.07 lbs/gallon (368 grams/litre)
Thinned 9%: 3.27 lbs/gallon (391 grams/litre) †

HAPS **Unthinned:** 1.37 lbs/gal solids
Thinned 4%: 1.89 lbs/gal solids
Thinned 9%: 2.51 lbs/gal solids

THEORETICAL COVERAGE 930 mil sq ft/gal (22.8 m²/L at 25 microns). See APPLICATION for coverage rates. †

NUMBER OF COMPONENTS One

PACKAGING 55 gallon (208.2L) drums, 5 gallon (18.9L) pails and 1 gallon (3.79L) cans.

NET WEIGHT PER GALLON
 77 12.83 ± 0.25 lbs (5.92 ± .11 kg)
 77W 12.70 ± 0.25 lbs (5.88 ± .11 kg)
 78 12.11 ± 0.25 lbs (5.61 ± .11 kg) †

STORAGE TEMPERATURE Minimum 20°F (-7°C) Maximum 110°F (43°C)

TEMPERATURE RESISTANCE (Dry) Continuous 200°F (93°C) Intermittent 250°F (121°C)

SHELF LIFE 24 months at recommended storage temperature.

FLASH POINT - SETA 65°F (18°C)

HEALTH & SAFETY Paint products contain chemical ingredients which are considered hazardous. Read container label warning and Material Safety Data Sheet for important health and safety information prior to the use of this product.
Keep out of the reach of children.

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APPLICATION

COVERAGE RATES

	Dry Mils (Microns)	Wet Mils (Microns)	Sq Ft/Gal (m ² /Gal)
Suggested	2.5 (65)	4.5 (115)	372 (34.6)
Minimum	2.0 (50)	3.5 (90)	465 (43.2)
Maximum	3.5 (90)	6.0 (150)	266 (24.7)

Allow for overspray and surface irregularities. Wet film thickness is rounded to the nearest 0.5 mil or 5 microns. Application of coating below minimum or above maximum recommended dry film thicknesses may adversely affect coating performance. †

MIXING

Stir thoroughly, making sure no pigment remains on the bottom of the can.

THINNING

Use No. 2 Thinner. For air spray, thin up to 9% per gallon. For airless spray, brush or roller, thin up to 4% per gallon.

APPLICATION EQUIPMENT

Air Spray

Gun	Fluid Tip	Air Cap	Air Hose ID	Mat'l Hose ID	Atomizing Pressure	Pot Pressure
DeVilbiss JGA	E	765 or 704	5/16" or 3/8" (7.9 or 9.5 mm)	3/8" or 1/2" (9.5 or 12.7 mm)	75-90 psi (5.2-6.2 bar)	10-20 psi (0.7-1.4 bar)

Low temperatures or longer hoses require higher pot pressure.

Airless Spray

Tip Orifice	Atomizing Pressure	Mat'l Hose ID	Manifold Filter
0.015"-0.019" (380-485 microns)	2700-3000 psi (186-207 bar)	1/4" or 3/8" (6.4 or 9.5 mm)	60 mesh (250 microns)

Use appropriate tip/atomizing pressure for equipment, applicator technique and weather conditions.

Roller: Use high quality synthetic woven nap covers. Short nap for smooth surfaces. Long nap for rough surfaces.

Brush: Recommended for small areas only. Use high quality nylon or synthetic bristle brushes.

SURFACE TEMPERATURE

Minimum 40°F (4°C) Maximum 120°F (49°C)

The surface should be dry and at least 5°F (3°C) above the dew point.

CLEANUP

Flush and clean all equipment immediately after use with the recommended thinner or xylol.

CAUTION!

Dry overspray can be wiped or washed from most surfaces. Satisfactory dry-fall performance depends upon height of work, weather conditions, equipment adjustment and proper thinning. Test for each application as follows: Spray from 15 to 25 feet towards paint container. The material then should readily wipe off. **Note:** Heat can fuse-dry overspray to surfaces. Always clean dry overspray from hot surfaces before fusing occurs. Be aware that exterior surface temperatures can be higher than air temperature.

† Values may vary with color.

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