

**Features & Uses**

High Build Epoxy Primer is a two component epoxy surfacer for use where high build and filling is required. Not to be used below the waterline.

In North America, D3002 is classed as a VOC Exempt Converter according to North American legislation. Using D3002 and T0176 the mixed ready to apply material has a VOC content of less than 2.8lbs/Gal or 340g/lit. Check with local authorities to determine VOC restrictions in your area.

**Specification Data**

Type: Epoxy Polyamide

Packaging: Available in 1 gallon and 1 quart containers

Theoretical Coverage: Sq. Feet/Gallon: 814 Sq. Feet (75.6 Sq. Meters) at one mil dry (25 microns).

111-157 Sq. Feet (10-15 Sq. Meters) at recommended dry film thickness with 2 coats.

Calculated for mixed base and converter reduced 20%.

Recommended Wet Film Thickness: 8-10 mils (200-250 microns) per coat

Recommended Dry Film Thickness: 4-5 mils (100-125 microns) per coat, 2-3 coats may be required.

Coverage calculations are based on theoretical transfer efficiency of 100%. Actual coverage rate obtained will vary according to equipment choice, application techniques, part size, and environment.

Recoatibility: With itself, 2 hours; with other products, 12-24 hours. Maximum without sanding: 24 Hours.

Sanding before over coating with other products is recommended. May be over coated with 545 Epoxy Primer, ULTRA BUILD, Sprayable Fairing Compound, AWL®FAIR L.W., and AWL®QUIK.

VOC: White Base (D8002) – 347 g/lit or 2.9 lbs/gallon

Yellow Base (D9002) – 338 g/lit or 2.8 lbs/gallon

Converter (D3002) – 361 g/lit or 3 lbs/gallon

Converter (D3002) NA only – 331 g/lit or 2.8 lbs/gallon (This VOC applies to North America only).

**Product Components, Reducers, Additives, and Auxiliary Components**

Yellow Base .....	D9002
Off White Base .....	D8002
Converter .....	D3002
Standard Reducer for Epoxy Primers .....	T0006
Medium Evaporating VOC Exempt Reducer (NA only).....	T0176
Equipment Cleaning .....	Acetone, T0006, T0176, T0002 Reducers or M.E.K.

**Application Equipment**

Conventional or airless spray. Pressure feed equipment required.

**SPRAY EQUIPMENT***Pressure Pot System Guns*

Binks or equivalent:

Spray Gun: #95

Fluid Nozzle: #68SS (.110" Orifice Size)

Fluid Needle: #668

Air Nozzle: #68PB

Pressure pot gauge should read 15 - 25 PSI (set to deliver 16-20 oz. product/per minute) atomizing pressure 50+ lbs.

*High Volume Low Pressure Guns*

SATAJET® K3 HVLP or equivalent::

Gun Pressure: 35 PSI

Fluid Needle / Nozzle: 1.6 – 2.0

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**Airless Equipment**

Binks or equivalent:

Spray Gun: Airless 1

Orifice Size: .028" - .043"

Fan Size &amp; Angle: 8" – 80°, or 6" – 60°

On a 25-1 pump, the pressure gauge should read 70 - 80 PSI

On a 40-1 pump, the pressure gauge should read 50 - 60 PSI

Product is not recommended for roll-and-tip application.

**Surface Preparation**

Best when used as a surfacer over other Awlgrip Primers and fairing compounds. May be applied directly to properly prepared wood or fiberglass; however, best results are obtained when these surfaces are first sealed with 545 Primer.

**Gelcoat/Fiberglass:** Sand with 100-150 grit paper.**Wood:** Smooth sand with 80-100 grit paper.**Mixing and Reduction**

Mix by volume one part Base with one part Converter to a smooth, homogenous mixture.

Induction Time after Mixing: 15 Minutes

Reduce 10-20% with appropriate reducer. Example: 8 oz. Base : 8 oz. D3002 : 3.2 oz. T0006 or T0176

Anticipated Pot Life at 77°F(25°C)/50% R.H: 8 Hours. Higher temperatures may shorten pot life.

**Application Instructions****Spray:** Apply High Build Epoxy Primer in even coats of 8 - 10 mils (200 - 250 microns) wet film thickness yielding 4 - 5 mils (100 - 125 microns) DFT. 2 - 3 coats may be required.

Do not apply paint materials to surfaces warmer than 105°F (41°C) or colder than 55°F (13°C). Do not attempt to cure products at temperatures below 55°F (13°C).

Product is not recommended for roll-and-tip application.

**Warning:**

Do not apply paint materials to surfaces less than 3°C (5° F) above dew point, or to surfaces warmer than 41°C (105°F). Ambient temperature should be minimum 13°C (55°F) and maximum 41°C (105°F).

The information in this Product Data Sheet is not intended to be exhaustive. Any person using the product without first making further enquiries as to the suitability of the product for the intended purpose does so at their own risk and, to the extent permitted by law. We can accept no responsibility for the performance of the product or for any loss or damage arising out of such use. The information contained in this Product Data Sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.

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