

Features & Uses

545 is a two component epoxy primer with outstanding corrosion and adhesion properties for steel, aluminum, wood, and fiberglass substrates. 545 is used to seal surfacing primers before applying topcoats. It may be applied by spray, brush, or roller and may be used above or below the waterline.

Specification Data

Type: Epoxy Polyamide

Packaging: Available in a 1 Gallon and 1 Quart containers.

Theoretical Coverage – 497 Sq. feet/gallon (46m²) at one mil dry (25 microns); 165-248 Sq. Feet (15-23m²) at recommended dry film thickness. Calculated for mixed base and converter, reduced 25%.

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 application environment.

Recommended Wet Film Thickness: 7-10 mils (175-250 microns) 2 to 3 coats.

Recommended Dry Film Thickness: 2-3 mils (50-75 microns).

Recoatibility: At 77°F/50% R.H. Spray: minimum with itself 1 hour, with other products 12 hours. Brush/Roll: with itself 12 - 14 hours, with other products 12 - 14 hours. Maximum without sanding 24 hours. Sanding is recommended to improve adhesion and appearance. Overcoat with Awlgrip, Awlgrip HS, Awlcraft SE or Awlcraft 2000 topcoats,, High Build Epoxy Primer, Awlquik Sanding Surfacer and Ultra Build Primer.

VOC: White Base (D8001) – 435 g/ltr or 3.6 lbs/gallon
 Gray Base (D1001) – 426 g/ltr or 3.6 lbs/gallon
 Converter (D3001) – 616 g/ltr or 5.1 lbs/gallon

Product Components, Reducers, Additives, and Auxiliary Components

White Base	D8001
Gray Base	D1001
Converter	D3001
Spray Reducer	T0006
Brushing Reducer.....	T0031
COLD CURE™ Accelerator.....	M3066
Equipment Cleaning	T0006 , T0002 Reducers or M.E.K.

Application Equipment

Conventional or airless spray and brush/roller. See the application guide for recommendations. Example:

Airless Equipment

Graco or Binks equivalent: :

Orifice Size.....028" – .043"

Fan size & Angle....8" – 80°, or 6" – 60°

On a 25-1 pump, the input pressure gauge should read 70 to 80 lbs.

On a 40-1 pump, the input pressure gauge should read 50 to 60 lbs.

Pressure Pot

Spray gun.....#95

Fluid nozzle.....#63BSS (.046" Orifice size)

Fluid needle.....#663A

Air nozzle.....#63PW

Pressure gauge should read 8-12 lbs. Atomizing pressure 50 to 60 lbs.

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Surface Preparation

Aluminum: Sand blast or grind to a 2-3 mil (50-75 microns) profile, clean silver color. Alternatively, on small parts/components, prime with Wash Primer CF. Steel: Sandblast/Grind SSPC-SP10 or Sa 2 1/2. Gelcoat/Fiberglass: Sand with 100-150 grit paper. Wood: Smooth sand with 80-100 grit paper.

Mixing and Reduction

Spray: Mix by volume one part 545 base with one part D3001 to a smooth homogenous mixture. Reduce up to 25% with T0006. Overall mix is 1:1:1/2 by volume. Example: 8 oz. 545 Base, 8 oz. D3001, 4 oz. T0006.

Brush/Roll: Mix by volume one part 545 Base with one part D3001 Converter to a smooth homogenous mixture; reduce 5-10% with T0031. Below 75°F you may use COLD CURE Accelerator M3066 to maintain dry and cure times. Induction Time after Mixing: 15 Minutes

Anticipated Pot Life at 77°F/50% R.H: 16 Hours

Application Instructions**Spray Application:**

Apply smooth, wet coats to fill and cover surface profile. 2-3 coats may be needed at 7-10 mils (175-250 microns) WFT yielding 2-3 mils (50-75 microns) DFT.

Brush or Roller Application:

Apply 2 coats at 3-4 mils (75-100 microns) WFT yielding 1.0-1.5 mils (25-37 microns) DFT per coat. Allow 12-14 hours between coats. Light sanding between coats will improve appearance. For large surfaces, rolling then tipping with a brush is preferred.

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

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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