

**PRODUCT DATA SHEET**  
**345 HS PRIMER**  
**R1011/R3011 or R8011/R3011**

**Features & Uses**

A two component high solids, VOC compliant epoxy finish primer. May be applied by spray, brush or roller.

**Specification Data**

**Type:** Low VOC Epoxy/modified aliphatic amine

**Packaging:** Available in 1 gallon containers

**Theoretical Coverage:** 332 Sq. Feet/gallon (8.1m<sup>2</sup> / litre) at 3 mils (75 microns) dry film thickness.  
249 Sq. Feet/gallon (6.1m<sup>2</sup> / litre) at 4 mils (100 microns) dry film thickness.

Calculated for mixed base and converter reduced 5%.

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.

**Recommended Wet Film Thickness:** 5-7 mils (125-175 microns) applied in 1 or 2 coats.

**Recommended Dry Film Thickness:** 3-4 mils (75-100 microns) applied in 1 or 2 coats.

**Recoatibility:** Minimum with itself at 77°F(25°C) 1 hour; with other products, 8-24 hours.

Maximum without sanding: 24 Hours. Sanding before overcoating with other products is recommended

**VOC:** White Base (R8011) – 96 g/lit or 0.80 lbs/gallon  
Gray Base (R1011) – 96 g/lit or 0.80 lbs/gallon  
Converter (R3011) – 520 g/lit or 4.3 lbs/gallon

Mixed components, reduced 5% with T0006 VOC is 334 g/lit, 2.79 lbs/gallon

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

White Base .....	R8011
Gray Base.....	R1011
Converter .....	R3011
Standard Reducer for Epoxy Primers .....	T0006
Slow Drying Reducer for Brush Applied Epoxy Primers and Urethane Topcoats .....	T0031
Equipment Cleaning .....	T0006 Reducers, Acetone or M.E.K

**DO NOT add Cold Cure Accelerator (M3066) to 345 HS Epoxy Primer**

**Application Equipment**

**BRUSHES AND ROLLERS**

Brushes must be recommended for use with solvent containing epoxy or urethane coatings. Natural bristle brushes work best. Do not use products recommended for water based coatings. Roller covers have similar requirements. They can be either foam or conventional mohair type, but must be solvent resistant.

Corona Brushes (813-885-2525) and Redtree Industries (973-481-0200) are good sources for brushes and roller covers. The Corona Urethamer or Redtree Chinese Ox would do a good job with 345HS Epoxy Primer.

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**SPRAY EQUIPMENT**

**Pressure Pot System Guns**

SATA or equivalent  
Spray Gun: K3 RP  
Fluid Nozzle: 1.1 mm  
Fluid Needle: 1.1 mm  
Pressure pot gauge should read 10 – 20 PSI (0.7-1.5 bar) atomization.

**High pot pressure could cause adverse coating defects.**

**Pressure Pot System Guns**

DeVILBISS or equivalent  
Spray Gun: GTI  
Fluid Nozzle: 1.1mm-1.4mm  
Air Nozzle: 122  
Pressure should be approximately 10-20 PSI (0,7 to 1,5 bar) on the pot and 30-65 PSI(2-4,5 bar) on the gun. (depending on compliancy)

**WARNING :**

**High pot pressure could cause adverse coating defects.**

**High Volume Low Pressure Guns**

DeVILBISS or equivalent pressure pot:  
For use with all Awlgrip Topcoats and low viscosity primers.  
Spray Gun: GTIW  
Fluid Nozzle: 1.1 -1.4  
Air Nozzle: 115 105/115 HVLP  
**HVLP equipment requires greater SCFM for proper application.**

**Cup Gun System**

SATA or equivalent  
Spray Gun: SATAjet 3000 RP  
Fluid Nozzle: 1.3mm  
Fluid Needle: 1.3 mm  
Atomizing air pressure should be approximately 30-40 PSI (2.1-2.8 bar)

**Cup Gun System**

DeVILBISS or equivalent  
Spray Gun: GTI  
Fluid Nozzle: 1.1mm-1.4mm  
Air Nozzle: 110  
Atomizing air pressure should be approximately 30-65 PSI (2-4,5 bar) pressure on the gun. (depending on compliancy)

**High Volume Low Pressure Guns**

Binks MACH 1 or equivalent pressure pot:  
For use with all Awlgrip Topcoats and low viscosity primers.  
Fluid Nozzle: #91 (.040" Orifice Size)  
#92 (.046" Orifice Size)  
Fluid Needle: #54-4382  
Air Nozzle: #93P  
**HVLP equipment requires greater SCFM for proper application.**

**Surface Preparation**

**Gelcoat/Fiberglass:** Sand with 100-150 grit paper.

**Wood:** smooth sand with 80-100 grit paper.

**Aluminium:** Sandblast/grind to 100% clean silver color or treat with Wash Primer CF. See Awlgrip application guide regarding surface preparation of Awlgrip fillers and surfacers.

**Mixing and Reduction**

Spray: Mix by volume 1 : 1, R8011 or R1011 : R3011.

Induction Time after Mixing: 10 Minutes

Mix base and converter thoroughly to achieve a smooth, homogenous mixture.

Reduce up to 5% with T0006.

Brush/Roll: Reduce 5% with T0031

Pot Life at 77°F (25°C)/50% R.H: approx. 2 hours, 50°F (10°C)/50% RH: approx 4 hours, 95°F (35°)/50% R.H approx 1hr. Higher temperatures may shorten pot life.

In areas not restricted by VOC requirements this Primer may be reduced further for spray application, up to 20% to suit individual applicator needs.

### **Application Instructions**

**Spray Application:**

Apply in even coats of 5-7 mils (125-175 microns) wet film thickness yielding 3-4 mils (75-100 microns) DFT.

**Brush or Roller Application:**

Apply 2 coats at 3 mils (75 microns) WFT yielding 2 mils (50 microns) DFT per coat. Allow 8 hours between coats at 77°F (25°C). Light sanding between coats will improve appearance. For large surfaces rolling, then tipping with a brush is preferred.

**WARNING:**

Temperature Range: Optimal Surface/Ambient Temperature range is 60°F (18°C) to 95°F (35°C). Proper application and/or cure results may be more difficult to achieve when conditions are outside this range.

Do not apply paint materials to surfaces less than 5°F (3°C) above dew point, or to surfaces warmer than 105°F (41°C). Ambient temperature should be minimum 50°F (10°C) and maximum 105°F (41°C).

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.