

Product Data Sheet

Epoxy Surfacing Primer

OD1030/OD3050



Intended Uses

Epoxy Surfacing Primer is a two component epoxy primer for use as a high build surfacing primer over fairing compounds. Do not use below the waterline.

Specification Data

Volume Solids	53% (unthinned), 42% (thinned)
Specific Gravity	1.66
Available Packs	1 Gallon
Base	D1030 - Light Gray
Converter	D3050 - Dark Grey
Reducer	T0006
Equipment Cleaning	For equipment cleaning use T0002 & T0006.

Theoretical Coverage

Application Methods	Number of Coats	Recommended Per Coat			Theoretical Coverage Per Coat (at recommended DFT)
		WFT	DFT	Max DFT	
Conventional Spray Pressure Feed, Air Assisted Airmix	2	225 µm 8.9 mil	95 µm 3.7 mil	105 µm 4.1 mil	5.6 m ² /lt 227.3 ft ² /Gal

Recommended WFT is based on 20% thinning with T0006.

Minimum WFT = 200µm and maximum WFT = 250µm (per coat)

After sanding, the minimum total DFT achieved must be 150 microns (6 mils).

A third coat may be necessary to achieve the minimum DFT.

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.



VOC

All VOC information contained herein is theoretical (unless otherwise stated). Actual VOC content may vary by batch and when tested via standard test methodology.

Product	As Supplied (without reducer)			
	g/l	lb/gal	g/Kg	lb/lb
D1030 Base	430	3.59	301	0.30
D3050 Converter	371	3.10	204	0.20
Epoxy Surfacing Primer	401	3.35	207	0.21



Surface Preparation

The surface preparation advice provided, and equipment suggestions, can be used as a guide. Preparation techniques and results will vary according to individual conditions, equipment choice/condition and other factors. Testing on a non-critical area should be carried out prior to full-scale preparation.

Product is only approved for use over approved fairing compounds. These should be sanded (finishing with P120) before application of Epoxy Surfacing Primer.



Mixing & Reduction

Mixing and reduction requirements will vary according to individual conditions, climate, equipment choice/condition and other factors. Mixing and application of a small sample before full-scale application is recommended.

Application Methods	Mix Ratio (Base:Converter)	Reducer	Recommended Thinning	Spraying Viscosity
Conventional Spray Pressure Feed	1:1 by volume	T0006	20 %	-
Air Assisted Airmix	1:1 by volume	T0006	10 %	-



Application

Application equipment and parameters are given as a guide. Actual equipment choices will vary according to application conditions, equipment condition and other factors. Testing on a non-critical area should be carried out prior to full-scale application. Contact your local technical service representative for further advice if necessary.

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

Application Methods	Fluid Tip	Fluid Pressure	Fluid Flow Rate	Air Pressure
Conventional Spray Pressure Feed	1.40 - 1.80 mm 55 - 71 thou	-	225 - 250 cc/min	2.5 - 3 bar 36 - 44 psi
Air Assisted Airmix	0.48 - 0.89 mm 19 - 35 thou	-	-	5 - 6 bar 73 - 87 psi

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To minimise texture on application, conventional spray application is recommended

Air assisted air mix inlet air pressure recommendation is based on a pump @ 45:1 ratio.



Recoatability & Drying Times

The data given for recoatability is not exhaustive. Actual recoatability can vary according to individual conditions, climate and surroundings. If unsure, consult your local technical service representative before proceeding.

Drying	15°C (59°F)	23°C (73°F)	35°C (95°F)
Touch Dry	3.5 Hours	3 Hours	1.5 Hours
Hard Dry	7.5 Hours	5 Hours	2.5 Hours
Pot Life	6 Hours	6 Hours	6 Hours

Overcoated By	15°C (59°F)		23°C (73°F)		35°C (95°F)	
	Min	Max	Min	Max	Min	Max
Self	3 Hours	5 days	2 Hours	5 days	1 Hours	5 days
545 Epoxy Primer	24 Hours	5 days	18 Hours	5 days	12 Hours	5 days

Maximum overcoating times are without sanding. For best aesthetical result Epoxy Surfacing Primer should be sanded before overcoating with 545 Epoxy Primer.



Warning Notes

Do not apply paint materials to surfaces less than 3°C (37°F) above dew point, or to surfaces warmer than 41°C (105°F). Ambient temperature should be minimum 10°C (50°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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