

**PRODUCT DATA SHEET
ULTRA BUILD EPOXY PRIMER
D8008/D3018**



Features & Uses

A two component epoxy primer with excellent sag resistance and excellent film build/filling capability. For use where high build and filling is required above the waterline.

Specification Data

Type: Epoxy Polyamide.

Packaging: Available in 1 gallon and 1 quart containers.

Theoretical Coverage: Sq. Feet/Gallon 946 Sq. Feet (88 m²) at one mil dry (25 microns)
47-63 Sq. Feet (4-6 m²) at recommended dry film thickness. Calculated for mixed base and converter reduced 10%.
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: 25-30 mils (625-750 microns).

Recommended Dry Film Thickness: 15-20 mils (375-500 microns).

Recoatibility: May be overcoated with 545 Primer, High Build Primer, Sprayable Fairing Compound, Awlfair LW and Awlquik.
Minimum with itself: 1 hour; other products: 12 hours.
Maximum without sanding: 24 hours. Sanding before overcoating with other products is recommended.

VOC: Base (D8008) - 392 g/lit or 3.3 lbs/gallon
Converter (D3018) – 189 g/lit or 1.6 lbs/gallon

Product Components, Reducers, Additives, and Auxiliary Components

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|--------------------------|--|
| White Base | D8008 |
| Converter | D3018 |
| Reducer | T0073 |
| Equipment Cleaning | T0073, T0006 or 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 to 25 lbs.
Atomizing pressure 50+ lbs.

High Volume Low Pressure Guns

Binks MACH 1 or equivalent pressure pot:
Fluid Nozzle: #97 (.070" Orifice Size)
Fluid Needle: #54-4382
Air Nozzle: #97P

Airless Equipment

Binks or equivalent:
Spray Gun: Airless 1
Orifice Size: .028" - .043"
Fan Size & Angle: 8" – 80°, or 6" – 60°
On a 25-1 pump, the pressure gauge should read 70 to 80 lbs.
On a 40-1 pump, the pressure gauge should read 50 to 60 lbs.

Surface Preparation

This product can be applied over other properly prepared Awlgrip Primers or Fillers.

Mixing and Reduction

Mix by volume one part D8008 with one part D3018 to a smooth homogenous mixture. Reduce 5%-25% with T0073 for conventional spray. Airless spray application can be made with no reduction. Example: 10 oz. D8008, 10 oz. D3018, 2 oz. T0073 (10% reduction).

Induction Time after Mixing: 15 Minutes.

Anticipated Pot Life at 77°F(25°C)/50% R.H: 8 Hours

Application Instructions

Apply in smooth, even coats, allow one hour between coats at 77°F(25°C)/50% R.H.

Note: Do not apply more than 2 coats without allowing to cure hard (12-24 hours). 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).

Warning:

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 55°F(13°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.