

Features & Uses

Hullgard Epoxy Primer is a two component epoxy primer that combines excellent anticorrosion and water barrier properties with anti-fouling tie-coat functionality. It offers a long overcoating interval without sanding to reduce work time for underwater systems.

Specification Data

Type: Two component epoxy

Color: Buff

Packaging: Available in a 1 Gallon container (base, filled to ¾ GL) and 1 Quart (converter, filled to 1QT). Mixed volume 1 US Gallon. Theoretical Coverage – 140 Sq. feet/gallon = 3.5 m²/litre at 5.5 mils/135 microns DFT or 360 Sq. feet/ gallon (9m²/lt) at 2 mils/ 50 microns 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.

Recommended Wet Film Thickness: 12 mils (300 microns) per coat by spray, 4 mils (100 microns) per coat by brush/roller.

Recommended Dry Film Thickness: 5.5 mils (138 microns) per coat by spray, 2 mils (50 microns) per coat by brush/roller.

Number of coats: See application instructions

Anticipated drying time at 77°F/25°C: 2 hours touch dry; 7 hours hard dry.

Recoatability (At 77°F/ 25°C, 50% RH):

With Itself: 2 hours (minimum)

Maximum recoat time without sanding 6 months. Inspection for cleanliness recommended prior to subsequent application. Ensure dust is removed and remove any dirt pick-up with T0006. If recoatability time is exceeded abrade using 180 – 220 grit paper.

With Antifouling: Minimum 2 hours by brush/roller or 6 hours by spray at recommended film thickness.

Maximum recoat time 7 hours by brush/roller or 16 hours by spray at recommended film thickness.

VOC: Base (D6070) – 391g/lt or 3.26 lbs/gallon

Converter (D3707) – 634 g/lt or 5.29 lbs/gallon

Product Components, Reducers, Additives, and Auxiliary Components

Base - Buff ColorD6070

ConverterD3707

Reducer..... T0006

Equipment Cleaning..... T0006 , T0002 or M.E.K.

Application Equipment

Apply by airless spray, air atomized spray, brush or roller. Airless spray is the most efficient way to apply this product

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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.....#68SS (.110" Orifice size)

Fluid needle.....#668

Air nozzle.....#68PB

Pressure gauge should read 15-25 lbs. Atomizing pressure 50+ lbs.

Surface Preparation

Hullgard Epoxy Primer may be directly applied to grit blasted steel in accordance with SSPC-SP10 to a 2-3 mil (50-75 microns) profile (or Sa2 ½ outside of the US). Alternatively power grind with a 24 to 36 disc to obtain profile. Fiberglass should be degreased with powdered household detergent followed by a solvent wipe. The surface should then be sanded with 180 grit paper. May also be applied to clean, dry wood. Abrade the wood using 80 – 180 grit paper. Any previous antifouling paint should be removed prior to application of Hull-Gard Epoxy Primer.

Mixing and Reduction

Check for settling, then thoroughly mix the base until a consistent homogenous blend is obtained. Power mixers or shakers are preferred. If not available thorough hand mixing is acceptable. Add converter and again mix thoroughly. Mix ratio by volume is 3 parts D6070 to 1 part D3707. Reduction is not normally required but at lower temperatures small amounts (5%) of T0006 can be added. Do not reduce more than 15% per gallon kit.

Induction time after mixing: 10 minutes

Anticipated Pot Life at 25°C/ 77°F, 50% RH: 3 hours

Application Instructions

Apply by airless spray, air atomized spray, brush or roller. **NOTE:** Only apply **Hullgard Epoxy** by roller if applying over **Max Cor CF** due to risk of snagging roller fibers. Apply 12 mils (300 microns) WFT yielding 5.5 mils (135 microns) DFT per coat. Three coats at the recommended film thickness are needed for the Standard Recoat System.

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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