

Features & Uses

545 Clear Epoxy Primer is a high performance two component sealer ideal for use on carbon fiber and wood constructions. The product provides a good build coat and may be recoated with Awlgrip Urethane clears or varnishes where UV protection is required.

Specification Data

Type: Epoxy Polyamide
Color: Clear
Packaging: Available in 1 gallon containers.

Theoretical Coverage: Sq. Feet / Gallon based on mixed base and converter thinned 25% with T0006 315 Sq. feet at 1 mil dry (29m² at 25 micron dry). 135 - 180 Sq. feet (12.5 – 16.7m²) at recommended dry film thickness (3 coats)
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 (spray or brush): 3 - 4 mils (75 - 100) per coat
Recommended Dry Film Thickness (spray or brush): 0.5 - 0.75 mils (15 - 20 microns) per coat

Number of coats: 2 - 3 coats required

Recoatibility: (At 77°F/ 25°C, 50% RH): Spray: Minimum with itself 1 hour, with other products 12 hours. Brush/ Roller: minimum with itself 12 – 14 hours, with other products 12 – 14 hours.

Maximum without sanding: 24 hours. Sanding is recommended to improve adhesion and appearance.

Recoat with Awlgrip High Gloss Clear , Awlcraft 2000 High Gloss Clear, Awlbrite Clear Gloss or Semi-gloss, Awlspar varnish, Awlspar High Solids Varnish, 545 and Awl-Quik.

VOC: 689 g/l or 5.74 lbs/gallon (mixed product with 25% T0006)
Per component: D3020 Clear base 678 g/l or 5.66 lbs/gallon. D3001 converter 616 g/l or 5.15 lbs/gallon.

Product Components, Reducers, Additives, and Auxiliary Components

Clear Base	D3020
Converter	D3001
Spray Reducer	T0006
Brush Reducer	T0031
COLD CURE Accelerator	M3066
Equipment Cleaner.....	T0006 or T0002 Reducers or M.E.K.

Application Equipment

Conventional spray and brush / roller. Spray equipment as follows:

Air Atomized
Siphon or Cup System
Binks or equivalent:
Spray gun: #95
Fluid nozzle: #66SS (.070" Orifice size)
Fluid needle: #665
Air nozzle: #66SK
Atomizing air pressure should be approx. 50 – 60 lbs.

Pressure Pot System Guns
Binks or equivalent
Spray gun: #95
Fluid nozzle: #63BSS (.046" Orifice Size)
Fluid needle: #663A
Air nozzle: #63PW
Pressure Pot gauge should read 8 – 12 lbs with 50-60 lbs atomization.

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Surface Preparation

Wood/ Composite: Smooth sand with 80-100 grit paper.

Mixing and Reduction

Mix ratio by volume is 1 part D3020 to 1 part D3001. Reduce up to 25% with T0006 (40% for the first coat on wood).

Overall mix is 1:1:½ by volume. Example: 8 oz. D3020, 8 oz. D3001, and 4 oz. T0006

Induction time after mixing: 15 minutes

Anticipated Pot Life at 77°F/ 25°C, 50% RH: 8 hours

Application Instructions**For Wood Application:**

Apply one coat thinned 40% with T0006 or T0031 (applied as below) to wet out the substrate prior to coat schedule listed below.

Spray Application:

Apply smooth, wet coats to fill and cover surface profile. Two to three coats may be needed at 3 - 4 mils (75 - 100 microns) WFT yielding 0.5 - 0.75 mils (15 - 20 microns) DFT per coat.

Brush or Roller Application:

Apply two coats at 3 - 4 mils (75 - 100 microns) WFT yielding 0.5 - 0.75 mils (15 - 20 microns) DFT per coat. Allow 12-24 hours between coats. Light sanding between coats will improve appearance. For large surfaces rolling, then tipping with a brush is preferred.

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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