



# PRODUCT DATA SHEET MAX COR HIGH SOLIDS ANTI-CORROSIVE PRIMER R4001/R3203

## Features & Uses

Excellent Low VOC Anti-Corrosive primer for use on steel or aluminum. Can be overcoated with any Awlgrip family topcoat on smooth surfaces or used under primers on fairing projects. Do not use below waterline.

## Specification Data

Type: Modified Epoxy Resin

Color: Green

Packaging: Available in a 1 Gallon Kit (3/4 gal R4001 (2.839lt) : 1QT R3203 (0.946lt))

Theoretical Coverage - Sq. Feet/Gallon; 953 Sq. Feet (88 m<sup>2</sup>) at 1 mil dry (25 microns); 1,058 to 1,588 Sq. Feet (98 to 147 m<sup>2</sup>) at recommended dry film thickness.

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: 1.0 - 1.5 mils (25-38 microns) per coat.

Recommended Dry Film Thickness: 0.6 - 0.9 mils (15-23 microns) per coat.

Recoatability at 77°F (25°C) /50% R.H: 4 to 16 hours to recoat; After 16 hours. Plan work schedules to allow recoat/overcoating within the four-sixteen hour window. If more than sixteen hours elapse before overcoating can occur, smooth surfaces can be abraded with a SCOTCHBRITE pad prior to recoat/overcoating. After 24 hours sand with 280-320 Grit sand paper. However, it is essential that the correct personal protective equipment is worn. Ground or sandblasted surfaces must be abraded with a grit appropriate to the surface profile before re-coating or overcoating. Due to its relatively low film thickness any significant abrading of the surface creates the need to reapply the Max Cor to have proper anti-corrosive performance.

VOC: Base (R4001) - 327 g/lit or 2.7 lbs/gallon  
Converter (R3203) - 374 g/lit or 3.1 lbs/gallon

## Product Components, Reducers, Additives, and Auxiliary Components

Base .....R4001  
Converter .....R3203  
Reducer ..... T0006  
Equipment Cleaning ..... T0002, T0006 or M.E.K

## Application Equipment

Air atomized, HVLP, airless, or air assisted airless equipment in conventional versions may be used. Use set ups recommended for low viscosity, fine finish coatings.

## Surface Preparation

The surface must be clean and dry, free of all dirt, grease and oil. Use T0008 Surface Cleaner or T0115 Wax and Grease Remover.

### For optimum Results:

ALODINE – De-oxidize with ALUMIPREP 33 or SCOTCHBRITE Pads and water. Treat surface with ALODINE 1201 Chrome Conversion Coating.

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### Alternative Method:

Where local health and environmental laws preclude the use of a chromate conversion coating (Alodine), the aluminum surface should be scrubbed with an alkaline detergent and SCOTCHBRITE Pads. Thoroughly rinse with tap water to a water breakfree surface. Repeat as needed until a breakfree surface is obtained.

Grind or sandblast the surface to reach quality appropriate to the specification. SSPC-SP%-85 for steel (Sa 2<sup>1/2</sup>). 2<sup>1/2</sup> to 3 mils (63-75 microns) with bright metal for aluminum.

### Mixing and Reduction

Mix by volume 3 parts R4001 with 1 part R3203 until one smooth, homogenous mixture is obtained. T0006 Reducer can be added at up to 15% of the mixed volume of R4001/R3203 (3:1:0.6) to improve flow. Add T0006 after the induction period. Example: 9oz R4001, 3 oz R3203, 1.8oz T0006.

Induction Time after Mixing: At 18°C (65°F) or above after mixing, allow to induct for 15 minutes then agitate before using. Below 18°C (65°F) after mixing, allow to induct for 1 hour then agitate before using.

Anticipated Pot Life at 25°C (77°F), 50% R.H: 3 Hours.

### Application Instructions

Spray apply one smooth wet coat at 1.5 mils WFT yielding 0.9 mils dry film. Do not exceed maximum recommended dry film thickness.

### Warning:

Do not exceed the recommended wet film thickness. Do not sand Max Cor Anti-Corrosive Primer without the proper personal protective equipment. Refer to the Material Safety Datasheet for guidance on personal protective equipment.

Temperature Range: Optimal Surface/Ambient Temperature range is 18°C (65°F) to 35°C (95°F). 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 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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