PRODUCT DATA SHEET
345 HS PRIMER
R1011/R3011 or R8011/R3011

Features & Uses

A two component high solids, VOC compliant epoxy finish primer. May be applied by spray, brush or roller.

Specification Data

Type: Low VOC Epoxy/modified aliphatic amine
Packaging: Available in 1 gallon containers
Theoretical Coverage: 332 Sq. Feet/gallon (8.1m^2 / litre) at 3 mils (75 microns) dry film thickness.
249 Sq. Feet/gallon (6.1m^2 / litre) at 4 mils (100 microns) dry film thickness.
Calculated for mixed base and converter reduced 5%

Recommended Wet Film Thickness: 5-7 mils (125-175 microns) applied in 1 or 2 coats
Recommended Dry Film Thickness: 3-4 mils (75-100 microns) applied in 1 or 2 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 environment
Recoatability: Minimum with itself at 77°F(25°C) 1 hour; with other products, 8-24 hours. Maximum without sanding: 24 Hours. Sanding before overcoating with other products is recommended

VOC: White Base (R8011) – 96 g/lt or 0.80 lbs/gallon
Gray Base (R1011) – 96 g/lt or 0.80 lbs/gallon
Converter (R3011) – 520 g/lt or 4.3 lbs/gallon

Mixed components, reduced 5% with T0006 VOC is 334 g/lt, 2.79 lbs/gallon

Product Components, Reducers, Additives, and Auxiliary Components

White Base R8011
Gray Base..... R1011
Converter R3011
Standard Reducer for Epoxy Primers T0006
Slow Drying Reducer for Brush Applied Epoxy Primers and Urethane Topcoats T0031

Equipment Cleaning ..... T0006 Reducers, Acetone or M.E.K

DO NOT add Cold Cure Accelerator (M3066) to 345 HS Epoxy Primer

Application Equipment

BRUSHES AND ROLLERS

Brushes must be recommended for use with solvent containing epoxy or urethane coatings. Natural bristle brushes work best. Do not use products recommended for water based coatings. Roller covers have similar requirements. They can be either foam or conventional mohair type, but must be solvent resistant.
Corona Brushes (813-885-2525) and Redtree Industries (973-481-0200) are good sources for brushes and roller covers. The Corona Urethaner or Redtree Chinese Ox would do a good job with 345HS Epoxy Primer

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SPRAY EQUIPMENT

Pressure Pot System Guns
SATA or equivalent
Spray Gun: K3 RP
Fluid Nozzle: 1.1 mm
Fluid Needle: 1.1 mm
Pressure pot gauge should read 10 – 20 PSI (0.7-1.5 bar) atomization.
High pot pressure could cause adverse coating defects.

Cup Gun System
SATA or equivalent
Spray Gun: SATAjet 3000 RP
Fluid Nozzle: 1.3mm
Fluid Needle: 1.3 mm
Atomizing air pressure should be approximately 30-40 PSI (2.1-2.8 bar)

Pressure Pot System Guns
DeVILBISS or equivalent
Spray Gun: GTI
Fluid Nozzle: 1.1mm-1.4mm
Air Nozzle: 122
Pressure should be approximately 10-20 PSI (0,7 to 1,5 bar) on the pot and 30-65 PSI(2-4,5 bar) on the gun. (depending on compliancy)

Cup Gun System
DeVILBISS or equivalent
Spray Gun: GTI
Fluid Nozzle: 1.1mm-1.4mm
Air Nozzle: 110
Atomizing air pressure should be approximately 30-65 PSI (2-4,5 bar) pressure on the gun. (depending on compliancy)

WARNING :
High pot pressure could cause adverse coating defects.

High Volume Low Pressure Guns
DeVILBISS or equivalent pressure pot:
For use with all Awlgrip Topcoats and low viscosity primers.
Spray Gun: GTIW
Fluid Nozzle: 1.1 -1.4
Air Nozzle: 115 105/115 HVLP
HVLP equipment requires greater SCFM for proper application.

High Volume Low Pressure Guns
Binks MACH 1 or equivalent pressure pot:
For use with all Awlgrip Topcoats and low viscosity primers.
Fluid Nozzle: #91 (.040" Orifice Size)
#92 (.046" Orifice Size)
Fluid Needle: #54-4382
Air Nozzle: #93P
HVLP equipment requires greater SCFM for proper application.

Surface Preparation

Gelcoat/Fiberglass: Sand with 100-150 grit paper. Wood: smooth sand with 80-100 grit paper. Aluminium: Sandblast/grind to 100% clean silver color and apply 345 HS Primer within 8 hours of surface preparation being carried out. For premium corrosion resistance apply 30-Y-94 or Max Cor Primer prior to application of 345 HS Primer. See Awlgrip application guide regarding surface preparation of Awlgrip fillers and surfacers.

Mixing and Reduction

Spray: Mix by volume 1 : 1, R8011 or R1011 : R3011.
Induction Time after Mixing: 10 Minutes
Mix base and converter thoroughly to achieve a smooth, homogenous mixture.
Reduce up to 5% with T0006.
Brush/Roll: Reduce 5% with T0031
Pot Life at 77°F (25°C)/50% R.H: approx. 2 hours, 50°F (10°C)/50% RH: approx 4 hours, 95°F (35°)/50% R.H approx 1hr. Higher temperatures may shorten pot life.
In areas not restricted by VOC requirements this Primer may be reduced further for spray application, up to 20% to suit individual applicator needs.

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Application Instructions

Spray Application:
Apply in even coats of 5-7 mils (125-175 microns) wet film thickness yielding 3-4 mils (75-100 microns) DFT.

Brush or Roller Application:
Apply 2 coats at 3 mils (75 microns) WFT yielding 2 mils (50 microns) DFT per coat. Allow 8 hours between coats at 77°F (25°C). Light sanding between coats will improve appearance. For large surfaces rolling, then tipping with a brush is preferred.

WARNING:
Temperature Range: Optimal Surface/Ambient Temperature range is 60°F (18°C) to 95°F (35°C). 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 5°F (3°C) above dew point, or to surfaces warmer than 105°F (41°C). Ambient temperature should be minimum 50°F (10°C) and maximum 105°F (41°C).

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