PRODUCT DATA SHEET
FINAL PRIME 5.0 R8028/R3228

Features & Uses

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

Specification Data

Type: Modified Low VOC Epoxy Resin
Packaging: Available in 1 gallon and 1 quart containers
Theoretical Coverage: Sq. Feet/Gallon 978 Sq. Feet (90m^2) at one mil dry
123-245 Sq. Feet (11-23m^2) at recommended dry film thickness with 2 coats
Calculated for mixed base and converter reduced 5%.
Recommended Wet Film Thickness: 3-6 mils (75-150 microns) per coat
Recommended Dry Film Thickness: 2-4 mils (50-100 microns) per coat. 2–3 coats recommended.
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, 12-24 hours. Maximum without sanding: 24 Hours. Sanding before overcoating with other products is recommended. Don't leave the sanded surface more than 5 days before recoating. Recoat times will double every 10°F (5°C) below 77°F (25°C)

VOC (EU and AP): Base (R8028) – 241 g/lt or 2.0 lbs/gallon
Converter (R3228) – 527 g/lt or 4.4 lbs/gallon

Mixed components, reduced 5% with T0006 VOC is 3.41 lbs/gal, 408 grams/L. For brush/roller applications reduced 5% with T0031 VOC is 3.42 lbs/gal, 410 grams/L.

VOC (US): Base (R8028) – 194 g/lt or 1.6 lbs/gallon
Converter (R3228) – 460 g/lt or 3.6 lbs/gallon

Mixed components, reduced 5% with T0163 VOC is 2.75 lbs/gal, 330 grams/L. Reduced 5% with T0006 VOC is 2.95 /lbs/gal, 353 grams/L. For brush/roller applications reduced 5% with T0031 VOC is 2.99 lbs/Gal, 358 grams/L.

Product Components, Reducers, Additives, and Auxiliary Components

Final Prime 5.0 Base R8028
Final Prime 5.0 Converter R3228
Standard Reducer for Epoxy Primers T0006
Slow Drying Reducer for Brush Applied Epoxy Primers and Urethane Topcoats.....T0031
Equipment Cleaning ..... T0006, T0002 Reducers, Acetone, Lacquer Thinner, or M.E.K.

DO NOT add Cold Cure Accelerator (M3066) to Final Prime 5.0

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Application Equipment

SPRAY EQUIPMENT

Pressure Pot System Guns
Binks or equivalent:
Spray Gun: #95
Fluid Nozzle: #63BSS (.046" Orifice Size)
Fluid Needle: #663A
Air Nozzle: #63PB
Pressure pot gauge should read 8 to 12 lbs. with 50 to 60 lbs. atomization.
Or achieve 3 fluid ounces per minute when using correct pot pressure.
High pot pressure could cause adverse coating defects.

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 CFM's for proper product application.

Siphon or Cup Gun System
Binks or equivalent:
Spray Gun: #95
Fluid Nozzle: #66SS (.070" Orifice Size)
Fluid Needle: #665
Air Nozzle: #65SK
Atomizing air pressure should be approximately 50 to 60 lbs.

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 Final Prime 5.0.

Surface Preparation

Gelcoat/Fiberglass: Sand with 100-150 grit paper. Wood: smooth sand with 80-100 grit paper. See Awlgrip application guide edition 12 regarding surface preparation of Awlgrip fillers and surfacers.

Mixing and Reduction

Spray: Mix by volume one part Final Prime 5.0 Base R8028 with one part Final Prime 5.0 Converter R3228 to a smooth, homogenous mixture.
Induction Time after Mixing: 15 Minutes
Reduce a minimum of 5% with T0006.
Example: 8 oz. (236ml) Final prime 5.0 Base R8028, 8 oz. (236ml) Final Prime 5.0 Converter R3228, 0.8 oz.(24ml) T0006, 5% Reduction (If local VOC restrictions allow.)
Brush/Roll: Reduce 5% with T0031 (If local VOC restrictions allow.)
Anticipated Pot Life at 77°F/50% R.H: 3 Hours. Higher temperatures may shorten pot life.

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Application Instructions

Spray Application:
Apply Final Prime 5.0 in even coats of 3-6 mils (75-150 microns) wet film thickness yielding 2-4 mils (50-100 microns) DFT. Two coats may be needed to fill and cover surface profile at 6-12 mils total WFT yielding 4-7 mils DFT. Do not apply more than 3 coats per day without allowing for over night dry and sanding.

Brush or Roller Application:
Apply 2 coats at 3-6 mils (75-150 microns) WFT yielding 2-4 mils (50-100 microns) DFT. per coat. Allow 12-14 hours between coats. 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 18°C (60°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 10°C (50°F) and maximum 41°C (105°F).

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