

Product Data Sheet

Hullgard Extra Epoxy Primer

D6120/D3730



Intended Uses

Hullgard Extra Primer is a two component epoxy substrate primer with excellent anticorrosive properties. It offers excellent aged recoatability and provides a perfect base for subsequent fairing with Awlfair fairing compound.

Specification Data

Volume Solids	46%
Specific Gravity	1.37
Available Packs	1 US Quart, 1 US Gallon, 5 US Gallon (EU only)
Base	D6120 Base
Converter	D3730 Converter
Reducer	T0006
Equipment Cleaning	T0002, T0006

Theoretical Coverage

Application Methods	Number of Coats	Recommended Per Coat			Theoretical Coverage Per Coat (at recommended DFT)
		WFT	DFT	Max DFT	
Airless Spray, Conventional Spray	1	217 µm 8.5 mil	100 µm 3.9 mil		4.6 m ² /lt 187.4 ft ² /Gal
Brush, Roller	2	130 µm 5.1 mil	60 µm 2.4 mil		7.7 m ² /lt 313.7 ft ² /Gal

Multiple coats may be required when using roller or brush.

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.



VOC

All VOC information contained herein is theoretical (unless otherwise stated). Actual VOC content may vary by batch and when tested via standard test methodology.

Product	As Supplied (without reducer)			
	g/l	lb/gal	g/Kg	lb/lb
D6120 Base	482	4.02		
D3730 Converter	376	3.14		
Hullgard Extra Epoxy Primer	468	3.91		



Surface Preparation

The surface preparation advice provided, and equipment suggestions, can be used as a guide. Preparation techniques and results will vary according to individual conditions, equipment choice/condition and other factors. Testing on a non-critical area should be carried out prior to full-scale preparation.

Hullgard Extra may be directly applied to grit blasted steel in accordance with SSPC-SP10 to a 2-3 mil (50-75 micron) profile (or Sa2 ½ outside of the US). Alternatively power grind with a 24-36 grit disc to obtain profile. May also be applied to abraded aluminium (36 grit disc) and fibreglass (degrease and abrade using 180 grit paper). For the ultimate anticorrosive system first apply a coat of Max Cor CF to the suitably prepared steel or aluminium substrate (refer to Max Cor CF datasheet for further information on surface preparation and overcoating times). Wood should be clean and sanded with 80-180 grit paper.

For underwater applications do not apply antifouling direct to Hullgard Extra Epoxy Primer. Apply a coat of Hullgard Epoxy Primer (EU only) prior to antifouling application.



Mixing & Reduction

Mixing and reduction requirements will vary according to individual conditions, climate, equipment choice/condition and other factors. Mixing and application of a small sample before full scale application is recommended.

Application Methods	Mix Ratio (Base:Converter)	Reducer	Recommended Thinning	Spraying Viscosity
Airless Spray, Conventional Spray, Brush, Roller	10:1.50 by volume	T0006	0 - 15 %	-

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 thoroughly mix again. Mix ratio by volume is 10 parts D6120 to 1.5 parts D3730. Reduction is not normally required but at lower temperatures small amounts (5%) of T0006 can be added. Do not reduce more than 15%. Induction time = 10 minutes.



Application

Application equipment and parameters are given as a guide. Actual equipment choices will vary according to application conditions, equipment choice/condition and other factors. Testing on a non-critical area should be carried out prior to full-scale application. Contact your local technical service representative for further advice if necessary.

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Airless spray is the most efficient way to apply this product.

Roller application of Hullgard Extra Epoxy Primer direct to metal should be avoided due to the risk of snagging fibers.

Do not apply paint materials to surfaces less than 3°C (37°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).



Recoatability & Drying Times

The data given for recoatability is not exhaustive. Actual recoatability can vary according to individual conditions, climate and surroundings. If unsure, consult your local technical service representative before proceeding.

Drying	15°C (59°F)	23°C (73°F)	35°C (95°F)
Touch Dry	2 Hours	1 Hours	1 Hours
Hard Dry	48 Hours	24 Hours	12 Hours
Pot Life	8 Hours		

Overcoated By	15°C (59°F)		23°C (73°F)		35°C (95°F)	
	Min	Max	Min	Max	Min	Max
Hullgard Epoxy Primer Spray, Hullgard Extra Epoxy Primer			2 Hours	Extended		
Awlfair LW, Awlfair LW / Fast			16 Hours	Extended		

Maximum recoat time without sanding is 6 months. Inspection for cleanliness is recommended. Do not wipe with solvents.



Warning Notes

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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