

**PRODUCT DATA SHEET
HULLGARD EXTRA EPOXY PRIMER
D6120/D3730**



Application Equipment

Apply by airless spray, air atomized spray, brush or roller. Airless spray is the most efficient way to apply this product

Airless Equipment

Graco or Binks equivalent:

Orifice Size.....019" – .021"
Fan size & Angle.....8" – 80°, or 6" – 60°
On a 25-1 pump, the input pressure gauge should read 70 to 80 lbs.
On a 40-1 pump, the input pressure gauge should read 50 to 60 lbs.

Pressure Pot

Spray gun.....#95
Fluid nozzle.....#68SS (.110" Orifice size)
Fluid needle.....#668
Air nozzle.....#68PB
Pressure gauge should read 15-25 lbs. Atomizing pressure 50+ lbs.

Surface 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 to 36 grit disc to obtain profile. May also be applied to abraded aluminum (36 grit disc) and fiberglass (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.

Mixing and Reduction

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

Application Instructions

Apply by airless spray, air atomized spray, brush or roller. **NOTE: Roller application of Hullgard Extra direct to metal should be avoided due to the risk of snagging fiber.** Apply 9 mils (225 microns) WFT yielding 4 mils (100 microns) DFT per coat. Multiple coats may be required when using roller or brush.

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.