

Product Data Sheet



545 Epoxy Primer

D8001/D3001 or D1001/D3001



Intended Uses

545 Epoxy Primer is a multi-use, corrosion-resistant epoxy primer used to seal undercoats and surfacing primers before applying finishes. Can be applied both above and below the waterline on a wide range of substrates, via spray or brush and roller.

- Dual purpose; seals both undercoats and surfacing primers in a single product
- Outstanding corrosion protection, increasing the longevity of your system
- Excellent adhesion to all substrates

Specification Data

Volume Solids	40% (unthinned)
Specific Gravity	1.25
Available Packs	1 US Quart, 1 US Gallon
Base	D8001 White Base, D1001 Gray Base
Converter	D3001 Converter
Reducer	T0006 (Spray), T0031 (Brush)
Equipment Cleaning	T0002, T0006
Typical Shelf Life	2 years

Theoretical Coverage

Application Methods	Number of Coats	Recommended Per Coat			Theoretical Coverage Per Coat (at recommended DFT)
		WFT	DFT	Max DFT	
Brush, Roller, Air Atomized	3	87 µm 3.4 mil	35 µm 1.4 mil	45 µm 1.8 mil	11.6 m ² /lt 472.6 ft ² /Gal

After sanding, the minimum recommended DFT is 50-75 microns (2-3 mil). A further coat may be necessary to achieve the minimum DFT.

Coverage calculations are based on theoretical transfer efficiency of 100%. Actual coverage rate obtained will vary according to equipment choice, thinning, 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 from one color to another and when tested via standard test methodology.

Product	As Supplied (without reducer)			
	g/L	lb/gal	g/Kg	lb/lb
OD1001 Base	413	3.45	274	0.27
OD8001 Base	414	3.46	272	0.27
OD3001 Converter	622	5.19	631	0.63
545 Epoxy Primer	518	4.32	414	0.41



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.

GRP: Remove all surface contamination (waxes, mold release products, dirt, grease etc). Sand with P150 - P220 grade (grit) paper.

Steel: Grit blast to white metal in accordance with SSPC-SP10 (Sa 2½) to a 2-3 mils (50-75 microns) profile.

Aluminium: Grind with 36 grit disc or blast to bright, clean aluminium. The metal must be bright silver and completely free of gray oxidation. The surface profile must be a 2-3 mils profile (50-75 microns).

Wood: The wood should be clean and dry. Sand the surface with 80-120 grit paper. Blow off the surface with clean, dry compressed air while wiping with clean rags to remove sanding and dust residue.



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
Brush, Roller	1:1 by volume	T0031	5 - 10 %	-
Air Atomized	1:1 by volume	T0006	0 - 25 %	-

Mix by volume one part Base with one part Converter to a smooth, homogenous mixture.

Brush - Below 25°C (77°F) you may use COLD CURE Accelerator (M3066) to maintain dry and cure times.

Induction Time after Mixing = 15 Minutes.



Application

Application equipment and parameters are given as a guide. Actual equipment choices will vary according to application conditions, equipment 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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For wood substrates, first seal the wood with a light coat of 545 Epoxy Primer (spray) reduced 40% with T0006. Allow to cure for 12-16 hours.

Application Methods	Fluid Tip	Fluid Pressure	Fluid Flow Rate	Air Pressure
Air Atomized	1.00 - 1.40 mm 39 - 55 thou	1.8 - 2.2 bar 26 - 32 psi	180 - 280 cc/min	1.8 - 2.2 bar 26 - 32 psi



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)	25°C (77°F)	35°C (95°F)	
Hard Dry	10 Hours	6 Hours	3 Hours	
Touch Dry	3 Hours	2 Hours	30 Minutes	
Pot Life	16 Hours	16 Hours	8 Hours	

Overcoated By	15°C (59°F)		25°C (77°F)		35°C (95°F)			
	Min	Max	Min	Max	Min	Max		
545 Epoxy Primer Brush/Roller, Awlcraft 2000, Awlcraft SE, Awlgrip HDT, Awlgrip Topcoat, Awlquik, High Build, Ultra Build	16 Hours	24 Hours	12 Hours	24 Hours	8 Hours	24 Hours		
545 Epoxy Primer Spray	2 Hours	24 Hours	60 Minutes	24 Hours	60 Minutes	24 Hours		

After 24 hours, sanding is required.

Sanding is recommended to improve adhesion and appearance.



Warning Notes

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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