



## HIGH BUILD EPOXY PRIMER: D9002/D3002; D8002/D3002

### Features & Uses

A two component epoxy primer for use where high build and filling is required. Not to be used below the waterline.

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### Specification Data

Type: Epoxy Polyamide

Packaging: Available in 1 gallon and 1 quart containers

Theoretical Coverage: Sq. Feet/Gallon

793 Sq. Feet at one mil dry

113-158 Sq. Feet at recommended dry film thickness

Calculated for mixed base and converter reduced 20%.

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.

Recommended Wet Film Thickness: 8-10 mils (200-250 microns)

Recommended Dry Film Thickness: 5-7 mils (125-175 microns)

Recoatibility: With itself, 4 hours; with other products, 12-24 hours. Maximum without sanding: 24 Hours. Sanding before overcoating with other products is recommended. May be overcoated with 545 Epoxy Primer, ULTRA-BUILD™, Sprayable Fairing Compound, AWL-FAIR™ L.W., and AWL-QUIK™.

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### Product Components, Reducers, Additives, and Auxiliary Components

Yellow Base	D9002
Off White Base	D8002
Converter	D3002
Reducer	T0006
Equipment Cleaning	T0006 or T0002 Reducers or M.E.K.

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### Application Equipment

Conventional or airless spray. Pressure feed equipment required.

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### **Surface Preparation**

Best when used as a surfacer over other Awlgrip Primers and fairing compounds. May be applied directly to properly prepared wood or fiberglass; however, best results are obtained when these surfaces are first sealed with 545 Primer. See Surface Preparation section for each type of substrate.

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### **Mixing and Reduction**

Mix by volume one part Base with one part D3002 to a smooth homogenous mixture. Reduce 10-20% with T0006.

Example: 8 oz. Base : 8 oz. D3002 : 3.2 oz. T0006

Induction Time after Mixing: 15 Minutes

Anticipated Pot Life at 77°F/50% R.H: 8 Hours

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### **Application Instructions**

Spray: Apply High Build Epoxy Primer in even coats of 8 to 10 mils (200 to 250 microns) wet film thickness yielding 4 to 5 mils (100 to 125 microns) DFT. Two to three coats may be required.

Do not apply paint materials to surfaces warmer than 105°F or colder than 55°F. Do not attempt to cure products at temperatures below 55°F.



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