

PRODUCT DATA SHEET

HD UNIVERSAL 306



Description:	A two pack Epoxy Primer is a cost effective quality air drying Epoxy Primer with base and hardener packed & supplied. To be over coated with a suitable epoxy finish coat to give a highly chemical resistance coatings.
Recommended use:	As a high performance primer to cast Iron structures in highly corrosive atmospheres like chemical plants, on shore off shore installation, ships, motor pump & gear box casting etc.
Service temperatures:	Maximum, dry exposure only: 120°C/248°F

Physical Properties :

Colours/shade Nos.:	Available in all shades.
Finish:	Flat
Volume solids, %:	65 ± 2 %
Theoretical spreading rate:	13 m ² /litre, 50 micron/2 miles
Flash point:	26°C [78.8°F]
Specific gravity:	1.5 kg/litre
Surface-dry:	20 minutes at 30°C
Handlable dry:	1 hours at 30°C

Application details:

Version, mixed product	HD Universal 306
Mixing ratio:	HD 306 Base: HD 306 Curing Agent 3 : 1 by volume
Application method:	Airless spray /Air spray/Brush/Flow coating
Thinner (max.vol.):	HD Epoxy Thinner (0 – 5 %)
Pot life:	4-6 hours at 30°C
Nozzle orifice:	.017"-.021"
Nozzle pressure:	170 bar [2538 psi] (Airless spray data are indicative and subject to adjustment)
Indicated film thickness, dry:	35-65micron (see REMARKS overleaf)
Indicated film thickness, wet:	60-100 micron
Overcoat interval, min:	According to Specification
Overcoat interval, max:	According to Specification

Safety:	Handle with care. Wear Necessary PPEs like safety shoes, gloves, goggles.
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Surface preparation:	Remove oil, grease and other contaminants by suitable detergent cleaning. Remove salts, detergents and other contaminants by high pressure fresh water cleaning. All damage of shop primer and contamination from storage and fabrication should be thoroughly mechanically/chemically cleaned prior to final painting. New build: Abrasive blasting to min. Sa 2½ (ISO 8501-1) / SP 10 (SSPC). Remove dust, blast media and loose materials. Maintenance and Repair Remove dust, blast media and loose materials. Flash rust degree of maximum FR M (ISO 8501-4). Spot abrasive blasting to min. PSa 2 (ISO 8501-2) / SP 6 (SSPC). Minor areas can be cleaned by power tool to St 3 provided the surface is roughened and not polished.
Application conditions:	Use only where application and curing can proceed at temperatures above: 10°C/50°F. Before exposure to outside temperatures below 10°C/50°F within the first day after application the coating must have been forced dried at minimum 15 minutes. The temperature of paint itself should be 15°C/59°F or above. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. In confined spaces provide adequate ventilation during application and drying.
Preceding coat:	According to specification.
Subsequent coat:	According to specification.
Remarks/Notes:	
Film thicknesses/thinning: (optional)	The temperature of the paint should preferably be above 15°C (59°F), otherwise extra thinner may be required to obtain application viscosity Adding too much thinner results in reduced sag resistance and slower cure Thinner should be added after mixing the components.
Overcoating note: (optional)	If the maximum over coating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion. The surface must be clean before over coating.

This Product Data Sheet supersedes those previously issued.

Data, specifications, directions and recommendations given in this data sheet represent only test results or experience obtained under controlled or specially defined circumstances. Their accuracy, completeness or appropriateness under the actual conditions of any intended use of the Products herein must be determined exclusively by the Buyer and/or User.

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