

Technical Data Sheet

MARINEPRO DEEPSHIELD 630 EPOXY PRIMER

Epoxy primer

Fast-drying epoxy primer,
hardened with amine adduct.

RELATED PRODUCTS

EPOXY HARD 9055

Hardener for epoxy primer

THINNER 60

Epoxy thinner

USE:

- Aluminium and composite watercraft
- Primer used as an adhesion promotor on aluminium

PROPERTIES

- Excellent insulating performance
 - Very good chemical resistance
 - High yield
- Perfect hiding power and flowability
- Possibility to apply on areas sanded down to the substrate
 - Very good mechanical resistance
- The primer can be used in a wet-on-wet system

SUBSTRATES							
Composites: polyester, vinyl ester, carbon fiber, fiberglass. Parts made of epoxy and PU resins.			Clean the composite surface, blow off dust, and degrease with MARINEPRO PLUS 780. Dry sand the laminate surface with P220–P280 and degrease. Pay attention not to sand through the gelcoat or resin surface. Blow off again and degrease once more before applying the primer.				
Old coatings			Degrease and dry sand with P220 - P360.				
Aluminum			To obtain proper adhesion, sand with P180-P280 sandpaper, then blow off and degrease with the recommended remover. NOTE: Apply the product before applying MARINEPRO EPOXY PUTTY				
MIXING RATIO							
	DEEPSHIELD 630 EPOXY PRIMER EPOXY HARD 9055 THINNER 60			Volume ratio		Weight ratio	
				1		100	
				1		58	
				10-25%		6-14	
							The thinner quantity is given as calculated on the basis of the primer.
SPRAYING PARAMETERS							
Component A	Hardener	Mixing ratio	THINNER 60	Viscosity DIN 4/20°C	Pneumatic spraying	Airless spraying	
DEEPSHIELD 630 EPOXY PRIMER 	EPOXY HARD 9055	1+1	10% 20% 25%	19 s 18 s 17 s	Nozzle: 1.4 - 1.6 mm, Pressure: 3 - 4 bar Distance: 15 - 20 cm	Nozzle: 0.23 ÷ 0.28 mm (0.009” ÷ 0.011 ”) Pressure: 100 - 120 bar, Air jacket: 2 - 4 bar Distance: 10 - 15 cm	
APPLICATION							
	Hardener	Mixing ratio	Thinner THINNER 60	Single dry layer thickness	Recommended number of layers		
	EPOXY HARD 9055	1+1	10-25%	50 - 60 µm	1-2		
	CAUTION: The minimum epoxy primer thickness is 60 µm on aluminium substrates.						
	Yield of the ready to use mixture for the given range of dry layer thickness			1+1 version: approx.. 5,4 m²/l 0,19 l/m² at 60 µm			
	The actual yield depends on the surface shape, roughness and application parameters.						
	Mixture life at 20°C			3 hours for hardeners EPOXY HARD 9055			
	Flash off between layers			20 minutes			

**MARINE COATINGS**

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12.01.2020

CURING TIME				
	Time to sand For max. thickness of 80-120 µm.	EPOXY HARD 9055		
		10°C	20°C	60°C
		48 hours	14 hours	45 min.
SANDING				
	Dry sanding	P240 - P500		
COATABILITY				
Topcoat application time for a 80 µm thick primer.	10°C	20°C	60°C	
	2 hours EPOXY HARD 9055	45 min. EPOXY HARD 9055	20 min. EPOXY HARD 9055	
Coatable by all NOVOL topcoats. The maximum coating time without matting is 48 h. The EPOXY HARD 9055 hardener permits applying the EPOXY PUTTY after 6 hours.				
TECHNICAL DATA				
Product	Solids content by weight	Solids content by volume	Density	Fineness of grind
DEEPSHIELD 630 EPOXY PRIMER	≈ 74 %	≈ 53 %	≈ 1.52 g/cm ³	< 12.5µm
EPOXY HARD 9055	≈ 19%	≈ 17.5%	≈ 0.88 g/cm ³	——
DEEPSHIELD 630 EPOXY PRIMER+ EPOXY HARD 9055: 1+1	≈ 54%	≈ 34%	≈ 1.20 g/cm ³	< 12.5µm
VOC CONTENT				
VOC For ready to apply mixture acc. to EU Directive 2004/42/EC	540 g/l (for 1+1)			
COLOUR MATCHING				
Not recommended.				
APPLICATION CONDITIONS				
The coated surface should be dry. The temperature of the coat, coated surface and environment should be between +10°C and +35°C at a maximum relative humidity of 80%. The coated surface temperature should exceed the dew point by a minimum of 3°C.				
COLOUR				
Grey.				
EQUIPMENT CLEANING				
THINNER 60 epoxy thinner				



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STORAGE CONDITIONS

Store in a dry room, away from sources of flame and heat. Avoid direct exposure to sunlight.
Recommended storage temperature: +5°C to +35°C.

SHELF LIFE*

MARINEPRO DEEPSHIELD 630 EPOXY PRIMER	24 months/20°C
EPOXY HARD 9055	24 months/20°C
THINNER 60	24 months/20°C

* In originally sealed packaging

SAFETY

See the Safety Data Sheet.

OTHER INFORMATION

Registration number: 000024104

The effectiveness of our systems / products is the combined result of research conducted under controlled conditions in the NOVOL laboratory and our long experience. The data contained in this document reflects the current level of knowledge about our products, quality features (characteristics) and verified possibilities (conditions) of their use. We ensure the high quality of the product, provided that the user follows the instructions (guidelines included in the product data sheet) and the work is performed in accordance with good workmanship.

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