

Technical data sheet

MARINEPRO MAXBUILT 631 EPOXY PRIMER

Epoxy primer

Thick epoxy primer hardened with amine adduct

RELATED PRODUCTS

EPOXY HARD 9056

Epoxy primer hardener

THINNER 60

Epoxy thinner

USE:

- Aluminium and composite watercraft
 - High-build primer
- Provides excellent resistance

PROPERTIES

- Perfect insulation properties
- Possibility of the application of thick layers up to 300 µm wet in a single layer
- Very good chemical resistance
 - High yield
- Large filling – suitable for multi-layer application
 - Very good mechanical resistance

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 decrease once more before applying the primer.			
Old paint coatings		Degrease and dry sandpaper P220 – P360.			
Polyester putties		Dry sand, for final sanding P240 ÷ P320.			
Aluminum		To achieve proper adhesion, apply MARINEPRO DEEPSHIELD 630 EPOXY PRIMER, designed for aluminium, before applying MARINEPRO MAXBUILT 631 EPOXY PRIMER. Once dry, sand with P240-P280 sandpaper and apply a high-build primer. Then, blow off and degrease with the recommended remover. NOTE: Apply the product before applying MARINEPRO EPOXY PUTTY			
MIXING RATIO					
	MAXYBUILT 631 EPOXY PRIMER EPOXY HARD 9056 THINNER 60		Volume ratio	Weight ratio	
			4	100	
			1	16	
			5-15%	4-12	
Apply the thinner in the amount calculated for the primer.					
VISCOSITY					
Component A	Hardener	Mixing ratio	Viscosity DIN 4/20°C	Pneumatic spraying	Airless spraying
MAXBUILT 631 EPOXY PRIMER 	EPOXY HARD 9056	4+1+5% 4+1+ 15%	88 s 42 s	Nozzle: 1.6 - 1.8 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 9056	4+1	10%	80 ÷ 100 µm	1-2
	CAUTION: The minimum epoxy primer thickness is 120 µm				
	Yield of the ready to use mixture for the given range of dry layer thickness		4+1 version: approx..6,18 m²/l 0,16 l/m² at 80 µm		
	The actual yield depends on the surface shape, roughness and application parameters.				
	Mixture life at 20°C		3 hours for hardener EPOXY HARD 9056		

**MARINE COATINGS**

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	Flash off between layers	20 min.		
CURING TIME				
	Time to sand For max. thickness of 80-120 µm	EPOXY HARD 9056		
		20°C	60 °C	
		24 hours	90 min	
SANDING				
	Dry sanding	P240 ÷ P500		
COATABILITY				
Topcoat application time for a 80 µm thick primer.	10°C	20°C	60°C	
	4 hours EPOXY HARD 9056	60 min. EPOXY HARD 9056	20 min. EPOXY HARD 9056	
Coatable by all NOVOL topcoats. The maximum coating time without mating is 48 h. The EPOXY HARD 9056 hardener permits applying the EPOXY PUTTY after 6 hours.				
TECHNICAL DATA				
Product	Solids content by weight	Solids content by volume	Density	Fineness of grind
MAXBUILT 631 EPOXY PRIMER	≈72%	≈53%	≈ 1.44 g/cm³	< 12.5µm
EPOXY HARD 9056	≈ 55%	≈ 58%	≈ 0.94 g/cm³	———
MAXBUILT 631 EPOXY PRIMER+ EPOXY HARD 9056 4+1	≈ 70%	≈ 52%	≈ 1.34 g/cm³	< 12.5µm
CONTENT OF VOLATILE ORGANIC COMPOUNDS				
Actual VOC content	472 g/l (dla układu 4+1 + 15% THINNER 60)			
For the ready to apply mixture compliant with Directive UE 2004/42/CE				
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				
Beige				



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EQUIPMENT CLEANING

THINNER 60 epoxy thinner.

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*

MAXBUILT 631 EPOXY PRIMER	24 months/20 °C
EPOXY HARD 9056	24 months/20 °C
THINNER 60	24 months/20 °C

* In originally sealed packaging

SAFETY

See Safety Data Sheet.

OTHER INFORMATION

Registration number: 000024104

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