



Effective 28 October, 2005

# DP3330

## SPRAY FAIRING

### Description

2-component chromate-free epoxy DuPont™ Marine Finishes Spray Fairing.  
Colour: grey.  
Composition based on epoxy resin.

### Products

DP3330	DuPont™ Marine Finishes Spray Fairing
DP3335	DuPont™ Marine Finishes Spray Fairing Activator
3871S	DuPont™ Thinner

### Auxiliary products

DP3320	DuPont™ Marine Finishes Fairing Lite
3910WB	DuPont™ Waterborne Degreaser
3911WB	DuPont™ Final Clean
3919S	DuPont™ Prepsol
3920S	DuPont™ Degreaser

### Properties

- Excellent adhesion on properly treated metal substrates.
- Provides, when used in combination with DP3320, a complete filling and fairing solution for turning rough surfaces into perfectly smooth areas.
- Very good filling properties. Suitable for use over rough substrates.
- High humidity resistance and very good flexibility.
- Recommended as spray fairing for all DuPont™ Marine Finishes systems.

### Substrates

Following specifications listed in the DuPont™ Marine Finishes Manual and in particular:

- bare metals: steel, aluminium and galvanised steel;
- well prepared gelcoat, well sanded fairing and cured repaired finishes.



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### PRODUCT PREPARATION

	<b>Mixing ratio</b>	DP3330 DP3335 3871S	<b>Volume</b>	<b>Weight</b>
			1 1 0 to 0.1	100 100 10
	<b>VOC</b>	245 g/l		
	<b>Pot life at 20°C</b>	4 hr		
	<b>Spray viscosity at 20°C</b>	<b>DIN 4</b> <b>FORD 4</b> <b>AFNOR 4</b>	35-80 s 35-80 s 40-90 s	
	<b>Spray equipment</b>	<b>Gravity feed</b> <b>HVLP</b> <b>Pressure feed/Airmix</b> <b>Airless</b>	<b>Fluid tip</b>	<b>Distance</b>
			2.2-2.8 mm 2.0-2.8 mm 1.6-2.2 mm 0.013"/65°-80°	20-30 cm 15 cm 20-30 cm 20-30 cm
	<b>Spray pressure</b>	<b>Gravity feed</b> <b>Suction feed</b> <b>HVLP</b> <b>Pressure feed</b> <b>Airless</b>	3.5-4.5 bar 3.5-4.5 bar 0.7 bar at nozzle 3.5-4.5 bar 180-200 bar	
	<b>Number of coats</b>	2 to 4		
	<b>Flash time at 20°C</b>	Between coats till flat maximum 2 hr.		
	<b>DFT</b>	Up to 600 μ.		
	<b>Dry to sand at 20°C</b>	16 hr Full cure time: 7 days.		
This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.				



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## RECOMMENDED USE

### Surface preparation

Following specifications listed in the DuPont™ Marine Finishes Manual and in particular:

Bare metals (steel, aluminium, aluminium alloys)

- Clean substrate with a suitable nitrocellulose thinner.
- Gritblast surface up to Sa 2 ½ to eliminate all traces of rust and corrosion.
- Blow surface to eliminate dust and blasting media.
- Apply etching primer and filling fairing till recommended film build.

Bare glass fibre

- Clean surface with water and soap. Rinse and dry.
- Degrease with 3919S or 3910WB. Wipe dry.
- Dry sand with P80 - P120.
- Clean with 3920S or 3911WB.
- Apply etching primer, osmose prevention primer and/or filling fairing till recommended film build.

### Remarks

- Activated material should not be returned to original can of non-activated material.
- Material has to be stirred well before use.
- Close can of DP3335 tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- Material has to be at room temperature (18-25°C) before use.

### Recoatability

At any time after full cure and sanding.

### Equipment cleaning

Use 3871S.



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## RECOMMENDED USE (con'd)

Product data	
Package viscosity:	DP3330: 340 cp DP3335: 420 cp
Volume solids:	68 % ± 5 %
Film build:	Wet: 600 μ Dry: 400 μ
Theoretical coverage:	2.0 m <sup>2</sup> /l

Products	Packages (l)	Storability at 20°C (year)	Density (kg/l)
DP3330	5	2	1.408
DP3335	5	2	1.408
3871S	5	2	0.839
DP3320	12	2	0.680
3910WB	5	2	0.975
3911WB	5	2	0.945
3919S	5 - 20	2	0.811
3920S	5 - 20	2	0.776

## Safety

Consult Material Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.