



Effective 28 October, 2005

DP8130

ALU GRIP PRIMER

Description

Thin film 2-component chromate-free epoxy DuPont™ Marine Finishes Alu Grip Primer.
Colour: white.
Composition based on epoxy resin.

Products

DP8130	DuPont™ Marine Finishes Alu Grip Primer
DP8135	DuPont™ Marine Finishes Alu Grip Primer Activator
3871S	DuPont™ Thinner

Properties

- Very good corrosion and chemical resistance.
- Excellent adhesion on properly treated aluminium, aluminium alloys and bronze.
- Recommended as a first coat over new aluminium constructions.
- High humidity resistance and very good flexibility.
- Recommended as a primer for all DuPont™ Marine Finishes systems.

Substrates

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

- aluminium, aluminium alloys, lead and bronze.

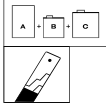









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PRODUCT PREPARATION

	Mixing ratio	DP8130 DP8135 3871S	Volume	Weight
			7	100
			3	35
			0 to 0.4	0 to 6
	VOC	499 to 533 g/l		
	Pot life at 20°C	18 hr		
	Spray viscosity at 20°C	DIN 4 FORD 4 AFNOR 4	40-65 s 40-65 s 40-65 s	
	Spray equipment	Gravity feed HVLP Pressure feed/Airmix Airless	Fluid tip	Distance
			2.2-2.8 mm	20-30 cm
			2.0-2.2 mm	15 cm
			1.6 mm	20-30 cm
			0.013"/65°-80°	20-30 cm
	Spray pressure	Gravity feed Suction feed HVLP Pressure feed Airless	3.5-4.5 bar 3.5-4.5 bar 0.7 bar at nozzle 3.5-4.5 bar 140-200 bar	
	Number of coats	1 to 2		
	Flash time at 20°C	Between coats till flat with maximum of 3 days.		
		Before recoating:	minimum	maximum
		2K primers	24 hr	7 days
	DFT	25 to 35 μ		
	Dry to sand at 20°C	1 hr to maximum 3 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 (aluminium, aluminium alloys, lead and bronze)

- Clean substrate with a suitable nitrocellulose thinner.
- Sand metal with P80 - P120 sanding paper.
- Apply primer till recommended film build.
- Flash recommended time before further priming.

Remarks

- Activated material should not be returned to original can of non-activated material.
- DP8130 can be applied by brush if no reducer is added to the activated material.
- Material has to be stirred well before use.
- Close can of DP8135 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

After minimum 1 hr at 20°C and maximum 7 days at 20°C without sanding.

Equipment cleaning

Use 3871S.



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RECOMMENDED USE (con'd)

Product data

Package viscosity:	5.500 cp
Volume solids:	41 % ± 2 %
Film build:	Wet: 60 µ Dry: 25 µ
Theoretical coverage:	12.0 m ² /l at 35 µ DFT - ready-to-spray 16.0 m ² /l at 25 µ DFT - ready-to-spray

Products	Packages (l)	Storability at 20°C (year)	Density (kg/l)
DP8130	3.55	2	1.137
DP8135	1.45	2	0.923
3871S	5	2	0.839

Safety

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