

Marine Coatings Technical Data



HMG Performance Coatings LLC
PO Box 313
Roebuck, SC 29376
+1 864 578 6770

Product Name	POLYKOTE AMC PRIMER SURFACER 3713
Issue date	7/19/2004
Formula Number	
Product code	3713

Packaging

Available in 4 liter packs (4 liters base + 1 liter hardener)

Product Description & Function

POLYKOTE AMC PRIMER SURFACER is a 2 pack isocyanate cured primer.

POLYKOTE AMC PRIMER SURFACER may be overcoated without sanding (although it has superlative sanding properties) wet on wet or may be denibbed. It has very low sinkage properties allowing for exceptional gloss hold up when overcoated with Acrythane XSC. It is particularly suited to repaints or when a color change might be required and the existing substrate is in a sound condition.

Substrates & Preparation

		Number of coats	
	Aluminum -	Sand blast or grind to 3-4 mils profile depending on grade of Aluminum. Spot repairs grind with 60 - 80 grit. Must be 100% clean and coated within 1 hr. of blasting/grinding. First apply one coat of HMG Etch Primer and apply Polykote AMC Primer Surfacer within 1hr	Apply minimum 2 - 3 coats depending on condition of substrate and expected operating conditions
	Steel -	Sand with P60-P80g or sand blast to SSPC-SP5-85. Apply HMG Etch Primer Coat within 1 hr. and then Polykote AMC Primer Surfacer within 4 hours	2 - 3 coats depending on condition of substrate and expected operating conditions.
	Previously painted -	Sand with P180-P320g - ensure good adhesion to previous coats	1 coat
	Wood -	Sand clean wood with P150-P180 grit and apply first coat reduced up to 50% with reducer. Reduce 2nd coat up to 25%. Best performance will be achieved by applying one coat of epoxy primer first. Follow instructions on TDS for either DG144 or Epi-prime epoxy primer	2 - 3 coats
	GRP/Gel Coat -	Sand with P180-P320g being careful not to abrade through the Gel coat.	1 - 3 coats

Cleaning



All surfaces should be pre cleaned prior to preparation and prior to application of primer. HMG SAH 270 degreaser is highly recommended as a wipe on wipe off cleaner. Cleaning between sanded coats, Contec ProSat wipes are recommended. **CLEAN BEFORE SANDING**

Application

	HVLP	Pressure Pot	Airless/Air Assisted
Mixing Ratio			
Base	4 Parts	4 Parts	4 Parts
As supplied	1 Part	1 Part	1 Part
Thinner	1 - 1.5 parts	1 - 1.5 parts	0 - 0.5 parts
Spray Viscosity	25 - 40 sec (Zahn 2 @ 72°F)	25 - 40 sec (Zahn 2 @ 72°F)	40 sec (Zahn 2 @ 72°F)
Gun Set Up	See gun recommendations	Pot pressure 8 - 15 lbs	See gun recommendations
No of Coats	See substrate		1 full coat
Flash Off	30 minutes @ 72°F		NA
Drying	1 hour @ 72°F		
Pot Life	2 - 3 hours @ 72°F		
Film Build	2.6 mils WFT gives approximately 1.6 mils DFT		
Overcoating	After 30 min without flattening as a wet on wet process with HMG Acrythane XSC Topcoat system. If greater than 36 hrs between coats, the surface should be sanded.		
Sanding	Wet sand after 4 hrs. Dry sand possible after overnight dry. Sand with P320 grit paper. Contec ProSat wipes provide a clean and anti-static surface and are highly recommended after sanding		
VOC (Ready for Use)	< 540 g / liter		

Reducer Options

Acrythane XSC Reducer CB122 (RTD)	Medium	} Dependant on temperature or size of vessel to enable a Wet Edge to be retained The choice of correct reducer will give optimum lay down of product and ease of application. Reducers can be blended
Acrythane XSC Reducer A788	Slow	
Acrythane XSC Reducer Brushing	Extra Slow Reducer	

Hardener Option

Polykote 9004	All purpose hardener. No other available
---------------	--

Technical Information

Solids	Approximately 60% when mixed.
Flashpoint	Between 72°F to 89°F
Storage	12 Months in original sealed containers
Equipment Cleaning	Acrythane XSC/Polykote Reducer (A788) SLOW or Acetone
Coverage	610 sq/ft per US Gallon (theoretical)
VOC (unmixed)	537g/l

Special Properties

Ultra high quality, high build premium primer that can be rapidly overcoated with topcoats without need for thru drying or further sanding. Even when epoxy primer is initially used, Polykote AMC provides a great finish primer.

Special notice - prevailing weather conditions

Polykote AMC Primer Surfacer should not be applied in temperatures below 50°F as curing times become extended beyond practical limits. Painting late in the day may result in condensation forming on the paint film that leads to loss of gloss and potential blistering problems in the cured coating. Space heaters can create moisture and worsen the situation. DO NOT apply paint if the temperature is going to drop below the dew point within 6 - 8 hrs after painting is complete.

Health & Safety

Refer to "Material Safety Data Sheet" and can label prior to use.

FOR PROFESSIONAL USE ONLY. PAINT APPLICATORS ARE ASSUMED TO BE EXPERIENCED IN THE HANDLING AND APPLICATION OF THESE PRODUCT TYPES

Wear air fed mask when spraying this material

KEEP OUT OF THE REACH OF CHILDREN

visit www.hmgmarine.com for more information and updates

THIS INFORMATION RELATES ONLY TO SPECIFIC MATERIAL DESIGNATED AND MAY NOT BE VALID FOR SUCH MATERIAL USED IN COMBINATION WITH ANY OTHER MATERIALS OR IN ANY OTHER PROCESS. Such information is to the best of HMG's knowledge and belief, accurate and reliable as of the date indicated. HOWEVER, NO REPRESENTATION, WARRANTY OR GUARANTEE IS MADE AS TO IT'S ACCURACY, RELIABILITY OR COMPLETENESS. IT IS THE USERS RESPONSIBILITY TO SATISFY HIMSELF AS TO THE SUITABILITY AND COMPLETENESS OF SUCH INFORMATION FOR HIS OWN PARTICULAR USE.