

**PRODUCT DATA SHEET
MAX COR CF PRIMER
R4330/R3330**



Features & Uses

Max Cor CF is a high solids two component anti-corrosive, chromate-free epoxy primer for aluminum and steel with excellent chemical and solvent resistance. Max Cor CF is based on 'Controlled Fusion' (CF) technology, a unique chemical system that allows extended re-coat times, removes the need for sanding prior to applying the next coat and also gives excellent substrate adhesion. This technology eliminates the requirement for high hazard chemicals and ensures a tightly fused intercoat layer between the CF-based coating and the next applied coat.
For above the waterline only.

Specification Data

Type: Epoxy Polyamine.

Colour: Green.

Packaging: Base available in a 1-gallon pack, converter in a ½ gallon pack.

Theoretical Coverage:

*1138 feet² / gallon (28.45 m² / litre) at 0.8 mil (20 microns) dry.

*910 - 1518 feet² / gallon (22.76 – 38.0 m² / litre) at recommended dry film thickness.

*Calculated for mixed base and converter.

Coverage calculations are based on theoretical transfer efficiency of 100%. Actual coverage rate obtained will vary according to equipment choice, application techniques, part size, and application environment.

Recommended Wet Film Thickness: 0.8-1.4 mils (20 - 34 microns) per coat.

Recommended Dry Film Thickness: 0.6-1 mils (15 - 25 microns) per coat.

Number of coats: 1.

Recoatibility:

Overcoating by	15°C/59°F		25°C/77°F		35°C/95°F	
	Min	Max	Min	Max	Min	Max
Hullgard Extra Primer	17 hours	72 hours	17 hours	72 hours	7 hours	72 hours
High Build Epoxy Primer	17 hours	72 hours	17 hours	72 hours	7 hours	72 hours

Min = Minimum recoatability
Max = Maximum recoatability

NOTE: If maximum overcoating interval is exceeded Max Cor CF will need to be fully removed and re-applied. If maximum overcoating interval is likely to be exceeded apply Hullgard Extra to give up to 6 months overcoating without the need for sanding.

VOC: R4330 – 2.12 lbs/gallon (254 g/l), R3330 – 5.54 lbs/gallon (628 g/l)
Mixed (R4330:R3330) – 3.15 lbs/gallon (378 g/l).

Product Components, Reducers, Additives, and Auxiliary Components

Base - Green.....R4330
 Converter.....R3330
 Reducer..... DO NOT THIN/REDUCE
 Equipment Cleaning..... T0006 or T0002 Reducers or M.E.K.

Application Equipment

	Air Cap	Fluid tip	Air Pressure	Pot Pressure
Conventional	110	1.4	30-40PSI (2.0-2.7 bar)	
(compliant)	110	1.4	30-40PSI (2.0-2.7 bar)	11 - 12 PSI (0.8 bar)
Conventional	30	1.4	50-60PSi (3.4-4.1 bar)	
(suction/gravity)	765	1.4	50-60PSi (3.4-4.1 bar)	11 - 12 PSI (0.8 bar)

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Gun #95	Siphon/Cup system fluid nozzle 66SS fluid needle 665 air nozzle 66Sk atomization 50-60PSi (3.4-4.1 bar) pressure pot	Pressure Pot fluid nozzle 66BSS fluid needle 663A air nozzle 63PW 50-60PSi (3.4-4.1 bar) 8-12PSI (0.55-0.83 bar)
Airless	orifice 0.13" angle 60°	

Surface Preparation

Max Cor CF may be directly applied to grit blasted steel in accordance with SSPC-SP10 to a 2-3 mil (50-70 microns) profile (or Sa2½ outside of the US). Alternatively power grind with 16 to 36 grit disc to obtain profile. The surface must be clean and dry, free of all dirt, grease and oil. Use Awlgrip Wipe-Down Solvent (NA: Awlprep T0008 or Awlprep Plus T0115; EU: Surface Cleaner T0340)

Aluminium: Sandblasted/ground to 100% clean silver color. A surface profile of 2-3 mils (50-75 microns) is recommended.

Steel: Sandblast/grind SSPC-SP10 or Sa2½. A surface profile of 2-3 mils (50-75 microns) is recommended.

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Mixing & Reduction

Mix by volume 2 parts R4330 with 1 part R3330. Ensure R4330 is uniformly dispersed before addition of R3330. Mix until a smooth homogenous mixture is obtained.

Induction Time after Mixing: N/A

Anticipated Pot Life at 77°F (25°C) @ 50% R.H: 2 hours

Application Instructions

Spray only. Apply one smooth wet coat. Substrate may be visible through the dry film. Do not exceed maximum recommended dry film thickness.

Do not apply paint materials to surfaces warmer than 40°C/105°F or colder than 15°C/59°F. Do not attempt to cure products at temperatures below 15°C/59°F.

Important notes: Read Material Safety Datasheet for the appropriate health and safety information prior to use. Full personal protective equipment is highly recommended.

Warning:

Always ensure that overcoating times are adhered to. Failure to allow the required overcoating time will result in blistering and delaminating of the underlying Max Cor CF.

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The information in this Product Data Sheet is not intended to be exhaustive. Any person using the product without first making further enquiries as to the suitability of the product for the intended purpose does so at their own risk and, to the extent permitted by law, we can accept no responsibility for the performance of the product or for any loss or damage arising out of such use. The information contained in this Product Data Sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.