



PRODUCT DATA SHEET
30-Y-94 ANTI-CORROSIVE CHROMATE EPOXY PRIMER
S9001 / S3001

Features & Uses

A two component anti-corrosive, strontium chromate epoxy primer for aluminum and steel with excellent chemical and solvent resistance. Do not use below the waterline.

Specification Data

Type: Epoxy Polyamide meets Mil-P-23377D standard.

Packaging: Available in 1 gallon and 1 quart containers

Theoretical Coverage: Sq. Ft./Gallon; *298 Sq. Feet (28m²) at one mil (25 microns) dry;

*198-496 Sq. Feet (18-46m²) at recommended dry film thickness

*Calculated for mixed base and converter, reduced 50%.

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: 3-7.5 mils (75-175 microns)

Recommended Dry Film Thickness: 0.6-1.5 mils (15-37 microns)

Recoatability: At 77°F/50% R.H. minimum 2-4 hours. Maximum without sanding is 24 hours. Plan your work schedule to eliminate having to sand. 30-Y-94 may be overcoated with AWLGRIP®/AWLCRAFT® 2000 Topcoats, 545 Epoxy Primer, High Build Epoxy Primer, AWL-QUIK Sanding Surfacers, and ULTRA-BUILD® Epoxy Primer.

VOC: Base (S9001) - 685 g/lit or 5.7 lbs/gallon
Converter (S3001) - 515 g/lit or 4.3 lbs/gallon

Product Components, Reducers, Additives, and Auxiliary Components

Base - Yellow	S9001
Acid Converter.....	S3001
Reducer.....	T0006
Equipment Cleaning.....	T0006 or T0002 Reducers or M.E.K.

Application Equipment

Conventional or airless spray.

Pressure Pot System Guns

Binks or equivalent:

Spray gun.....#95

Fluid Nozzle..... #63BSS (0.46" Orifice size)

Fluid needle.....#663A

Air nozzle.....#63PB

Pressure gauge should read 8-12 lbs.

With 50 to 60 lbs. atomization.

Siphon or Cup Gun System

Binks or equivalent:

Spray gun.....#95

Fluid nozzle.....#66SS (.070" Orifice size)

Fluid needle.....#665

Air nozzle.....#65SK

Atomizing air pressure should be approximately

50 to 60lbs.

Surface Preparation

Aluminum: Sandblast/Grind to 100% clean silver color or treat with ALUMIPREP 33/ALODINE 1201. Steel: Sandblast/Grind SSPC-SP5-85 or Sa 2 1/2. Do not apply over Zinc Chromate Wash Primer (G9072/G3014).

1 East Water Street • Waukegan, Illinois 60085 • USA • Tel: 847.599.6212 • Fax: 847.599.6209

Bannerlaan 54 • B-2280 Grobbendonk • Belgium • Intl. Tel: 32.14.257770 • Intl. Fax: 32.14.230880

76 Waterway Drive • Coomera • QLD 4209 • Australia • Tel: 61.7.5573.9600 or 1800.007.866 • Fax: 61.7.5573.9677

449 Tagore Industrial Avenue • 04 03 Hong Joo Industrial Building • Singapore 787820 • Tel: 65.6453.1981 • Fax: 65.6453.1778

Mixing & Reduction

Mix by volume 1 part S9001 with 1 part S3001. When a smooth homogenous mixture is obtained, reduce up to 50% with T0006. Overall mix is 1:1:1 by volume.

Example: 8 oz. S9001, 8 oz. S3001, 8 oz. T0006.

Tip: You will get a smoother application by inducing the mixed S9001/S3001 30-45 minutes before adding the reducer. Stir the S9001/S3001 mixture every 10-15 minutes while inducing.

Induction Time after Mixing: 15 Minutes

Anticipated Pot Life at 77°F/50% R.H: 8 Hours

Application Instructions

Spray only. Apply one smooth wet coat. Cross coating or double coating is acceptable on very rough surfaces. Substrate may be visible through the dry film. Too thick a film may split and peel.

Do not apply paint materials to surfaces warmer than 105°F or colder than 55°F. Do not attempt to cure products at temperatures below 55°F.

Important notes:

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

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.

Awlgrip® and all products mentioned in this Product Data Sheet are trademarks of, or licensed to, Akzo Nobel.

© Akzo Nobel, 2005