

- 1. Introduction** ALEXSEAL® Super Build 302 is an epoxy-based high build primer / surfacer which cures into a smooth easy to sand, water resistant coating. ALEXSEAL® Super Build 302 has excellent spray characteristics and is fast drying to allow maximum efficiency while fairing. The cured film offers excellent mechanical resistance values.
- 2. Range of application** ALEXSEAL® Super Build 302 is used to seal ALEXSEAL® Fairing Compound 202 and to even out imperfections remaining after the filling and sanding process. It can also be used as a smooth, non-porous surfacer prior to the application of ALEXSEAL® Finish Primer 442 or Finishing Primer 401.
- 3. Color**
- | | |
|-------------------|-----------|
| Color of mixture: | Off White |
| Base material: | White |
| Converter: | Gray |
- 4. Coverage**
- Coverage for ALEXSEAL® Super Build 302 when applying 2 - 3 coats or passes in the same application period.
Volume Solids catalyzed without reduction: 57 %
- Theoretical:** 2 m² / l (84 sq. ft. per gallon) at recommended dry film thickness of 500 microns (20 mils).
- Practical:**
- Conventional Air Spray Equipment:** 1.2 m² / l (50 sq. ft. per gallon) at recommended dry film thickness of 500 microns (20 mils).
HVLP Air Spray Equipment: 1.5 m² / l (63 sq. ft. per gallon) at recommended dry film thickness of 500 microns (20 mils).
Brush / Roller and Airless Spray Equipment: 2 m² / l (84 sq. ft. per gallon) at recommended dry film thickness of 500 microns (20 mils).
- 5. Substrate pre-treatment**
- The substrate must be clean, dry and free from dust, grease, oil and other contamination. ALEXSEAL® Super Build 302 may be applied over sanded fillers such as ALEXSEAL® Fairing Compound 202. After finish sanding the ALEXSEAL® Fairing Compound 202 with 60 to 150 grit, the surface must be cleaned and dusted off thoroughly before applying ALEXSEAL® Super Build 302.
- ALEXSEAL® Super Build 302 may be applied as a high build surfacer over gel coat and raw resin lay-up. Gel coat must be sanded with 80 - 150 grit. Fiberglass resin should be ground with 36 - 60 and / or sand blasted. The surface and the bottom of any profile should be dull and abraded, with no shiny spots.
- Refit and repair: Old coatings must have good adhesion and chemical resistance and must be sanded with 100 - 150 grit. A compatibility test should be performed if the old coating is questionable.
- ALEXSEAL® Super Build 302 should be sealed with ALEXSEAL® Finish Primer 442 or Finishing Primer 401 prior to topcoating.
- 6. Trade names**
- | | | |
|---------------|-------|-------------------------------------|
| Base Material | P3002 | ALEXSEAL® Super Build 302 |
| Converter | C3052 | ALEXSEAL® Super Build 302 Converter |
| Reducer | R3040 | ALEXSEAL® High Build Epoxy Reducer |
| Accelerator | A4030 | ALEXSEAL® Epoxy Primer Accelerator |
- 7. Mixing ratio**
- | | | | |
|---------------------|-----------------------------|-------|-------------------------------------|
| Conventional Spray: | 1 part by volume | P3002 | ALEXSEAL® Super Build 302 |
| | 1 part by volume | C3052 | ALEXSEAL® Super Build 302 Converter |
| | 20 to 25 % reduction (vol.) | R3040 | ALEXSEAL® High Build Epoxy Reducer |
- Example: 1 : 1 : ½ = 25 % reduction
 Example: 1 : 1 : ¼ = 12 % reduction may be more effective for airless spraying

Professional Use Only

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Super Build 302

Technical Data Sheet:
453-14 / P3002

8. Application

Viscosity (Zahn #2)	approx. 24 sec
Fluid Nozzle Size	1.7 - 2.2 mm (0.070 - 0.086) - Conventional & HVLP
Atomizing Pressure	3.0 to 5.0 bar (42 to 70 PSI) - Conventional & HVLP
Pot Pressure	0.7 to 1.5 bar (10 to 20 PSI) - Conventional & HVLP
Airless Equipment	Tip 0.43 - 60 to 0.60 - 60 mm (0.017 - 60 to 0.024 - 60)
Airless Equipment	Pressure 3.0 to 5.0 bar (42 to 70 PSI)

Apply 2 to 3 coats to a wet film thickness (WFT) of 150 - 300 microns (6 - 12 mils) per coat. This will achieve a dry film thickness (DFT) of 210 - 420 microns (8 - 17 mils) for a 2 coat application, and 315 - 630 microns (13 - 25 mils) for a 3 coat application, using 20 % reducer. Minimum recommended film thickness before sanding is 210 microns (8 mils) DFT. Maximum recommended film thickness during a spray application is 3 coats totaling 900 microns (36 mils) WFT, or 630 microns (25 mils) DFT.

Accelerator

A4030 ALEXSEAL® Epoxy Primer Accelerator is used to reduce the drying time of ALEXSEAL® Super Build 302. At the same time, use of A4030 ALEXSEAL® Epoxy Primer Accelerator reduces the pot life.

Per each 1 gallon of P3002 ALEXSEAL® Super Build 302 base, a maximum of 1 pint (16 oz) of A4030 ALEXSEAL® Epoxy Primer Accelerator may be added. Additional quantities of accelerator reduce pot life, and are not recommended. Mix ratio quantity for A4030 is for base quantity used in mixture.

9. Pot life and Drying

Temperature for minimum recoat time	15°C (60°F)	20°C (68°F)	25°C (77°F)	30°C (85°F)	Max Dry Time
Pot Life - approx.	12 hrs	12 hrs	12 hrs	12 hrs	12 hrs
Pot Life - with A4030 ALEXSEAL® Epoxy Primer Accelerator	6 hrs	6 hrs	6 hrs	6 hrs	N/A
Fully Cured	21 days	18 days	14 days	10 days	N/A
Tape Dry - without accelerator	30 hrs	24 hrs	18 hrs	12 hrs	N/A
Tape Dry - with A4030 ALEXSEAL® Epoxy Primer Accelerator	24 hrs	18 hrs	12 hrs	10 hrs	N/A
Recoat with another coat of ALEXSEAL® Super Build 302	4 hrs minimum	2 hrs minimum	1 hr minimum	1 hr minimum	24 hrs maximum
Overcoat with another product including 442 and 401. Preparation including sanding is required after max. time.	12 hrs minimum	12 hrs minimum	12 hrs minimum	12 hrs minimum	24 hrs maximum

Note: The above chart reflects approximate minimum and maximum time. Surface temperature, air flow, direct or non-direct sunlight, quantity of reducer, and film thickness will effect actual times during application. During the drying phase the minimum temperature is 15°C (60°F). Ideal temperature: 25°C (77°F).

10. Packaging

P3002	ALEXSEAL® Super Build 302	1 Gal
C3052	ALEXSEAL® Super Build 302 Converter	1 Gal
R3040	ALEXSEAL® High Build Epoxy Reducer	1 QT & 1 Gal
A4030	ALEXSEAL® Epoxy Primer Accelerator	1 PT

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