



Corlar® 2.8 HG™ High Solids Epoxy



GENERAL

DESCRIPTION

A high build, high solids, two-component, VOC conforming (2.8 lbs./gal.), high gloss epoxy based on Axalta modified polyamide epoxy technology. The resulting coating is designed to be highly durable and to deliver outstanding corrosion and chemical resistance.

SUGGESTED USES

As a high performance coating or topcoat on properly prepared carbon steel, galvanized steel, stainless steel, aluminum, concrete, concrete block and wood where:

- Smooth appearance with high gloss and custom color capability is desired.
- Excellent resistance to chemical and/or marine environments is required.
- Application by brush and roller, in addition to spraying, may be necessary.
- Application may be required down to 40°F.

USDA approved -- (incidental food contact) contains no lead or chromate pigments.

Corlar 2.8 HG will chalk upon exposure to sunlight. If gloss, color retention and color stability are important, Corlar 2.8 HG should be topcoated with Imron® 2.8 HG™ or Imron 3.5 HG™ + or other appropriate topcoat.

COMPATIBILITY WITH OTHER COATINGS

Corlar 2.8 HG is highly compatible with most coating types. It may be used over most aged and hard cured coatings in good condition. Testing for lifting, bubbling and adhesion is recommended to assure compatibility with unknown coatings. Contact your Axalta representative for specific recommendations.

NOT RECOMMENDED FOR

- Immersion service
- Extreme exposure without topcoat

PERFORMANCE PROPERTIES

Abrasion & Mechanical	Excellent
Alkalis	Excellent
Humidity	Excellent
Solvents	Excellent
Acids	Very Good
Salts	Excellent
Weather	Very Good (will chalk on exterior exposure)
Ammonia	Excellent

COLOR

Select Factory Packaged colors and custom mixes available.

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.



MIXING

COMPONENTS

Corlar 2.8 HG – Base	1 gallon container short filled to allow for colorant
1LB26P™ Light base	(122 oz./gal)
2MB26P™ Medium base	(116 oz/gal)
3DB26P™ Deep Base	(110 oz/gal)
4NB26P™ Neutral base	(104 oz/gal)
Corlar VG-026™ Activator	1 gallon container 100% Full (128 oz.)

MIX RATIO

Component	Part by Vol.
Corlar 2.8 HG – 26P Base	1
Corlar VG-026 Activator	1

ACTIVATION

Thoroughly agitate Corlar 2.8 HG (26P) base to uniformly incorporate all pigments. Add 1 part Corlar VG-026 Activator to 1 part Corlar 2.8 HG (26P) base. Allow 1 hour induction prior to using.

Reduction

None required for normal conditions. Use up to 20% T-8054™ Thinner on hot or windy days. If more than 20% reduction is required, contact your local Axalta representative.

APPLICATION THINNERS

Normal Conditions	None required
Hot or Windy Conditions	T-8054

*Do not thin if compliance with 2.8 lbs/gal is required.

POT LIFE

5 hours @ 70°F to 90°F after induction period of 1 hour.



APPLICATION

SURFACE PREPARATION

Can be applied directly over properly cured primers or most old thermoset coatings in good condition. Before application to surface, hardened or smooth concrete, roughen surface. Surface must be clean, dry and free of chemical contamination.

APPLICATION CONDITIONS

Do not apply if material, substrate or ambient temperature is below 40°F (4°C) or above 110°F (43°C). The substrate must be at least 5°F (3°C) above the dew point. Relative humidity should be below 90%.

ROLL APPLICATION

Manufacturer: Wooster® Pro/Doo-Z ¼"- ½" nap
• Keep roll wet. Roll in one direction, rewet, then cross roll.

BRUSH APPLICATION

Manufacturer: Wooster® China Bristle - 3"-4" brush



SPRAY APPLICATION

Manufacturers listed below are a guide. Others may be used. Changes in tip size or pressure may be required to achieve proper application.

Conventional Spray

	<u>Binks</u>	<u>DeVilbiss</u>	<u>SATA</u>
Spray Gun:	2001	JGA	K3RP
Fluid Nozzle:	63PSS	E (1.8)	1.1
Pot Pressure:			25
Atomizing Pressure			36
Air Cap:	63PR	704	

HVLP Spray

	<u>Binks</u>	<u>DeVilbiss</u>
Spray Gun:	Mach 1	GTi
Fluid Nozzle:	94 (1.4)	1.4
Air Cap:	97AP	2000

Airless Spray

Pump: Graco Extreme 33:1
 Airless Gun: Graco 207945
 Fluid Hose: 3/8" x 50' max.
 Tips: 414-617
 Minimum pressure to avoid fingering: 2400 psi min.

Application Notes

- Some colors may require multiple coats and higher film build to achieve complete hiding
- Epoxies chalk with extended exposure to sunlight. Lack of ventilation, incomplete mixing, mis-catalyzation or the use of heaters that emit carbon dioxide and carbon monoxide during application and initial stages of curing may cause yellowing to occur.

CLEAN UP THINNERS

T-8054 or MEK



DRY TIMES

Cure Time At Recommended Thickness 2 mils DTF @ 50% RH

	77°F (25°C)
To Touch	3 hours
Tack Free (Zapon)	7 hours
To Handle	16 hours
To Recoat	16 hours
Full Cure	7 Days



PHYSICAL PROPERTIES

Maximum Service Temperature	Up to: 250°F (121°C) Continuous (light colors will yellow) 300°F (148°C) Intermittent
Volume Solids	61% ± 2%
Weight Solids	74% ± 2%
Theoretical Coverage Per Gallon	978 ft ² (24.0 m ² /L) @ 1 mil DFT 489 ft ² (11.39 m ² /L) @ 2 mils suggested DFT

Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.

Weight Per Gallon 10.7 lbs./gal ± 0.2%



UV Con (ASTM D4587)*	3000 hours	Gloss before exposure 92.9 Gloss after exposure 2.1 - chalking
	Evaluation	no rusting, no blisters, no delamination
Impact (ASTM D2794):	4 inch pounds	
Mandrel Bend (ASTM D522):	% Elongation - 0%	
Taber Abrasion (ASTM D4060):	weight loss in grams - 0.18	

*8 hour UV @ 50°C, 4 hour condensation @ 40°C, gloss readings @ 60°

SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

All technical advice, recommendations and services are rendered by the Seller gratis. They are based on technical data which the Seller believes to be reliable, and are intended for professional use by persons having skill and know-how at their own discretion and risk. Seller assumes no responsibility for results obtained or damages incurred from their use by Buyer in whole or in part. Such recommendations, technical advice or services are not to be taken as a license to operate under or intended to suggest infringement of any existing patent.

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In the United States:
1.855.6.AXALTA
axalta.us

In Canada:
1.800.668.6945
axalta.ca

