

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 $^{\text{TM}}$ or Imron 3.5 HG $^{\text{TM}}$ + 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.

AXALTA CORLAR® 2.8 HG™
Page 1 of 5





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

ComponentPart by Vol.Corlar 2.8 HG – 26P Base1Corlar VG-026 Activator1

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

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 1/4" - 1/2" nap

• Keep roll wet. Roll in one direction, rewet, then cross roll.

BRUSH APPLICATION

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

AXALTA CORLAR® 2.8 HG™

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



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>	SATA
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>	DeVilbiss
Spray Gun:	Mach 1	GTi
Fluid Nozzle:	94 (1.4)	1.4
Air Cap:	97 À P	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

 $\begin{array}{lll} \mbox{Volume Solids} & \mbox{61\% \pm 2\%} \\ \mbox{Weight Solids} & \mbox{74\% \pm 2\%} \\ \end{array}$

Theoretical Coverage Per Gallon 978 ft² (24.0 m²/L) @ 1 mil DFT

489 ft² (11.39 m²/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%

AXALTA CORLAR® 2.8 HG™
Page 3 of 5



Shipping Weight (approximate) 1 gallon container: 13 (base) / 9 (activator); 5 gallon container: 66 (base) / 42 (activator)

Suggested Film Thickness: 3 mils (75 µm) wet 2 mils (50 µm) dry

Application by brush and roller may require additional coats to achieve recommended films thickness.

Flash Point:

Corlar 2.8 HG Bases
Corlar VG-026

Gloss:
Package Size:
Shelf Life:

Corlar 2.8 HG Bases
20-73°F (-7 to 23°C)
High (90 @ 60° angle)
1 & 5 gallon containers
12 months minimum

STORAGE CONDITIONS

Store in a dry, well-ventilated area. Storage conditions should be between -30°F (-34°C) and 120°F (48°C).

Corlar 2.8 HG may settle. Agitate before each use and intermittently while sitting in storage.

VOC REGULATIONS

VOC (Theoretical less water and exempt compounds).

		%	VOC	VOC
Condition	<u>Thinner</u>	<u>Max</u>	(lbs/gal)*	(g/l)*
Normal	None		2.8	336
Hot/Windy	T-8054	20	3.5	420

*VOC varies with color. Reported values are averages, when mixed with Corlar VG-026 Activator.

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

ASTM INFORMATION

Physical properties are for a system of Corlar LV-A[™]/Corlar 2.1 ST[™] and Corlar 2.8 HG. For other system results, contact Axalta Coating Systems.

Paint System: Corlar LV-A | Corlar 2.1 ST | Corlar 2.8 HG

6AL90P | 25P | 26P

Type | Color: epoxy mastic aluminum/epoxy gray/epoxy white

DFT: 5/5/5

Salt Fog (ASTM B117) 1000 hours no rusting, no blisters 2000 hours no rusting, no blisters 3000 hours no rusting, no blisters, no undercutting at the scribe Relative Humidity (ASTM D2247) 1000 hours no rusting, no blisters 2000 hours no rusting, no blisters 3000 hours no rusting, no blisters Dry Heat (ASTM D2485) 250°F for 24 hours no cracking, no blisters, no

loss of adhesion, very slight discoloration

Electrical Resistance (ASTM D2457): 1.1X10^16

Adhesion (ASTM D4521 A2): 1875 psi cohesive failure within the

primer

Cleveland Cond (ASTM D4585): 1000 hours no rusting, no blisters, no

delamination



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.

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