



Corlar® 2.8 HG-D™ High Gloss High Build Epoxy DTM



GENERAL

DESCRIPTION

A 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, direct-to-metal coating, intermediate coat or topcoat on properly prepared carbon steel, stainless steel, aluminum, concrete, concrete block and wood where:

- Smooth appearance with high gloss and custom color capability is desired.
- Single coat application up to 5 mils dry film thickness is required.
- Excellent resistance to chemical and/or marine environments is required.
- Application by brush and roller, in addition to spraying, may be necessary.
- Rusted, hand or power-tool cleaned metal surfaces must be protected.
- Application may be required down to 40°F.

Corlar 2.8 HG-D is primarily designed for corrosion protection. Corlar 2.8 HG-D will chalk upon exposure to sunlight. If gloss, color retention and color stability are important, Corlar 2.8 HG-D should be topcoated with Imron® 2.8 HG™ or Imron 3.5 HG™ + or other appropriate topcoat. In high temperature applications, some yellowing may occur.

COMPATIBILITY WITH OTHER COATINGS

Corlar 2.8 HG-D 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

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

COLOR

Various. 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-D – 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 VF-026™ Activator	1 gallon container 100% Full (128 oz.)

MIX RATIO

Component	Part by Vol.
Corlar 2.8 HG-D - Base	1
Corlar VF-026 Activator	1

ACTIVATION

Thoroughly agitate Corlar 2.8 HG-D base to uniformly incorporate all pigments. Add 1 part Corlar VF-026 Activator to 1 part Corlar 2.8 HG-D (26P HB DTM) 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, consult your local Axalta representative.

APPLICATION THINNERS

Normal Conditions	None
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 to metal or over properly cured primers or most old thermoset coatings in good condition. For steel surfaces, an SSPC-SP 6 Commercial Blast Cleaning is preferred for optimal performance. If not possible or practical, then Hand Tool Clean to an SSPC-SP 2 or Power Tool Clean to an SSPC-SP 3. 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 ½"- ¾" 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:	67SS	D (2.2)	1.1
Pot Pressure:			25
Atomizing Pressure			36
Air Cap:	67PB	64 HD	

HVLP Spray

	<u>Binks</u>	<u>DeVilbiss</u>
Spray Gun:	Mach 1	GTi
Fluid Nozzle:	905 (2.3)	2.0
Air Cap:	905P	2000

Airless Spray

Pump: Graco Extreme 33:1
 Airless Gun: Graco 207945
 Fluid Hose: 3/8" x 50' max.
 Tips: 411-617
 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 5 mils DTF @ 50% RH

	50°F (10°C)	70°F (21°C)	90°F (32°C)
To Touch	5 hours	3 hours	2 hours
To Handle	24 hours	16 hours	8 hours
To Recoat	24 hours	16 hours	8 hours
Full Cure		10 Days	

- May be recoated by spray when tack free



PHYSICAL PROPERTIES

Maximum Service Temperature	Up to: 250°F (121°C) Continuous (light colors will yellow) 300°F (148°C) Intermittent
Volume Solids	63% ± 2%
Weight Solids	76% ± 2%
Theoretical Coverage Per Gallon	1010 ft ² @ 1 mil DFT 202 ft ² @ 5 mils DFT

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

Weight Per Gallon 11.4 lbs./gal ± 0.2%



Shipping Weight (approximate) 1 gallon container: 13 (base) / 10 (activator);
 5 gallon container: 66 (base) / 47 (activator)

Suggested Film Thickness:
 8 mils (200 µm) wet
 5 mils (250 µm) dry

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

Flash Point:
 Corlar 2.8 HG-D Pigmented Bases > 100°F (38°C)
 Corlar VF-026 20-73°F (-7 to 23°C)

Gloss: High (80 @ 60° angle) Will vary with application technique

Package Size: 1 & 5 gallon containers
 Contact Axalta for current package availability.

Shelf Life: 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-D may settle. Agitate before each use and intermittently while sitting in storage.

VOC REGULATIONS

VOC (Theoretical less water and exempt compounds).

Condition	Thinner	% Max	VOC (lbs/gal)*	VOC (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 VF-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® 2.8 HG-D/Corlar® 2.8 HG-D and Corlar® 2.8 HG-D™. For other system results, contact Axalta Coating Systems.

Paint System: Corlar 2.8 HG-D | Corlar 2.8 HG-D | Corlar 2.8 HG-D
 26PHB | 26PHB | 26PHB

Type | Color: epoxy high build gray | epoxy high build gray | epoxy high build white

DFT: 4.9 | 4.9 | 5.8 mils

Salt Fog (ASTM B117)	1000 hours	no rusting, no blisters
	2000 hours	no rusting, no blisters
	3000 hours	no rusting, few #8 blisters, ¼" 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 loss of adhesion, slight discoloration
Electrical Resistance (ASTM D2457):	1.6X10^16	



Adhesion (ASTM D4521 A2):	1548 psi	adhesion failure between primer and substrate
Cleveland Cond (ASTM D4585):	1000 hours	no rusting, no blisters, no delamination
UV Con (ASTM D4587)*	3000 hours	Gloss before exposure 81.7 Gloss after exposure 2.8
	Evaluation	no rusting, no blisters, no delamination
Impact (ASTM D2794):	3 inch pounds	
Mandrel Bend (ASTM D522):	% Elongation - 0%	
Taber Abrasion (ASTM D4060):	weight loss in grams - 0.15	

*8 hr UV @ 50°C, 4 hr 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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