



Corlar® 2.8 PR™ High Solids Epoxy Primer



GENERAL

DESCRIPTION

A high solids, two-package, VOC conforming (2.8 lbs./gal.) Low HAPS primer based on Axalta modified polyamide epoxy technology. The resulting primer is designed to be highly durable and to deliver excellent corrosion and chemical resistance.

SUGGESTED USES

As a highly durable primer on properly prepared carbon steel, galvanized steel, stainless steel and aluminum where:

- A smooth, sandable primer is required for maximum appearance when topcoated.
- A primer for abrasive blasted, power tool cleaned or hand tool cleaned carbon steel in moderate environments is required.
- Spray application with minimal dry spray is desired.
- Application by brush and roller, in addition to spraying, may be necessary.
- No induction time and long pot life will improve productivity.

Corlar 2.8 PR is intended to be used as a primer and should be topcoated.

COMPATIBILITY WITH OTHER COATINGS

- Corlar 2.8 PR 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
- Blasted steel with average surface profile greater than 2 mils

PERFORMANCE PROPERTIES

Alkalis	Excellent
Humidity	Excellent
Solvents	Excellent
Acids	Very Good
Weather	Excellent (will chalk if left untopcoated)

COLOR

Corlar 525-33009™ Base
Corlar FG-33011™ Light Salmon Activator
Corlar FG-33272™ Gray Activator

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



MIXING

COMPONENTS

Corlar 2.8 PR – 525-33009 Base	1 gallon container 100% Full (128 oz.)
Corlar FG-XXXXX Activator	1 gallon container 100% Full (128 oz.)



MIX RATIO

Component	Part by Vol.
Corlar 2.8 PR - 525-33009 Base	1
Corlar FG-33XXX Activator	1

ACTIVATION

Add 1 part Corlar 2.8 PR activators, see Color section, to 1 part Corlar 2.8 PR 525-33009 base while power mixing. Mix until thoroughly blended. You may begin painting immediately—there is no induction time.

Reduction

No reduction should be necessary. Addition of T-8805™ or T-8245™ can be made up to 5%. If more reduction is required, consult your local Axalta representative.

APPLICATION THINNERS

Normal Conditions	up to 5% T-8805 or T-8245
Hot or Windy Conditions	up to 5% T-8805 or T-8245
Brush or Roll	up to 5% T-8805 or T-8245

POT LIFE

6-8 hours @ 70°F



APPLICATION

SURFACE PREPARATION

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. Blast profile not to exceed 2 mils.

APPLICATION CONDITIONS

Do not apply if material, substrate or ambient temperature is below 50°F (10°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%.

Note: high humidity which can lead to condensation (sweating) is to be avoided during application and initial curing. For best results, apply only when temperature during application and for four hours thereafter is expected to be above 55°F (13°C). However, these effects can be minimized and successful applications made at 45-55°F (7-13°C), provided the mixed components of the paint are allowed to react for the two hours at 75°F (24°C) or four hours at 60°F (16°C), prior to application.

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:	63CSS	FF (1.4)	1.1
Pot Pressure:			25
Atomizing Pressure			36
Air Cap:	63PR	765	



HVLP Spray

	<u>Binks</u>	<u>DeVilbiss</u>
Spray Gun:	Mach 1	GTi
Fluid Nozzle:	94 (1.4)	1.4
Air Cap:	93P	2000

Airless Spray

Pump:	Graco Extreme 33:1
Airless Gun:	Graco 207945
Fluid Hose:	3/8" x 50' max.
Tips:	415-519
Minimum pressure to avoid fingering: 2700 psi min.	

Application Notes

- Apply by spray for best results. Corlar 2.8 PR may be brushed or rolled with some sacrifice in appearance.

Re-Coat

Recoating of Corlar 2.8 PR should be done as soon as possible, a minimum of 2-3 hours at 70°F, up to overnight.

If you cannot recoat within 7 days up to 30 days, and you have not exposed the Corlar 2.8 PR to strong exterior sunlight and elevated temperatures over 100°F, you should water wash with a minimum of 1500 psi to remove any surface contamination.

If you cannot recoat before 30 days and have exposed the Corlar 2.8 PR surfaces to exterior sunlight and elevated temperatures over 100°F, you should either:

Option 1: Water wash the surface with 1500 psi and apply 1-2 mils DFT tack-mist coat Corlar 2.8 PR over the existing Corlar 2.8 PR painted surface and topcoat within 2-3 hours up to overnight, or

Option 2: Water wash the surface with 1500 psi and abrasively brush-blast to an SSPC-SP7 (sweep-blast) and topcoat within 2-3 hours up to overnight.

CLEAN UP THINNERS

T-8805 or MEK



DRY TIMES

Cure Time At Recommended Thickness 3 mils DTF @ 50% RH

	77°F
Dust Free	1 hour
Tack Free	2-3 hours
To Touch	1 hour
Recoat	2-3 hours
Hand Dry	4 hours

Dry times for Corlar 2.8 Activators are average across all activators.

Some variation in dry times might be seen across colors.



PHYSICAL PROPERTIES

Maximum Service Temperature	250°F (121°C)Continuous Service
Volume Solids	53% ± 2%
Weight Solids	73% ± 2%
Theoretical Coverage Per Gallon	850 ft ² (20.8 m ² /L) @ 1 mil DFT 283 ft ² (6.9 m ² /L) @ 3 mils DFT



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

Weight Per Gallon	12.01 lbs./gal ± 0.2%
Shipping Weight (approximate)	1 gallon container: 14 base 14 activator) 5 gallon container: 64 base 62 activator)
Suggested Film Thickness:	6 mils (150 µm) wet 3 mils (75 µm) dry

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

Flash Point: (Tag Closed Cup)	20 – 73°F (-7 to 23°C)
Gloss:	Flat
Package Size:	1 & 5 gallon containers Contact Axalta for current package sizes.
Shelf Life:	6 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 PR may settle. Mix each component thoroughly using a shear mixer at low speed before activating.

VOC REGULATIONS

VOC (Theoretical, varies with color).

	<u>VOC</u> <u>lbs/gal</u>	<u>VOC</u> <u>g/l max</u>
Mixed with all activators (average)	2.7	324
Mixed with all activators and reduced 5% with T-8805 or T-8245 Thinners	2.98	357

HAPS (Theoretical, varies with color)

	<u>lbs/gal max solids</u>
Mixed with all activators (average)	1.16
Mixed with all activators and reduced 5% with T-8805 or T-8245 Thinners	1.87

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 PR | Imron 3.5 HG. For other system results, contact Axalta Coating Systems.

Paint System:	Corlar 2.8 PR Imron 3.5 HG	
Type Color:	Epoxy urethane light salmon white	
DFT:	3 2	
Salt Fog (ASTM B117)	1000 hours	No rusting, no blisters
	2000 hours	Slight creep, #2, Few
Relative Humidity (ASTM D2247)	1000 hours	#8 Med
	2000 hours	#8 Med
Adhesion (ASTM D4521 A2):	1031 psi	Cohesive failure within the primer
Cleveland Cond (ASTM D4585):	1000 hours	#4 few blisters
Impact (ASTM D2794):	24 inch pounds	
Taber Abrasion (ASTM D4060):	Weight loss 48.5 mg	



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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