Corlar® LV-SG™
Semi-Gloss Epoxy Mastic Primer

GENERAL

DESCRIPTION
A high-build, very high solids, two component, VOC conforming (0.71 lbs/gal) semi-gloss epoxy based on Axalta amido amine cured 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, intermediate coat, direct-to-metal coating or topcoat on carbon steel, galvanized steel, stainless steel, aluminum, concrete, concrete block and wood where:

- A very low VOC, high-solids coating is required, but plural component spray equipment is not available or impractical to use.
- Single coat applications up to 12 mils dry film thickness are required.
- Rusted, hand or power-tool cleaned surfaces must be protected.
- Excellent resistance to chemical and/or marine environments is required.
- Outstanding abrasion resistance and edge protection are required.
- Application by brush and roller, in addition to spraying, may be necessary.
- Smooth appearance is desirable.

COMPATIBILITY WITH OTHER COATINGS
- Corlar LV-SG 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
- Exterior exposure without topcoat

PERFORMANCE PROPERTIES

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

COLOR CHANGE | CHALKING
Corlar LV-SG is primarily designed for corrosion protection. If gloss, color retention and color stability are important, Corlar LV-SG should be topcoated with Imron® polyurethane or other Axalta topcoat. Corlar LV-SG will chalk on exterior exposure. Colors will start to shift in continuous high heat service.

COLOR
LF-64090P™ Black
LF-63290P™ White
LF-63790P™ Cirrus Gray

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

MIXING

COMPONENTS

Corlar LV-SG Base	1 gallon container 100% Full (128 oz.)
Corlar FG-090™ Activator	1 gallon container 100% Full (128 oz.)

MIX RATIO

Component	**Part by Vol.**
Corlar LV-SG Base	2
Corlar FG-090™ Activator	1

ACTIVATION

Mix ratio 2:1. Thoroughly agitate Corlar LV-SG base to uniformly incorporate all pigments. Slowly add 1 part Corlar FG-090 Activator to 2 Parts Corlar LV-SG base until completely mixed (at least 5 minutes). Allow a 5-10 minute induction prior to using (or longer at temperatures below 70°F).

Reduction

None should be required for airless application. For application by conventional spray, add up to 5% T-6013™ with mixing until uniform. Thinning will effect VOC. If more than 5% reduction is required, consult your local Axalta representative.

APPLICATION THINNERS

Airless Application:	None
Conventional Spray:	T-6013

POT LIFE

60 minutes @ 100°F (38°C)
90 minutes @ 77°F (25°C)

APPLICATION

SURFACE PREPARATION

SSPC-SP 6 Commercial Blast Cleaning is preferred for optimal performance. If not possible or practical, Hand Tool Clean to an SSPC-SP 2 or Power Tool Clean to an SSPC-SP 3 with some sacrifice in performance. Surface must be clean, dry and free of chemical contamination.

APPLICATION CONDITIONS

Do not apply if material, substrate or ambient temperature is below 55°F (12°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

	Binks	DeVilbiss
Spray Gun:	2001	JGA
Fluid Nozzle:	67SS	D (2.2)
Air Cap:	67PB	64HD

HVLP Spray

	Binks	DeVilbiss
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:	415-521

Minimum pressure to avoid fingering: 2400 psi min.

Application Notes

- Apply by brush, roll, or spray. (Airless is the preferred method. Brush and roll can be done with some sacrifice in appearance.).

Re-Coat

Recoating of Corlar LV-SG should be done as soon as possible after dry to touch, a minimum of 8 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 LV-SG 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 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 LV-SG over the existing Corlar LV-SG painted surface and topcoat within 8 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 3-5 hours up to overnight.

CLEAN UP THINNERS

T-6013 or MEK

DRY TIMES

Cure Time At Recommended Thickness 10 mils DTF @ 50% RH

	77°F (25°C)
To Touch	4 hours
To Recoat*	8 hours
Full Cure	24 hours

Note: Lower temperatures extend drying time.

PHYSICAL PROPERTIES

Maximum Service Temperature	250°F (121°C) in continuous service 350°F (177°C) in intermittent heat
Volume Solids	90% ± 2%
Weight Solids	94% ± 2%
Theoretical Coverage Per Gallon	1443 ft² (35 m²/L) @ 1 mils DFT 288 ft² (6.9 m²/L) @ 5 mils DFT 144 ft² (3.5 m²/L) @ 10 mil DFT

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

Weight Per Gallon	12.2 lbs./gal ± 0.2%
Suggested Film Thickness:	
Single Coat:	10-12 mils DFT
Primer:	5-8 mils DFT
Intermediate:	5-8 mils DFT

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

Flash Point: (Tag Closed Cup)	81°F (37°C) Red Label Required
Gloss:	Semi-gloss
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 LV-SG may settle. Mix each component thoroughly using a shear mixer at low speed before activating.

VOC REGULATIONS

VOC (Theoretical, varies with color).

Condition	Thinner	Maximum Reduction	VOC (lbs/gal)	VOC (g/l)
Airless	None	0	0.71	85
Conventional	T-6013	0-5%	1.02	122

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

Test results are for Corlar LV-SG only. Properties may be enhanced when combined with other products in systems. For other system results, contact Axalta Coating Systems.

Paint System:	Corlar LV-SG	
Type | Color:	various	
DFT:	10	
Salt Fog (ASTM B117)	1000 hours	few #6 & #8 blisters at the scribe
	2000 hours	very few #2 blisters at the scribe
	3000 hours	very few #2 blisters at the scribe, 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 blisters, no loss of adhesion, no discoloration
Electrical Resistance (ASTM D2457):	>1X10^18	
Adhesion (ASTM D4521 A2):	3059 psi	cohesive failure within the coating
Cleveland Cond (ASTM D4585):	1000 hours	no rusting, no blisters, no delamination
Impact (ASTM D2794):	14 inch pounds	
Mandrel Bend (ASTM D522):	% Elongation - 4%	
Taber Abrasion (ASTM D4060):	weight loss in grams - 0.22	

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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