



# Corlar® 18515S™ High Build Epoxy Primer



## GENERAL

### DESCRIPTION

An epoxy sanding primer-surfacer that builds to 12 to 16 mils to provide leveling and filling where required. It has been formulated to sand easily. This high-solids primer has a ready-to-spray VOC of less than 2.8 lbs/gal.

### RECOMMENDED USES

Corlar 18515S High-Build Epoxy Primer is recommended for use above the waterline as a sanding surfacer over properly sanded gelcoat, faired and/or primed substrates. It is compatible with most epoxy primers and polyurethane topcoats with proper surface preparation.

Corlar 18515S is recommended for use with:

Primers: Corlar 18510S™, 18513S™ Epoxy Primer

Topcoats: Imron® MS600™, Imron MS100™

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



## MIXING

### COMPONENTS

Corlar® 18515S High-Build Epoxy Primer

Corlar® 18115S™ High-Build Epoxy Activator

18710S™ VOC Exempt Reducer

### MIX RATIO

Thoroughly mix Corlar 18515S High-Build Epoxy Primer prior to activation. Mix activated material well prior to use.

### Three Component System

Corlar18515S High-build Epoxy Primer  
Corlar 18115S High-Build Epoxy Activator  
18710S VOC-Exempt Reducer Optional

### Parts by Volume

4

1

up to 10%

### INDUCTION TIME

Induction time is 15 minutes.

### POT LIFE

Pot life is 8 hours at 70°F (21°C).

### ADDITIVES

None recommended.



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## APPLICATION

### SUBSTRATES AND SURFACE PREPARATION

Substrate must be properly prepared for application including scuff sanding and cleaning. When applying over fairing or primer, follow cure and recoat window guidelines to ensure proper adhesion. Scuff sand as required. Use 80 grit for fairing and 240 grit for gelcoat substrates.

### ENVIRONMENTAL CONDITIONS

Substrate and ambient temperature must be between 60°F (16°C) and 100°F (38°C). The substrate must be at least 5°F (3°C) above the dew point. Relative humidity should be below 90%. Heating activated material above 110°F (43°C) may cause gelation.

### GUN SETUP

Corlar 18515S High-Build Epoxy Primer can be applied with conventional spray equipment using pressure pot. Material will not apply properly with a suction/siphon/gravity gun.

**Conventional**  
Pressure Pot

**Fluid Tip**  
2.2mm - 2.8mm (0.086" - 0.110")

### FLUID DELIVERY

Conventional

12-10 oz./minute

### AIR PRESSURE

Conventional

50-60 psi atomizing air

### APPLICATION

Apply additional product using a full-wet coat to achieve 5 - 8 mils wet film thickness. Point-to-point flash time between coats should be 15 to 30 minutes depending upon environmental conditions. Apply subsequent coats as required maintaining flash between coats. Maximum 4 coats, with total film thickness of 12.0 – 16.0 mils dry.

### CLEANUP SOLVENTS

Axalta 107™ Low VOC Gun & Equipment Cleaner  
Axalta 105™ Gun & Equipment Cleaner



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## DRY TIMES

At 70°F (21°C)

Dependent upon film builds and ambient conditions

Dry to Touch

2 - 4 hours

Dry to Sand

12 - 16 hours

### RECOAT

Primer may be over-coated with itself within 24 hrs.

Prior to final finish primer application, or overcoating, sand with 240-grit or higher using a dual action orbital sander.



## PHYSICAL PROPERTIES

### VOC

RTS Corlar 18515S Epoxy Primer

Less Exempts (LE)	As Packaged (AP)
2.7 lbs/gal	2.2 lbs/gal

### FACTORY PACKAGED PRIMER

Color  
Closed Cup Flash Point  
Shelf Life

Off-white  
20°F - 73°F  
2 years (Unopened at 50°-110°F)

### READY-TO-SPRAY

Theoretical Coverage

807 ft<sup>2</sup>/gal at 1 mil dry film thickness  
67 ft<sup>2</sup>/gal at 12 mils dry film thickness

Weight Solids  
Volume Solids  
Gallon Weight

70.8%  
50.3%  
13.5 lbs/gal

### DRY FILM

Gloss  
Recommended Film Thickness

Satin  
12 – 15 mils DFT

### COATING PERFORMANCE

Adhesion  
Chemical and Solvent Resistance  
Humidity Resistance

Excellent  
Excellent  
Excellent

## VOC REGULATED AREAS

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.

## 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. Do not allow material or overspray to enter drains or waterways.

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In the United States:  
**1.855.6.AXALTA**  
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In Canada:  
**1.800.668.6945**  
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