CORLAR®
824S™ PRIMER

GENERAL

DESCRIPTION
A two-component, epoxy primer that delivers excellent durability and good corrosion protection.

SUGGESTED USES
Over properly treated metal substrates. Highly recommended for use over properly treated aluminum. Note: clean and degrease substrate to remove contaminants. Treat bare steel with 5717S™ or 5718S™ Conditioners. Treat aluminum with 225S™ or 226S™ Conditioners.

COMPATIBLE COATINGS
Compatible with all Axalta Transportation topcoat systems.

NOT RECOMMENDED FOR
Immersion service or stainless steel

DRY FILM CHARACTERISTICS
With appropriate topcoat

Chemical Resistance	VERY GOOD
Humidity Resistance	EXCELLENT
Weatherability	EXCELLENT

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

MIXING

MIX RATIO
Thoroughly mix prior to activation. The use of a Cyclone® shaker is recommended. Combine components and mix thoroughly. Filter material prior to spray application.

Component	Volume
824S™ Primer	2
826S™ Activator	1
3602S™ Thinner	Up to 20%

Decrease reduction to increase film build applications.

INITIAL APPLICATION VISCOSITY
20-23 seconds with Zahn #2

INDUCTION TIME
Allow induction time of 1 hr. if temperature of paint is above 70°F (21°C) and 2 hours if temperature of paint is 50-70°F (10-21°C). Do not use when temperature is below 50°F (10°C).

POT LIFE - 70ºF (21°C)
72 hours

APPLICATION

APPLICATION CONDITIONS

Do not apply if material, substrate or ambient temperature is less than 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%.

APPLICATION EQUIPMENT

Refer to spray equipment documentation for setting recommendations.
Pressure Pot
Gravity Feed Gun
Suction Spray
Airless Spray
Air-Assisted Airless

APPLICATION

Apply one coat to 0.7-1.0 mil. dry film thickness. For optimum corrosion resistance, apply a second coat of equivalent build for a total of 1.4-2.0 mils.

Allow to dry 2-4 hours before topcoat application. Cure is dependent on temperature, and recoat time may be longer at lower temperatures.

APPLICATION SOLVENTS

3602S™ Thinner

CLEANUP SOLVENTS

3602S™ Lacquer Thinner
106™ Lacquer Thinner
107™ Low VOC Gun Cleaner
108™ Low HAPS Cleaning Solvent

DRY TIMES

AIR DRY

77°F (25°C) & 50% RH at recommended film thickness

Dry to touch:	2 hours
Dry to handle:	2 hours
Dry to recoat:	2-4 hours
Hard dry:	16 hours
Full cure:	5 days

Product must be sanded if allowed to dry for more than 72 hours

FORCE DRY

30 minutes at 140-180°F (60-82°C)

PHYSICAL PROPERTIES

Maximum Service Temperature	200°F (92°C) in continuous service 200°F (92°C) in intermittent heat
Weight Per Gallon (component only)	12.79 lbs.
Weight Per Liter (component only)	1532 grams
Suggested Dry Film Thickness	0.7 – 2.0 mils
Gloss	Flat
Color	Light Gray
Flash Point (Closed Cup)	See MSDS/SDS
Shelf Life	12 months minimum

RTS mixed 2:1 with:	826S plus 20% 3602S
Gallon Weight pounds per gallon	10.25
Gallon Weight grams per liter	1229
VOC AP pounds per gallon	4.4
VOC AP grams per liter	531
VOC LE pounds. per gallon	4.7
VOC LE grams per liter	566
Weight Solids	52.8%
Volume Solids	30.8%
Weight Volatiles	47.2%
Weight Water	0.0%
Volume Water	0.0%
Weight Exempt Solvents	3.9%
Volume Exempt Solvents	6.1%
Theoretical Coverage per RTS Gallon at 1 mil DFT	494 ft^2 (45.9 m^2)

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/SDS 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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