



CORLAR® 2.8 PR™ HIGH SOLIDS EPOXY PRIMER

Corlar® 2.8 PR™ is a high solids, two-package, VOC conforming (2.8 lbs./gal.) Low HAPS primer based on DuPont modified polyamide epoxy technology. The resulting highly durable primer delivers 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.

NOT RECOMMENDED FOR:

- Immersion service
- Blasted steel with average surface profile greater than 2 mils

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 DuPont Performance Coatings Representative for specific recommendations.

MAXIMUM SERVICE TEMPERATURE:

250°F (121°C) in continuous service

COLOR CHANGE/CHALKING:

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

PERFORMANCE PROPERTIES:

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

VOLATILE ORGANIC CONTENT (VOC) THEORETICAL: VARIES WITH COLOR

Corlar® 2.8 PR™ Mixed with all activators 2.7 lbs/gal (324 g/l) average for all activators
 Corlar® 2.8 PR™ Mixed with all activators 2.98 lbs/gal (357 g/l)
 Activators and reduced 5% with DuPont T-8805™ or T-8245™ Thinners.

HAPS INFORMATION THEORETICAL: VARIES WITH COLOR

Corlar® 2.8 PR™ Mixed with all activators 1.16 lbs/gal solids max
 Corlar® 2.8 PR™ Mixed with all activators and reduced 5% with DuPont™ T-8805™ or T-8245™ 1.87 lbs/gal solids max

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 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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CORLAR® 2.8 PR™ High Solids Epoxy Primer

COLOR:

Corlar® 525-33009™ Base	Corlar® FG-33045™ Dark Salmon	Corlar® FG-33278™ Black
Corlar® FG-33011™ Light Salmon	Corlar® FG-33046™ Buff	
Corlar® FG-33044™ Red Oxide	Corlar® FG-33272™ Gray	

GLOSS:

Flat

CURE TIME – HOURS @ 77°F (25°C) & 50% R.H.***w/Corlar® 2.8 Activators (Dry times are average across all activators)**

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

*See Additional Comments 1 & 2

THEORETICAL COVERAGE PER GALLON:*850 ft.² (20.8 m²/L) @ 1 mil DFT283 ft.² (6.9 m²/L) @ 3 mils DFT

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

SUGGESTED FILM BUILD:

6 mils (150 µm) wet
3 mils (75 µm) dry

VOLUME SOLIDS (MIXED):

53 ± 2%

WEIGHT SOLIDS (MIXED):

73 ± 2%

WEIGHT PER GALLON (MIXED):

12.01 ± 0.2 Lb.

FLASH POINT (TAG CLOSED CUP):

20 – 73°F (-7 to 23°C)

PACKAGING:

1 & 5 gallon containers (Please contact DuPont Customer Service for availability in 5 gallon containers.)

SHIPPING WEIGHT (LBS.) APPROXIMATE:

1 gallon container: 14(base) / 14 (activator);
5 gallon container: 64 (base) / 62 (activator)

SHELF LIFE & STORAGE CONDITIONS:

Store in a dry, well-ventilated area. Storage temperatures should be between -30°F (-34°C) and 120°F (48°C).

- 6 months minimum
- Corlar® 2.8 PR™ may settle. Agitate before each use.

SAFETY:

Consult the Material Safety Data Sheet for this product prior to use.



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APPLICATION INSTRUCTIONS

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.

ACTIVATION:

Add 1 part Corlar® 2.8 PR activators, see section on Color, 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.

POT LIFE:

6-8 hours @ 70°F

REDUCTION:

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

APPLICATION THINNERS:

Up to 5% DuPont T-8805™ or T-8245™

CLEAN UP THINNERS:

DuPont T-8805™ or MEK

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.

APPLICATION EQUIPMENT:

- Apply by spray for best results. Corlar® 2.8 PR™ may be brushed or rolled with some sacrifice in appearance.
- Manufacturers listed below are a guide. Others may be used. Changes in pressure and tip size may be required to achieve proper application.

BRUSH & ROLL:

- 1/4" - 1/2" nap Wooster Pro/Doo-Z roller cover. Keep roll wet. Roll in one direction, rewet, then cross roll.
- 3"-4" Wooster China Bristle Brush

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	

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CORLAR[®] 2.8 PR[™] High Solids Epoxy Primer

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.

ADDITIONAL COMMENTS:

1. 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.
2. Some variation in dry times might be seen across colors.



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ASTM INFORMATION

Physical properties are for a system of Corlar[®] 2.8 PR[™]/Imron[®] 3.5 HG[™]. For other system results, contact DuPont Technical Service.

◆ 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	