



# Corlar® 3.0 PR™ High Solids Epoxy Primer



## GENERAL

### DESCRIPTION

A high solids, two component, VOC conforming (3.0 lbs./gal.) Low HAPS productive primer based on Axalta epoxy technology. The resulting primer is formulated to be highly durable with very fast dry times and to deliver excellent corrosion and chemical resistance.

### SUGGESTED USES

As a highly durable primer on properly prepared substrates where:

- Recoating in 30 minutes is required for maximum productivity.
- No induction time and long pot life will improve productivity.
- A smooth, primer at 3 mils DFT for maximum appearance when topcoated is required.
- A high build primer up to 4 mils DFT over abrasive blasted or power tool cleaned carbon steel substrates is needed.

Corlar 3.0 PR is intended to be used as a primer and should be topcoated.

### COMPATIBILITY WITH OTHER COATINGS

- Corlar 3.0 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

### PERFORMANCE PROPERTIES

(with appropriate topcoat)

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

### COLOR

2525-100™ White      2525-400™ Gray

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



## MIXING

### COMPONENTS

Corlar 3.0 PR – 2525 Base      1 gallon container 100% Full (128 oz.)  
Corlar FG-2525™ Activator      1 gallon container 100% Full (128 oz.)

### MIX RATIO

Component	Part by Vol.
Corlar 3.0 PR - 2525 Base	3
Corlar FG-2525 Activator	1



**ACTIVATION**

Using a shear mixer at low speed so to create a small vortex, mix 2525 base. Using same procedure mix, FG-2525 activator. Slowly add 1 part FG-2525 Activator to 3 parts mixed 2525 Base. Continue to mix at low speed using a shear mixer until thoroughly blended. You may begin painting immediately—there is no induction time.

**Reduction**

No reduction is necessary. If reduction is required, consult your local Axalta representative.

**POT LIFE**

5 hours @ 75°F

2.5 hours @ 85°F



**APPLICATION**

**SURFACE PREPARATION**

SSPC-SP-6 Commercial Blast Cleaning will provide very good performance. Other surface preparations such as Phosphating and Sanding are also acceptable as long as surface is clean, free of rust etc. Surface must be clean, dry and free of chemical contamination. Average peak to valley surface profile shall be 1.5 to 2.5 mils.

**APPLICATION CONDITIONS**

Do not apply if material, substrate or ambient temperature is below 35°F (2°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).

**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)	1.0-1.7
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

**Application Notes**

- Corlar 3.0 PR is a very fast drying material. Under high temperature conditions, on large substrates it might be necessary to add 15395S to help minimize dry spray and help melt in.

**Re-Coat**

Recoating of Corlar 3.0 PR should be done as soon as possible, a minimum of 10 minutes at 75°F, up to overnight. If you cannot recoat within 3 days, a light sanding with 320 grit sandpaper, must be done to assure proper topcoat adhesion. You should water wash with a minimum of 1500 psi to remove any surface contamination.

**CLEAN UP THINNERS**

105, 106, 107, 108, TP33364



## DRY TIMES

Cure Time At Recommended Thickness 2 mils DTF @ 50% RH

	<b>75°F</b>	<b>85°F</b>
Dust Free	30 minutes	30 minutes
To Touch	60 minutes	45 minutes
Recoat	15 minutes	10 minutes
Hard Dry	2 hours	1.5 hours
To Sand	5 hours	4 hours
Pack/Ship	4 hours	3 hours
Pot Life	5 hours	2.5 hours

Some slight variation in dry times might be seen across colors. Dry times can vary between 10-30 minutes @ 75°F.



## PHYSICAL PROPERTIES

All Values Ready To Spray:

Maximum Service Temperature	250°F (121°C) Continuous Service
Volume Solids	53% ± 2%
Weight Solids	70% ± 2%
Theoretical Coverage Per Gallon	850 ft <sup>2</sup> (20.8 m <sup>2</sup> /L) @ 1 mil DFT 283 ft <sup>2</sup> (6.9 m <sup>2</sup> /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	11.95 lbs./gal ± 0.2%
Shipping Weight (approximate)	1 gallon container: 13 (base + activator) 5 gallon container: 64 (base + activator)

Suggested Film Thickness:	6 mils (150 µm) wet 3 mils (75 µm) dry
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NOTE: Corlar 3.0 PR can be applied in higher builds, @ 4 mils dft, for additional corrosion resistance.

	8 mils (200 µm) wet 4 mils (100 µm) dry
Flash Point:	Base: Below 20°F Activator: 100°F- 141°F

Gloss:	Flat
Package Size:	1, 5 & 55 gallon containers Consult Axalta for current package availability.
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 3.0 PR may settle. Mix each component thoroughly using a shear mixer at low speed before activating.



## VOC REGULATIONS

All Values Ready To Spray:

	2525-100	2525-400
Max. VOC (LE):	3.0 lbs/gal (354 g/L)	3.0 lbs/gal (354 g/L)
Max. VOC (AP):	2.4 lbs/gal (293 g/L)	2.4 lbs/gal (293 g/L)
Avg. Gallon Weight:	11.50 lbs/gal (1378 g/L)	11.49 lbs/gal (1377 g/L)
Avg. Weight % Volatiles:	31.2%	31.2%
Avg. Weight % Water:	0.0%	0.0%
Avg. Weight % Exempt Solvent:	10.0%	10.0%
Avg. Volume % Water:	0.0%	0.0%
Avg. Volume % Exempt Solvent:	17.4%	17.4%

HAPS (Theoretical, varies with color)

	lbs/gal max solids
All Colors Mixed with FG-2525 No reduction	0.151
All Colors Mixed with FG-2525 and reduced 5% with 15385s	0.144
All Colors Mixed with FG-2525 and reduced 10% with 15385S	0.151

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.

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.

Revised: August 2016

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