

Corlar® 18515S™ High-Build Epoxy Primer

Type

Corlar® 18515S™ High Build Epoxy Primer is a sanding epoxy primer-surfacer.

Description

Corlar® 18515S™ High Build Epoxy Primer is a sanding primer that builds to 12 to 15 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 DuPont™ 18560S™ Alumistick™ Epoxy Primer
Fairings:	DuPont™ 18545S™, DuPont™ 18550S™
Topcoats:	Imron® MS600™, Imron® MS100™

General Information for Use

Components

Corlar® 18515S™ High-Build Epoxy Primer
Corlar® 18115S™ High-Build Epoxy Activator
DuPont™ 18710S™ VOC Exempt Reducer or DuPont™ 68083™ Thinner

Mix Ratio

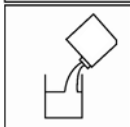
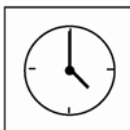
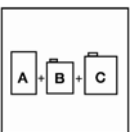
Thoroughly mix Corlar® 18515S™ High-Build Epoxy Primer prior to activation. Mix activated material well prior to use.

Three Component System

Corlar® 18515S™ High-build Epoxy Primer
Corlar® 18115S™ High-Build Epoxy Activator
DuPont™ 18710S™ VOC-Exempt Reducer*
*DuPont™ 68083™ Thinner may be substituted.

Parts by Volume

2
1
approx 10%



Pot Life and Induction Time

Pot life is 8 hours at 70°F (21°C).
Induction time is 15 minutes

Additives

None recommended



Guidelines for Use

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, 240 grit for Gelcoat substrates.



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.

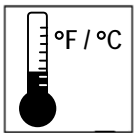
<i>Conventional</i>	<i>Fluid Tip</i>
Pressure Pot	.110"/2.8MM

Fluid Delivery

Conventional	8-12 oz/min
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Air Pressure

Conventional	50 – 60 psi atomizing air
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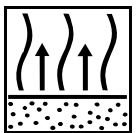
Environmental Conditions

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.



Application

Apply additional product using a full-wet coat to achieve 5 - 9 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 – 15.0 mils dry.



Dry Times

Air Dry 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

Prior to final finish primer application, or overcoating, sand with 240-grit or higher using a dual action orbital sander. Primer may be over-coated with itself within 24 hrs.



Cleanup Solvents

DuPont™ 105™ Thinner or DuPont™ 106™ Thinner

Physical Properties

VOC-Ready to Spray @ 10% reduction	<u>Less Exempts (LE)</u>	<u>As Packaged (AP)</u>
Corlar® 18515S™ High-Build Epoxy Primer	2.7 lbs/gal	2.0 lbs/gal
Using 10% DuPont™ 68083™ Thinner	3.3 lbs/gal	2.8 lbs/gal

Factory-Packaged Primer

Color	Off -White
Closed Cup Flash Point	20°F – 73°F
Shelf Life	2 years (Unopened at 50° – 110°F)

Ready-to-Spray

Theoretical Coverage	739.0 ft ² /gal at 1 mil dry film thickness
Weight Solids	65.2%
Volume Solids	46.1%
Gallon Weight	13.00 lbs/gal

Dry Film

Gloss	Satin
Recommended Film Thickness	12- 15 mils dry

Coating Performance

Adhesion	Excellent
Chemical and Solvent Resistance	Excellent
Humidity Resistance	Excellent

Safety and Handling

For industrial use only by professional, trained painters. Not for sale to 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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