



# DuPont OEM/Fleet Finishes TECHNICAL MANUAL

CORLAR 824S

## TYPE

Light gray, lead and chromate free, epoxy polyamide primer.

## DESCRIPTION

A 2-package rust inhibitive epoxy primer (activated with 826S or VG-Y-8392) which is durable, flexible, and chemically resistant for exterior or interior surfaces exposed to corrosive environments.

## SUGGESTED USES

For use over properly treated substrates. Wash surface with a mild detergent. Clean and degrease with PREP-SOL 3919S or DuPont Reducer 3812S. Treat bare metal with conditioner and conversion coating:

	CONDITIONER	CONVERSION
■ Steel	5717S	5718S
■ Aluminum	225S	226S

## NOT RECOMMENDED FOR

- Immersion service.
- Stainless steel.

## COMPATIBILITY WITH OTHER COATINGS

Highly recommended to use under CENTARI, CHROMAONE, IMRON, CENTARI 5000, IMRON 5000 and IMRON 6000 topcoats.

## DRY FILM CHARACTERISTICS

- Chemical Resistance — VERY GOOD.
- Humidity Resistance — EXCELLENT.
- Weatherability — EXCELLENT with appropriate topcoat.

## MAXIMUM SERVICE TEMPERATURE

- 200°F (92°C) in continuous service.
- 300°F (148°C) in intermittent heat.

## VOLUME SOLIDS

- 37.9% as packaged.
- 36.7% mixed 2:1 with 826S CORLAR Activator.

## WEIGHT SOLIDS

- 66.2% as packaged.
- 56.5% mixed 2:1 with 826S.

## WEIGHT PER GALLON

- 13.1 lbs/gal as packaged.
- 11.1 lbs/gal mixed 2:1 with 826S.

## SUGGESTED FILM THICKNESS

- 0.7 - 2.0 mils dry film thickness.

## THEORETICAL COVERAGE PER GALLON

- 608 sq ft/gal @ 1 mil as packaged.
- 590 sq ft/gal @ 1 mil mixed 2:1 with 826S.

## GLOSS

- Flat

## COLOR

- Light Gray

## FLASH POINT (CLOSED CUP)

- Between 20 - 73°F (-7 to -23°C)

## SHELF LIFE

- 12 months minimum.

## APPLICATION SOLVENTS

- 3602S
- 3608S

## CLEANUP SOLVENTS

- DuPont Thinner 3602S.
- Reducer 8685S.

EPOXY PRIMER

**ACTIVATION**

Mix two parts 824S Primer with one part 826S Activator. Reduce mixture up to 35% with 3602S. For increased build, decrease reduction. 824S can also be activated 3:1 with VG-Y-8392 Activator to improve dry time.

**INDUCTION TIME**

One hour at 70°F and above; 2 hours when temperature is between 55°F and 70°F. Do not use when temperature is below 55°F.

Note: The time at temperature is for paint temperature, not atmospheric temperature.

**POT LIFE**

- 3 days at 70°F.

**ADDITIONAL COMMENTS**

- Dry to recoat in 2 - 6 hours depending on film build.
- Formulated to comply with Rule 66 (non-photochemically reactive).
- Allow induction time of 12 hours at 70°F for optimum properties.
- Highly recommended for use over properly treated aluminum.

**APPLICATION CONDITIONS**

Do not apply if material, substrate or ambient temperature is less than 55°F (10°C) or above 110°F (43°C). The substrate must be at least 5°F above the dew point. Relative humidity should be below 90%.

**APPLICATION**

- Thoroughly mix two parts 824S Primer with one part 826S Activator, or mix three parts 824S with one part VG-Y-8392.
- Allow to stand for an induction period of 1 hour if temperature is 70 - 90°F; 2 hours if temperature is 55 - 70°F.
- After activating, thin up to 35% with 3602S Thinner to a viscosity of 20 - 30 seconds in a DuPont M-50 (Zahn #2) cup.

- Spray one coat to give a dry film thickness of 0.7 - 1.0 mil. For optimum corrosion resistance, spray a second coat of equivalent build (total 1.4 to 2.0 mils).
- Clean equipment with 3602S Thinner.
- Allow to dry 2 - 6 hours before topcoat application. Cure is dependent on temperature, and recoat time may be longer at lower temperatures.

**CURE TIME AT RECOMMENDED THICKNESS (AT 77°F & 50% RH)**

- |                 |           |
|-----------------|-----------|
| ■ Dry to Touch  | 2 hrs     |
| ■ Dry to Handle | 2 hrs     |
| ■ Dry to Recoat | 2 - 4 hrs |
| ■ Hard Dry      | 16 hrs    |
| ■ Full Cure     | 5 days    |

Product must be sanded if allowed to dry for more than 72 hours. Product may be force dried 30 min at 140 - 180°F.

**APPLICATION EQUIPMENT**

- Pressure Pot (recommended)
- Airless Spray
- Air-Assisted Airless
- Gravity Feed Gun
- Suction Spray
- HVLP

**FOR VOC REGULATED AREAS**

These directions refer to the use of products which may be restricted or require special mixing instructions in your area. Follow recommendations in the DuPont Compliant Products Chart for your area.

**SAFETY AND HANDLING**

DuPont is committed to helping you develop and maintain a safe working environment. Carefully read the specific warnings and precautions printed on the labels of all DuPont products before handling or using. These products are for industrial use by trained professional painters only.