



PPG Industries, Inc.
One PPG Place
Pittsburgh, PA 15272
1-800-441-9695

Product Data Sheet

Coraflox™ ADS

Epoxy Primer

Product Information

Product Code: ADS552 Off White Component A
ADS553 Gray Component A
ADS554 Curing Agent Component B

Product: Two component epoxy

Suggested Use: Coraflox™ ADS Epoxy Primer is recommended for use on properly prepared substrates to be topcoated with Coraflox ADS or Megaflox™ MS.

Product Description

Color: Gray or Off White

Gloss 60°: Typically 20-25. Gloss not controlled.

VOC: 241 g/L (2.01 lbs./gal.)

Method: Calculated (mixed)

Weight/Gallon: 12.0 ± 0.5 lbs./gal. (mixed)

In Service Heat Limitations: 400°F (205°C) maximum, dry heat

Flash Point: ADS552 & ADS553 Comp A 70°F (21°C)
ADS554 Component B 66°F (19°C)

Package: Available in full filled one and five gallon containers.

Percent Solids by Volume: 72.2% ± 3.0% (mixed)

Percent Solids by Weight: 83.2% ± 3.0% (mixed)

Drying Schedule

Air Dry per ASTM D5895			
	32°F (0°C)	77°F (25°C)	100°F (37.8°C)
Dry to Touch:	16 hours	3-4 hours	
Dry to Handle:	3 days*	7-8 hours*	Unthinned 2 to 3 hours.* Thinned with ADS708 4 to 5 hours.*
Dry to Recoat:	When dry to handle.	3 hours minimum**	3 hours minimum**

Drying times listed may vary depending on temperature, humidity and air movement.

Application Data

Substrate: Dimensionally stable

Substrate Preparation: The service life of the coating is directly related to the surface preparation. The surface to be coated must be properly prepared, dry, clean and free of contamination. Preparation varies with the substrate to be coated. Consult Technical Service for specific recommendation.

Application Method: Spray preferred. Small areas may be brushed. Roller application may be used with appropriate thinning.

Air Spray: DeVilbiss MBC gun, 704 or 777 air cap with "E" tip and needle or equivalent equipment. Atomizing pressure 55-70 psi.

Airless Spray: Equipment capable of maintaining a minimum of 1500 psi at the tip without surge. 0.017" (0.432 mm) to 0.021" (0.533 mm) orifice.

Brush: Use a high quality natural bristle brush.

Parts Base by Volume: 1 part ADS552 or ADS553 Component A

Parts Catalyst by Volume: 1 part ADS554 Component B

Thinner Code & Percent: Thinning not normally required. To compensate for unusual environmental or application conditions, and where allowed by local VOC regulations, thin up to 10% with ADS708 in cool weather and up to 10% with ADS702 or ADS704 in warmer weather.

Digestion Time: None required

Pot Life: 32°F (0°C) 4-5 hours
77°F (25°C) 4 hours
100°F (38°C) 1 hour unthinned, 4 hours thinned with ADS702.

Wet Film Per Coat: 2.8 to 4.2 mils as a tie coat
6.9 to 9.7 mils for barrier protection

Dry Film Per Coat (mils): 2.0-3.0 as a tie coat 5.0-7.0 for barrier protection

Coverage Sq. Ft./Gal.: 579 to 386 sq. ft. (53.8 to 35.9 sq. meters) at 2.0 to 3.0 mils dry film per U. S. gallon (3.78 liters).
232 to 165 sq. ft. (21.6 to 15.3 sq. meters) at 5.0 to 7.0 mils dry film per U. S. gallon (3.78 liters).
Coverage figures do not include loss due to mixing, transfer or application of the coating.



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Application Data (continued)

Clean Up Solvent: ADS701, ADS702, ADS704 or ADS708

Additional Surface Preparation Information: Service for Ferrous Metal: Minimum surface preparation for ferrous metal substrates is wire brushing (SSPC-SP 2/3, Hand Tool Cleaning) to remove all loose rust and paint. Service life is in direct proportion to surface preparation.

Hot Dipped Galvanized Steel: Caution must be used when selecting coatings for use on all galvanized metal surfaces. These substrates may have a factory applied stabilizer, which is used to prevent white rusting during storage and shipping. Some of these stabilizers are not soluble in solvents used for degreasing. They remain on the surface and prevent the paint from gaining maximum adhesion. Such stabilizers must be removed by either brush blasting or chemical treatment.

Aluminum: Must be lightly blasted to remove contaminants and provide an anchor pattern prior to application of Coraflox ADS Epoxy Primer. If blasting is not possible, then the aluminum surface must be pretreated with ADS Wash Primer, ADS225/ADS226/ADS703. The Wash Primer must dry overnight prior to the application of Coraflox ADS Epoxy Primer.

Tie coat for aged fluoropolymer: Surface must be dry, clean and free of all contamination.

Mixing Instructions: Agitate both components thoroughly prior to blending. Add equal parts by volume ADS554 Component B to Component A and mix well. No digestion time is required.

Additional Information

Apply only when air, product and surface temperatures are above 32°F (0°C) and surface temperature is at least 5°F (3°C) above the dew point and no frost or ice is present on the substrate. This product may be applied to damp surfaces. Excessive dampness is observed when the surface appears to shine from moisture or there is standing water.

Due to the inherent nature of the chemistry of these products, they will yellow, chalk and lose gloss with age and exterior exposure. None of these conditions will affect the integrity of the film or its ability to guard against corrosion.

Not intended residential use.

Read all label and Material Safety Data Sheet (MSDS) information prior to use. MSDS are available by calling 1-800-238-8596.

Spray equipment must be handled with due care and in accordance with manufacturer's recommendation.

High-pressure injection of coatings into the skin by airless equipment may cause serious injury, requiring immediate medical attention at a hospital.

WARNING! If you scrape, sand, or remove old paint, you may release lead dust or fumes. LEAD IS TOXIC. EXPOSURE TO LEAD DUST OR FUMES CAN CAUSE SERIOUS ILLNESS, SUCH AS BRAIN DAMAGE, ESPECIALLY IN CHILDREN. PREGNANT WOMEN SHOULD ALSO AVOID EXPOSURE. Wear a properly fitted NIOSH-approved respirator and prevent skin contact to control lead exposure. Clean up carefully with a HEPA vacuum and a wet mop. Before you start, find out how to protect yourself and your family by contacting the USEPA National Lead Information Hotline at 1-800-424-LEAD or log on to www.epa.gov/lead. In Canada contact a regional Health Canada office. Follow these instructions to control exposure to other hazardous substances that may be released during surface preparation.

*This condition does not mean that the paint film has reached full cure; handling can be achieved without loosening, wrinkling or otherwise marring the film under minimal pressure from fingers or hands. Drying times listed may vary depending on temperature, humidity, air movement and film thickness.

**Under this condition the paint film is not dry to handle and may be easily damaged. When recoating or topcoating, the dry time of the total system will be extended compared to the dry time of a single coat. Additional care must be taken not to exceed the recommended film thickness of primer and topcoat. Dry times will vary depending on temperature, humidity, air movement and film thickness.