Product Data Sheet

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

Coraflon™ ADS High Build Epoxy Primer/Intermediate

Product Information

Product Code:	ADS538 White Component A ADS539 Curing Agent Component B
Product:	Polyamide Epoxy
Suggested Use:	Coraflon™ ADS High Build Epoxy Primer/ Intermediate is recommended for use on properly prepared substrates to be topcoated with Coraflon ADS.

Product Description

Color:	White
Gloss 60°:	Flat
VOC:	302 g/L (2.52 lbs/gal)
Method:	Calculated (mixed)
Weight/Gallon:	13.6 ± 0.5 lbs./gal. (mixed)
In Service Heat Limitations:	250°F (121°C) maximum, dry heat
Flash Point:	ADS538 Component A 78°F (26°C) ADS539 Component B 123°F (51°C)
Package:	ADS538 Component A is available in short filled gallon and five gallon containers ADS539 Component B is available in short filled quart and full filled gallon containers
Percent Solids by Volume:	66.2% ± 3.0% (mixed)
Percent Solids by Weight:	81.5% ± 3.0% (mixed)

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. See WARNING in Additional Information section on page 2.
Application Method:	Air Spray: DeVilbiss MBC gun, 704 or 777 air cap with "E" tip and needle or equivalent equipment. Atomizing pressure 30-60 psi. Airless Spray: Equipment capable of maintaining a minimum of 2500 psi at the tip without surge. 0.015" (0.38 mm) to 0.019" (0.48 mm) orifice. See ** comments on page 2.
Parts Base by Volume:	4 parts ADS538 Component A
Parts Catalyst by Volume:	1 part ADS539 Component B
Thinner Code & Percent:	Thin up to 10% by volume with ADS701 as needed for application.
Digestion Time:	45 minutes
Pot Life:	8 hours at 77°F (25°C) The addition of 6 fluid ounces of 97-723 Epoxy Accelerator per mixed gallon will result in pot life of 2.5 hours at 77°F (25°C).
Percent Solids by Volume at Application:	60.2 ± 3.0% (mixed and thinned 10%)
Wet Film Per Coat:	4.2 to 10.0 mils (mixed and thinned 10%)

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Application Data (continued)

Dry Film Per Coat: 2.5 to 6.0 mils

Coverage Sq. Ft./Gal.: 425 to 177 sq. ft. (39.5 to 16.4 sq. meters) at 2.5 to 6.0 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.

Clean Up Solvent: ADS701 or ADS702

Mixing Instructions: Under mechanical agitation, mix ADS538 Component A thoroughly. Add ADS539 Component B and mix until uniform. Allow to digest for 45 minutes before use. When adding 97-723 Epoxy Accelerator, add Component B to Component A and mix well, then add 97-723 Epoxy Accelerator under agitation.

Drying Schedule: Per ASTM D5895, air dry and 50% relative humidity

	77°F (25°C)		40°F (4.4°C)	
	Without 97-723 Accelerator	With 97-723 Accelerator	Without 97-723 Accelerator	With 97-723 Accelerator
Dry to Touch:	2.5 hours	1 hour	7.5 hours	4 hours
Dry Through:	6 hours	1.75 hours	26 hours	6.5 hours
Dry to Recoat:	24 hours	When dry through	Not recommended	When dry through

Apply only when air, product and surface temperatures are above 40°F (4.4°C) and surface temperature is at least 5°F (3°C) above the dew point. Curing is retarded below 60°F (15.5°C) without the addition of accelerator. Add up to 6 fluid ounces 97-723 Epoxy Accelerator per mixed gallon of ADS538/ADS539 when applying below 50°F (10°C). DO NOT EXCEED 6 FLUID OUNCES OF 97-723 PER MIXED GALLON.

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

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Additional Information

Store materials at temperatures between 50°F (10°C) and 95°F (35°C).

**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.

Read all label and Material Safety Data Sheet (MSDS) information prior to use. MSDS are available by calling 1-800-441-9695.

Not intended for residential use.

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.

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