

Product Data Sheet



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

Coraflox™ Urethane Mastic

DTM

ADS650 Series

Product Information

Product Code: ADS650 Neutral Base Comp. A
ADS651 White Base Comp. A
ADS650B Curing Agent Comp. B

Generic Type: Acrylic Urethane

Suggested Use: A high solids, high build, two component acrylic urethane formulated for direct-to-metal applications. This product is compliant for application in areas where VOC requirements of less than 250 g/l (2.08 lbs/gal) is required. Can earn LEED NC Version 2.2 Credits.

Not Recommended: Immersion service.

Product Description

Color: Available in a wide variety of colors.

Gloss 60°: 85 minimum

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

Method: Calculated

Weight/Gallon: 11.3 ± 0.5 lbs./gal. *

In Service Heat Limitations: 250°F (121°C) maximum, dry heat

Flash Point: Comp. A, 84°F (29°C)
Comp. B, 460°F (238°C)

Package: ADS651 and ADS650 Comp. A are available in short filled one and five gallon containers.
ADS650B Comp. B is available in short filled quart and gallon containers.

Percent Solids by Volume: 65.2 ± 3.0% *

Percent Solids by Weight: 74.3 ± 3.0% *

Application Data

Substrate: Ferrous metal

Substrate Preparation: The service life of the coating is directly related to the surface preparation. The surface to be coated must be dimensionally stable, properly prepared,

dry, clean and free of contamination including oil, dirt, grease and rust.

SSPC-SP2 Hand Tool or SSPC-SP3 Power Tool Cleaning is minimum. For best performance, SSPC-SP6 (NACE #3) Commercial Blast Cleaning is recommended.

See WARNING in Additional Information on page 2.

Application Method: Apply by air or airless spray, brush or roller.

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

Airless Spray: Equipment capable of maintaining a minimum of 2500 psi at the tip without surge. 0.013" (0.330 mm) to 0.017" (0.432 mm) orifice.

Brush: Use a high quality natural bristle brush.

Roller: Use a 3/8" nap roller cover with a solvent resistant core.

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.**

Parts Base by Volume: 5 parts ADS651 or ADS650 Comp. A

Parts Catalyst by Volume: 1 part ADS650B Comp. B

Thinner Code & Percent: Thinning not normally required. For a 2.08 lb/gal (250 g/l) VOC, thin up to 5% by volume with ADS706 Exempt Thinner. ADS709 can be added, up to 5% by volume, for brush, roll or spray application where VOC regulations allow.

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Corafon™ Urethane Mastic DTM ADS650 Series

Application Data (continued)

Digestion Time: None required

Pot Life: 3 hours @ 77°F (25°C)

Coverage Sq.

Ft./Gal. @ 4 mils: 261 sq. ft./gal. *

Wet Film Per 4.6 to 7.7 mils *

Coat:

Dry Film Per Coat: 3.0 to 5.0 mils

Mixing Instructions: Mix Component A thoroughly. Add ADS650B Curing Agent Comp. B to Comp. A and mix well. No digestion time is required.

Clean Up

Solvent: ADS709, ADS705 or ADS708

Drying Schedule

Air Dry @ 77°F (25°C) ASTM D5895, 50% RH

With 97-722 Accelerator				Without 97-722 Accelerator		
	90°F(32°C)	77°F(24°C)	40°F(4.4°C)	90°F(32°C)	77°F(24°C)	40°F(4.4°C)
Dry To Touch:	<1 Hour	<1 Hour	1 Hour	1 Hour	2 Hours	4 Hours
Dry Through:	<1 Hour	<1 Hour	4 Hours	8 Hours	8.5 Hours	>24 Hours
Dry to Recoat:	When dry through	When dry through	When dry through	When dry through	When dry through	When dry through

Additional Information

Apply only when air, product and surface temperatures are at least 50°F (10°C) and the surface temperature is at least 5°F (3°C) above the dew point.

Store materials at temperatures between 45°F (7.2°C) and 95°F (35°C).

*Values are calculated using ADS651 White Comp. A mixed with ADS650B Curing Agent Comp. B. Values will vary with color.

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

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.