



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

Corafylon™ ADS
Epoxy PVDF Bonding Primer
ADS510 Series

(Formerly WT200602/WT200603)

Product Information

Product Code: ADS510, Component A - White
ADS511, Component A - Gray
ADS512, Component B

Product: Polyamide Epoxy

Suggested Use: Corafylon™ ADS Epoxy Bonding Primer is recommended as an intermediate coat or tie coat over previously applied PVDF coatings on steel or aluminum substrates.

Product Description

Color: Gray, White

Gloss 60°: Satin

VOC: 227 g/L (1.89 lbs./gal.)*

Method: Calculated (mixed)

Weight/Gallon: 11.8 ± 0.5 lbs./gal. (mixed)*

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

Flash Point: ADS510 80°F (28°C)
ADS511 80°F (28°C)
ADS512 123°F (51°C)

Package: ADS510 and ADS511 is filled in One quart (946 mL) One gallon (3.79 liters) and Five gallon (18.93 liters) containers
ADS512 is filled in One quart (946 mL) One gallon (3.79 liters) and Five gallon (18.93 liters) containers

Percent Solids by Volume: 73.8 ± 3.0% (mixed)*

Percent Solids by Weight: 84 ± 3.0% (mixed)*

Drying Schedule

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

Dry to Touch: 3 hours

Dry to Handle: 6 hours

Dry to Recoat: 6 hours minimum

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

Application Data

Substrate: PVDF coated steel or aluminum

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 all contamination.

Solvent clean per SSPC-SP1 or power wash to remove contaminants.

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" (0.381 mm) to 0.018" (0.457 mm) orifice.

Small areas may be brushed using a high quality natural bristle brush.

Please read ** items on page 2.

Parts Base by Volume: 1 part ADS510 or ADS511 Component A

Parts Catalyst by Volume: 1 part ADS512 Component B

Thinner Code & Percent: Thin up to 20% by volume with ADS706 in VOC compliant areas <250 g/L. Can be thinned up to 10% with ADS702 in areas <340 and 450 g/L.

Digestion Time: None

Pot Life: 3 - 4 hours at 77°F (25°C)

Percent Solids by Volume at Application: 67 ± 3.0% (mixed and thinned 10%)*

Wet Film Per Coat: 3 to 7.5 mils

Dry Film Per Coat: 2.0 to 5 mils

Product Data Sheet



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Application Data (continued)

Coverage Sq. 1184*
Ft./Gal. @ 1 mil: Coverage figures do not include loss due to mixing, transfer or application of the coating.

Clean Up
Solvent: ADS701 or ADS702 Thinners

Mixing Under mechanical agitation, mix ADS511 Component A thoroughly. Add ADS512 Component B to
Instructions: Component A and mix until uniform. No digestion time required.

Additional Information

*Items listed are based on 1 to 1 mix of ADS511 and ADS512

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.

**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: Removal of old paint by sanding, scraping or other means may generate dust or fumes which contain lead. EXPOSURE TO LEAD DUST OR FUMES MAY CAUSE ADVERSE HEALTH EFFECTS, ESPECIALLY IN CHILDREN OR PREGNANT WOMEN. Controlling exposure to lead or other hazardous substances requires the use of proper protective equipment, such as a properly fitted and approved (e.g., NIOSH-approved) respirator and proper containment and cleanup. For additional information, contact the USEPA/Lead Information Hotline at 1-800-424-LEAD or the regional Health Canada office.

The statement and methods presented in this bulletin are based upon the best available data and practices known to PPG Architectural Finishes, Inc. at the present time. They are not representations or warranties of performance, results or comprehensiveness of such data. Since PPG Architectural Finishes, Inc. is constantly improving its coatings and paint formulas, future technical data may vary somewhat from what was available when this bulletin was printed. Contact your PPG Sales Representative or the Pittsburgh Paints Information Center for the most up-to-date information.

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