

Architectural Coatings

Corafon® ADS Epoxy PVDF Bonding Primer

**PRODUCT INFORMATION**

**Product Codes:** ADS510 A Component - White  
 ADS511 A Component - Gray  
 ADS512 B Component - Curing Agent

**Product Type:** Polyamide Epoxy

**Product Description:** Corafon ADS Epoxy Bonding Primer is recommended as an intermediate coat or tie coat over previously applied PVDF coatings on exterior or interior steel or aluminum substrates.

**RECOMMENDED SUBSTRATES**

PVDF Coated Metal

**TINTING AND BASE INFORMATION**

ADS510 A Component – White  
 ADS511 A Component – Gray

Do not tint.

**PRODUCT DATA**

**Color:** White (ADS510)  
 Gray (ADS511)  
**Gloss:** Satin

**VOC (mixed and thinned)\*:** 227 g/L (1.89 lbs./gal.)

**Volume Solids (mixed, unthinned)\*:** 73.8% ± 3.0%  
**Weight Solids (mixed, unthinned)\*:** 84% ± 3.0%

**Weight per Gallon (mixed, unthinned)\*:** 11.8 lbs. (5.4 kg) ± 0.5 lbs. (227 g)

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

\*Values calculated using Corafon ADS510 White with ADS512.

**CLEANUP:** ADS702 or ADS706 Thinners

**DISPOSAL:** Contact your local environmental regulatory agency for guidance on disposal of unused product. Do not pour down a drain or storm sewer.

**FEATURES AND BENEFITS**

**Feature**

Excellent adhesion  
 Corrosion and abrasion resistant  
 Ease of application  
 Promotes excellent base  
 Flexible

**Benefit**

Bonds to previously applied PVDF coatings  
 Protects the substrate longer  
 Can be brushed, sprayed or rolled applied  
 Improves durability of finish  
 Withstands bends with no cracking or peeling

**TEST DATA**

Property	Test Method	Results
Abrasion Resistance	ASTM D4060	Tabor Loss CS-17 100g
Adhesion	ASTM D3359	5A
Impact Resistance	ASTM D2794	160 Forward/80 Reverse Cross Hatch No Loss
Pencil Hardness	ASTM D3363	F
Flexibility	ASTM D4145	Pass ¼" No Cracking
Salt Fog	ASTM B117	9, 4mm Creepage

Performance data may vary depending on substrate, surface preparation, system selected, color, and/or film build.

## SURFACE 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. **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](http://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.

Solvent clean per SSPC-SP 1. Abrade substrate to remove gloss and obtain minimum surface profile of 1.0 mil. Solvent wipe to remove dust.

## MIXING AND THINNING INFORMATION

**Mix Ratio by Volume:** 1:1 (ADS510 or 511: ADS512)

**Mixing Instructions:** Under mechanical agitation, mix ADS510/ADS511 thoroughly. Add ADS512 to ADS510/ADS511 and mix until uniform.

**Induction Time:** Not applicable

**Pot Life:** 3 - 4 hours at 77°F (25°C)

**Thinning:** Thin up to 10% by volume with ADS702 or ADS706

**Accelerator:** None available

## APPLICATION

**Coverage:** 215 to 538 sq. ft./gal. (20 to 50 sq. m/ 3.78L)

Coverage figures do not include loss due to surface irregularities and porosity or material loss due to application method or mixing.

Wet Film Build: 3 to 7.5 mils (mixed & thinned)

Dry Film Build: 2 to 5 mils

### 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. 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. Explosion-proof equipment must be used when coating with these materials in confined areas. Keep containers closed and away from heat, sparks, and flames when not in use.

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

## DRYING SCHEDULE

Air Dry @ 77°F (25°C); 50% relative humidity

To Touch: 3 hours

To Handle: 6 hours

To Recoat: 6 hours

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

**SAFETY**

**Safety:** Before using the products listed in this publication, carefully read each product label and follow directions for its use. Read and observe all label and Material Safety Data Sheet (MSDS) information prior to use. MSDS are available by calling 1-800-441-9695. Utilize appropriate safety practices including use of proper personal protective equipment. See MSDS for details.

**Ventilation:** This product contains flammable solvents. Keep away from sparks and open flames. When working in enclosed areas, proper ventilation and air circulation must be maintained during and after application and coating cure. Before coating application, an assessment of the ventilation system should be made to ensure solvent vapors are effectively removed from the area. Effective solvent removal will prevent collection of solvent vapor which could provide an ignition source, fire or explosion.

**LIMITATIONS OF USE**

For Professional Use Only. Not intended for Residential Use.

Apply only when air, product and surface temperatures are above 50°F (10°C) and surface temperature is at least 5°F (3°C) above the dew point. Curing is retarded below 60°F (15°C). Air and surface temperatures must remain 50°F (10°C) for at least 24 hours. Avoid painting late in the day when dew and condensation are likely to form or if rain is predicted.

**PACKAGING**

ADS510/ADS511	Quart (946 mL) 1-Gallon (3.78L) 5-Gallon (18.9 L)
ADS512	Quart (946 mL) 1-Gallon (3.78 L) 5-Gallon (18.9 L)

Not all products available in all sizes

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ADS510 6/2011  
(Supersedes 2/2011)