

Architectural Coatings

Corafon® Urethane Mastic DTM

**PRODUCT INFORMATION**

**Product Codes:** ADS650 A Component - Neutral Base  
 ADS651 A Component - White Base  
 ADS650B B Component - Curing Agent

**Product Type:** Acrylic Urethane

**Product Description:** Corafon Urethane Mastic DTM is a high solids, high build, two component acrylic urethane formulated for direct-to-metal applications. This product can be used in areas where VOC requirements are less than 250 g/L VOC and can help earn LEED credits.

**RECOMMENDED SUBSTRATES**

Ferrous Metal                      Steel  
 Galvanized Steel                  Weathered Galvanized Steel  
 PVDF Coated Metal

**TINTING AND BASE INFORMATION**

Refer to color formula book, computer color matching system, or automatic tinting equipment for color formulas and tinting instructions.

ADS651 A Component    White Base  
 ADS650 A Component    Neutral Base

**PRODUCT DATA**

**Color:** Neutral Base (ADS650)  
 White Base (ADS651)

**Gloss:** Gloss

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

**Volume Solids (mixed, unthinned)\*:** 65.2% ± 3.0%

**Weight Solids (mixed, unthinned)\*:** 74.3% ± 3.0%

**Weight per Gallon\*:** 11.3 lbs. (5.1 kg) ± 0.5 lbs.(227 g)  
 . (mixed, unthinned)

\*Values are calculated using ADS651 White. Values will vary with color.

**Flash Point:** ADS651 84°F (29°C)  
 ADS650B 460°F (238°C)

**CLEANUP:** ADS705, ADS706, ADS708, or ADS709 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**

<b>Feature</b>	<b>Benefit</b>
Excellent adhesion	Adheres to PVDF coated and ferrous metal substrates
Excellent chemical and abrasion resistance	Protects the substrate longer
High film build in one coat	Provides high performance protection
Superior color and gloss retention	Excellent long-term appearance
Flexible	Withstands bends with no cracking or peeling
Very good hardness	Durable coat providing excellent abrasion resistance
Can help earn LEED NC version 3.0 credits	Contributes to sustainable design

**TEST DATA**

<b>Property</b>	<b>Test Method</b>	<b>Results</b>
Gloss Retention	ASTM D523	2 Yrs FLA 80%
Color Retention	ASTM D2244	2 Yrs FLA DE <2.0
Abrasion Resistance	ASTM D968	Tabor Loss CS-17 120g
Chemical Resistance	AAMA 605.2	Excellent
Adhesion	ASTM D3359	5A
Impact Resistance	ASTM D2794	>160
Pencil Hardness	ASTM D3363	F
Flexibility	ASTM D4145	Conical Mandrel PASS
Salt Fog	ASTM B117	10, No 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.

### Ferrous Metal

Recommended surface preparation commercial blast per SSPC-SP 6. Minimum surface preparation SSPC-SP 2/SP 3 Hand Tool/Power Tool Clean. **Primer:** ADS570, Coraflo<sup>®</sup> ADS Zinc Rich Epoxy Primer, ADS573, Coraflo ADS Epoxy Intermediate Primer

### Galvanized Steel

Abrasive blast per SSPC-SP 7/NACE 4 "brush off blasting" for removal of passivator that may be present. Obtain a surface profile of 1.0 - 2.0 mils. Ensure passivator not present. **Primer:** ADS573, Coraflo ADS Epoxy Intermediate Primer

### PVDF Coated Metal (after use of ADS510 as a primer)

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. **Primer:** ADS510, Coraflo ADS Epoxy PVDF Bonding Primer

### Steel

Recommended surface preparation commercial blast per SSPC-SP 6. Minimum surface preparation SSPC-SP 2/SP 3 Hand Tool/Power Tool Clean. **Primer:** ADS573, Coraflo ADS Epoxy Intermediate Primer

### Weathered Galvanized Steel

Recommended surface preparation commercial blast per SSPC-SP 6. Minimum surface preparation SSPC-SP 2/SP 3 Hand Tool/Power Tool Clean. **Primer:** ADS573, Coraflo ADS Epoxy Intermediate Primer

## MIXING AND THINNING INFORMATION

**Mix Ratio by Volume:** 5:1 (ADS651 or ADS650: ADS650B)

**Mixing Instructions:** Mix ADS651 or ADS650 thoroughly. Add ADS650B to ADS651 or ADS650 Component and mix well. Thoroughly drain curing agent from its container to insure proper mix ratio.

**Induction Time:** Not applicable

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

**Thinning :** Thinning not normally required. If needed, thin up to 5% by volume with ADS705, ADS706, ADS708 or ADS709.

**Accelerator:** Yes – Use 97-722. If 97-722 accelerator is used, add it to "A" Component and mix well prior to the addition of Component "B". Add up to 6 fluid ounces of 97-722 per mixed gallon.

## APPLICATION

**Coverage:** 209 to 349 sq. ft./gal.\* (19.4 to 32.5 sq. m/3.78 L)

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

Wet Film Build: 4.6 to 7.7 mils (mixed)\*

Dry Film Build: 3 to 5 mils\*

\*Values are calculated using ADS651 White. ADS650 Neutral will require an additional 0.3 wet mils to achieve 3 to 5 mils dry.

### 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.

**APPLICATION (continued)**

**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. 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.

**Brush:** Use a high quality natural bristle brush

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

**DRYING SCHEDULE**

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

	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)
To Touch:	<1 Hour	<1 Hour	1 Hour	1 Hour	2 Hour	4 hours
Through:	<1 Hour	<1 Hour	4 Hours	8 Hours	8.5 Hours	>24 hours
To Recoat:	<1 Hour	<1 Hour	4 Hours	8 Hours	8.5 Hours	>24 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.

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

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**

ADS651/650 1-Gallon (3.78 L)  
5-Gallon (18.9 L)

ADS650B 1-Gallon (3.78 L)  
5-Gallon (18.9 L)

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