



# Corlar® 821CR™ Epoxy Primer



## GENERAL

### DESCRIPTION

A two-component, chromate containing, non-sanding primer designed to deliver excellent adhesion and corrosion resistance.

### SUGGESTED USES

For use with:

Properly cleaned and sanded cured finishes and fiberglass gelcoat substrates

Metalok Adhesion Promoter 230S™

Metalok Pretreatment Coatings 250S™ and 235S™

Properly cleaned and chemical treated metal substrates

### COMPATIBLE COATINGS

Compatible with Axalta commercial transportation topcoats.

### NOT RECOMMENDED FOR

Immersion service

### DRY FILM CHARACTERISTICS

Chemical resistance	VERY GOOD
Humidity resistance over treated substrate	EXCELLENT
Weatherability with appropriate topcoat	EXCELLENT
Adhesion	EXCELLENT
Holdout	GOOD to VERY GOOD
Solvent resistance	EXCELLENT

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.



## MIXING

### MIX RATIO

Thoroughly mix prior to activation. The use of a Cyclone® shaker is recommended. Combine components and mix thoroughly. Filter material prior to spray application.

Component	Volume
Corlar 821CR Primer	2
Corlar 82xS Activator	1

Corlar 822S™ Epoxy Activator  
Corlar 823S™ Epoxy Activator- Slow

Note: 822S and 823S activators may be blended with each other to reach dry times between them individually. The resulting blend remains at the 2 parts primer to 1 part activator mixing ratio.

### VISCOSITY

18-20 seconds in a Zahn #2 cup.

### INDUCTION TIME

No induction is required.

### POT LIFE - 70°F (21°C)

12 hours



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## APPLICATION

### APPLICATION CONDITIONS

Do not apply if material, substrate or ambient temperature is less than 50°F (10°C) or above 110°F (43°C). The substrate must be at least 5°F (3°C) above the dew point. Relative humidity should be below 90%.

### APPLICATION EQUIPMENT

Pressure Pot (recommended)  
Gravity Feed Gun  
Siphon Gun

### APPLICATION

- 821CR builds at approximately 0.8-1.0 mils DFT per medium-wet pass.
- Pressure pot application is recommended to provide the best atomization and delivery.
- Set fluid delivery to 10-12 ounces per minute.
- Film build dry should be 0.8-1.0 mils as a non-sanding primer-sealer over aluminum, galvanized, or stainless steel.
- Up to 2 coats can be applied (2.0-2.2 mils) as non-sanding primer-sealer over steel.
- Two coats of primer will slow down the dry time to topcoat to 40-60 minutes.

### APPLICATION SOLVENTS

Ready-to-spray below 4.5 lbs./gal VOC upon activation. Further reduction may result in greater than 4.5 lbs./gal VOC.

### CLEANUP SOLVENTS

130™ Acetone  
105™ Lacquer Thinner  
107™ Low VOC Gun Cleaner  
108™ Low HAPS Cleaning Solvent

### ADDITIONAL COMMENTS

821CR is a non-sanding primer-sealer. It is not designed for extensive sanding. Light overall or nib sanding can be done after air drying for 2-4 hours or force drying at 30 minutes at 140°F (60°C).



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## DRY TIMES

### AIR DRY

77°F (25°C) & 50% RH at recommended film thickness

Dry to touch:	30 minutes
Tack free:	30 minutes
Print free:	1 hour
Dry to topcoat:	30-40 minutes (1 coat) 50-60 minutes (2 coat)

Note: Times listed are for 1-coat applications. Times are longer for 2-coat applications. Product must be sanded if allowed to dry for more than 24 hours.

### FORCE DRY

30 minutes at 140°F (60°C)

### RECOAT

- When recoating with itself, scuff sanding is required if the primer has been allowed to dry more than 24 hours, or if it has been force dried.
- For optimum appearance sand with 320 grit or finer until smooth.



## PHYSICAL PROPERTIES

Maximum Service Temperature	200°F (92°C) in continuous service 200°F (92°C) in intermittent heat
Weight Per Gallon (component only)	12.1 lbs.
Weight Per Liter (component only)	1450 grams
Suggested Dry Film Thickness	0.8 – 1.0 mils in 1 coat, 2.0 – 2.2 in 2 coats
Gloss	Satin
Color	Olive green
Flash Point (Closed Cup)	See MSDS/SDS
Shelf Life	12 months minimum

### RTS mixed 2:1 with:

	<b>822S</b>	<b>823S</b>
Gallon Weight pounds per gallon - Average	10.41	10.41
Gallon Weight grams per liter - Average	1248	1248
VOC AP pounds per gallon - Maximum	4.1	4.1
VOC AP grams per liter - Maximum	492	492
VOC LE pounds. per gallon - Maximum	4.5	4.5
VOC LE grams per liter - Maximum	539	539
Weight Solids - Average	55.0%	55.0%
Volume Solids - Average	33.0%	33.0%
Weight Volatiles - Average	45.0%	45.0%
Weight Water - Average	0.0%	0.0%
Volume Water - Average	0.0%	0.0%
Weight Exempt Solvents - Average	6.0%	6.0%
Volume Exempt Solvents - Average	9.0%	9.0%
Theoretical Coverage per RTS Gallon at 1 mil DFT	536 ft <sup>2</sup> (49.8 m <sup>2</sup> )	536 ft <sup>2</sup> (49.8 m <sup>2</sup> )

## VOC REGULATED AREAS

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

## SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS/SDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

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In the United States:  
**1.855.6.AXALTA**  
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In Canada:  
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**axalta.ca**

