



Corlar[®] 934S[™] Epoxy Primer



GENERAL

DESCRIPTION

A two-component, epoxy primer that delivers excellent appearance and excellent corrosion protection.

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 all Axalta Transportation topcoat systems.

NOT RECOMMENDED FOR

Immersion service or stainless steel

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

COMPONENT

- Corlar 934S[™] Primer
- Corlar 946S[™] Activator Fast
- Corlar 947S[™] Activator Slow
- Corlar 948S[™] Activator Extra Slow

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 934S Primer	5
Corlar 946S / 947S / 948S Activator	1

INITIAL APPLICATION VISCOSITY

12-16 seconds in a Zahn #3

INDUCTION TIME

No induction is required



POT LIFE - 70°F (21°C)
4 - 6 hours



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

Refer to spray equipment documentation for setting recommendations.

Pressure Pot (recommended)
Gravity Feed
Siphon Gun
Airless Spray
Air Assisted Airless

APPLICATION

- Pressure pot application is recommended to provide the best atomization and delivery. Fluid delivery is recommended at 10-12 fluid oz/min.
- Apply using a cross-coat technique, top-to-bottom, and then side-to-side. Each coat should be medium-wet with no flash between coats.
- Paint heaters can help provide a smoother appearance by controlling the temperature and viscosity of the product.

APPLICATION SOLVENTS

Ready-to-spray below 3.5 lbs. /gal VOC upon activation. Further reduction may result in greater than 3.5 lbs. /gal VOC.

CLEANUP SOLVENTS

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

ADDITIONAL COMMENTS

934S is a non-sanding primer. It is not designed for extensive sanding. Light overall or nib sanding can be done after air drying for 4-6 hours or force drying at 30 minutes at 180°F (82°C).



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
To topcoat mixed with 946S:	30 minutes*
To topcoat mixed with 947S:	45 minutes*
To topcoat mixed with 948S:	60 minutes*

* If more than 2 mil DFT (~4 mil wet) is applied, additional flash time is required. Product must be sanded if allowed to dry for more than 72 hours.

FORCE DRY

30 min at 140-180°F (60-82°C)

RECOAT



When recoating with itself, scuff sanding is required if the primer has been allowed to dry more than 72 hours. For optimum appearance sand with 320 grit or finer until smooth.

Maximum Service Temperature:	200°F (92°C) in continuous service 300°F (148°C) in intermittent heat
Weight Per Gallon (component only)	11.81 lbs.
Weight Per Liter (component only)	1415 grams
Suggested Dry Film Thickness	1.2 – 1.8 mils
Gloss	Satin
Color	Gray
Flash Point (Closed Cup)	See MSDS/SDS
Shelf Life	12 months minimum

	946S
	947S
	948S
RTS mixed 5:1 with:	
Gallon Weight pounds per gallon – Average	11.14
Gallon Weight grams per liter – Average	1335
VOC AP pounds per gallon – Maximum	2.6
VOC AP grams per liter – Maximum	314
VOC LE pounds. per gallon - Maximum	3.1
VOC LE grams per liter – Maximum	366
Weight Solids – Average	68.1%
Volume Solids – Average	48.7%
Weight Volatiles – Average	31.9%
Weight Water – Average	0.0%
Volume Water – Average	0.0%
Weight Exempt Solvents – Average	8.8%
Volume Exempt Solvents – Average	14.7%
Theoretical Coverage per RTS Gallon at 1 mil DFT	781 ft ² (72.6 m ²)

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
axalta.us

In Canada:
1.800.668.6945
axalta.ca

