Product Data Sheet

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

Coraflon™ ADS
High Build Epoxy Primer/Intermediate
ADS538/ADS539 White

Product Information

Product Code:	ADS538 White Component A ADS539 Curing Agent Component B
Product:	Polyamide Epoxy
Suggested Use:	Coraflon ADS High Build Epoxy Primer/ Intermediate is recommended for use on properly prepared substrates to be topcoated with Coraflon ADS or Megaflon™ MS.

Product Description

Color:	White
Gloss 60°:	Flat
VOC:	302 g/l (2.52 lbs/gal)
Method:	Calculated (mixed)
Weight/Gallon:	13.6 +/- 0.5 lbs./gal. (mixed)
In Service Heat Limitations:	250°F (121°C) maximum dry heat
Flash Point:	ADS538 Component A 78°F (26°C) ADS539 Component B 123°F (51°C)
Package:	ADS538 Component A is available in short filled gallon and five gallon containers. ADS539 Component B is available in short filled quart and full filled gallon containers.
Percent Solids by Volume:	66.2% +/- 3.0% (mixed)
Percent Solids by Weight:	81.5% +/- 3.0% (mixed)

Application Data

Substrate:	Dimensionally stable
Substrate Preparation:	Preparation varies with the substrate to be coated. Consult Technical Service for specific recommendation.
Application Method:	Air Spray: DeVilbiss MBC-510 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” (0.38 mm) to 0.019” (0.48 mm) orifice. Refer to Application Guide APG-83 for additional information.
Parts Base by Volume:	4 parts ADS538 Component A
Parts Catalyst by Volume:	1 part ADS539 Component B
Thinner Code & Percent:	Thin up to 10% by volume with ADS701 Thinner as needed for application.
Digestion Time:	45 minutes
Pot Life:	8 hours at 77°F (25°C) The addition of 6 fluid ounces of 97-723 Epoxy Accelerator per mixed gallon will result in pot life of 2.5 hours at 77°F (25°C).
Percent Solids by Volume at Application:	60.2 +/- 3.0% (mixed and thinned 10%)
Wet Film Per Coat (mils):	4.2-10.0 (mixed and thinned 10%)
Dry Film Per Coat (mils):	2.5-6.0

May, 2003

Product Data Sheet

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

Coraflon™ ADS

High Build Epoxy Primer/Intermediate

ADS538/ADS539 White

Coverage Sq. Ft./Gal. @ 1 mil: 1062

Clean Up Solvent: ADS701 or ADS702

Mixing Instructions: Under mechanical agitation, mix ADS538 Component A thoroughly. Add ADS539 Component B and mix until uniform. Allow to digest for 45 minutes before use. When adding 97-723 Epoxy Accelerator, add Component B to Component A and mix well, then add 97-723 Epoxy Accelerator under agitation.

Drying Schedule: Per ASTM D5895, air dry and 50% relative humidity.

	77°F (25°C)		40°F (4.4°C)	
	Without 97-723 Accelerator	With 97-723 Accelerator	Without 97-723 Accelerator	With 97-723 Accelerator
Dry to Touch:	2.5 hours	1 hour	7.5 hours	4 hours
Dry Through:	6 hours	1.75 hours	26 hours	6.5 hours
Dry to Recoat:	24 hours	When dry through	Not recommended	When dry through

Additional Information: Apply only when air, product and surface temperatures are above 40°F (4.4°C) and surface temperature is at least 5°F (3°C) above the dew point. Curing is retarded below 60°F (15.5°C) without the addition of accelerator. Add up to 6 fluid ounces 97-723 Epoxy Accelerator per mixed gallon of ADS538/ADS539 when applying below 50°F (10°C). DO NOT EXCEED 6 FLUID OUNCES OF 97-723 PER MIXED GALLON.

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

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.

Store materials at temperatures between 50°F (10°C) and 95°F (35°C).

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.

Read all label and Material Safety Data Sheet (MSDS) information prior to use. MSDS are available by calling 1-800-238-8596.

May, 2003