



# Corlar® 13550S™ Corrosion-Resistant Epoxy Primer



## GENERAL

### DESCRIPTION

A strontium-chromate based corrosion-resistant epoxy primer designed to provide excellent adhesion and corrosion resistance for aerospace applications. It is formulated for direct-topcoat applications and to deliver excellent finished appearance due to minimal primer texture. This high-solids primer is also formulated to provide productive dry times and has a ready-to-spray VOC of less than 2.8 lbs./gal.

Corlar 13550S is a MIL-PRF-23377J; Type I, Class C2 approved primer.

### RECOMMENDED USES

Corlar 13550S is recommended for use as a primer over properly treated substrates including aluminum, aluminum alloys, and steel. It is compatible with most epoxy and urethane surfacers and polyurethane topcoats. Corlar 13550S is recommended for use with:

Pre-Treatment	13206S™, Alodine® 600 or 1200, 13238S™
Topcoats	Imron® AF3500™ / AF400™
Basecoat/Clearcoat	Imron AF700™ / AF740™
Surfacers	Corlar 13580S™, 13520S™

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



## MIXING

### COMPONENTS

Corlar 13550S Corrosion-Resistant Epoxy Primer  
Corlar 13150S™ Epoxy Activator  
13756S™ VOC-Exempt Reducer

### MIX RATIO

Thoroughly mix Corlar 13550S prior to activation. Filter activated material prior to spray application.

Components	Parts by Volume
Corlar 13550S Epoxy Primer	3
Corlar 13150S Epoxy Activator	1
13756S VOC-Exempt Reducer	2

### VISCOSITY

17-21 seconds in a Zahn #2 cup.

Listed ranges were established using GARDCO EZ Zahn (AS) Cups, measurements using other Zahn type cups may provide different results.

### INDUCTION TIME

30 minutes

### POT LIFE

10 hours at 70°F (21°C)

### ADDITIVES

#### Anti-crater additive

- Up to 1 oz. 13813S per RTS gallon
- Do not use FEE



## APPLICATION

### ENVIRONMENTAL CONDITIONS

Substrate and ambient temperature must be between 50°F (10°C) and 110°F (43°C). The substrate must be at least 5°F (3°C) above the dew point. Relative humidity should be below 90%. Heating activated material above 110°F (43°C) may cause gelation.

### SUBSTRATES AND SURFACE PREPARATION

Substrate must be properly prepared for application. Aluminum surfaces must be clean and water-break free, followed by conversion coating or pretreatment. For best results, aluminum should be converted following the recommended 13206S, Alodine 600 or Alodine 1200 process (see product data sheets for pre-treatments). If conversion cannot be used due to facility constraints, pre-treatment may be achieved with 13238S Epoxy Pre-Treatment.

### GUN SETUP

Corlar 13550S can be applied with conventional, HVLP, and electrostatic spray equipment using pressure or gravity fluid delivery.

#### Conventional Fluid Tip

Pressure Pot	1.2 mm-1.5 mm (.047"-.059")
Gravity Feed	1.3 mm-1.6 mm (.051"-.063")

#### HVLP

Pressure Pot	1.0 mm-1.4 mm (.039"-.055")
Gravity Feed	1.2 mm-1.5 mm (.047"-.059")

#### FLUID DELIVERY

Conventional	8-10 oz./minute
HVLP	8-10 oz./minute

#### AIR PRESSURE

Conventional	50-60 psi atomizing air
HVLP	25-30 psi atomizing air

### APPLICATION

Apply using a single medium-wet coat to achieve 0.5-1.0 mils dry film thickness (1.5-3.0 mils wet).

### CLEANUP SOLVENTS

Axalta 107™ Low VOC Gun & Equipment Cleaner  
Axalta 105™ Gun & Equipment Cleaner



## DRY TIMES

### AIR DRY AT 70°F (21°C)

Dry to Touch	30 minutes
Dry to Tape	2 hours
Dry to Topcoat	2 hours

### FORCE DRY AT 130°F (54°C)

Flash not required before force dry	
Dry to Touch	15 minutes
Dry to Tape	1 hour
Dry to Topcoat	1 hour

### RECOAT

Recoat window is 48 hours for Corlar 13550S which has been either air dried or force dried for up to 1 hour at 130°F (54°C).



## PHYSICAL PROPERTIES

VOC	Less Exempts (LE)	As Packaged (AP)
Corlar 13550S	2.8 lbs./gal	2.5 lbs./gal
RTS Corlar 13550S	2.8 lbs./gal	1.5 lbs./gal

### FACTORY-PACKAGED PRIMER

Color	Green
Closed Cup Flash Point	20°F - 73°F
Shelf Life	3 years (Unopened at 50°-110°F)

### READY-TO-SPRAY

Theoretical Coverage	530 ft <sup>2</sup> /gal at 1 mil dry film thickness
Weight Solids	48%
Volume Solids	33%
Gallon Weight	11.2 lbs./gal

### DRY FILM

Gloss	Eggshell to Satin
Recommended Film Thickness	0.5-1.0 mils

### COATING PERFORMANCE

Corrosion Resistance	Excellent
Adhesion	Excellent
Chemical and Solvent Resistance	Very Good
Weatherability with Topcoat	Excellent
Topcoat Holdout	Excellent
Humidity Resistance	Excellent
Flexibility	Excellent

## 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 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.

Revised: January 2015

YOUR LOCAL WA STOCKIST

**PARK** T. 08 9444 9822  
UNIT 1/7 NEIL STREET, OSBORNE PARK, WA 6017  
WWW.PARKGROUP.COM.AU

In the United States:  
**1.855.6.AXALTA**  
axalta.us

In Canada:  
**1.800.668.6945**  
axalta.ca

