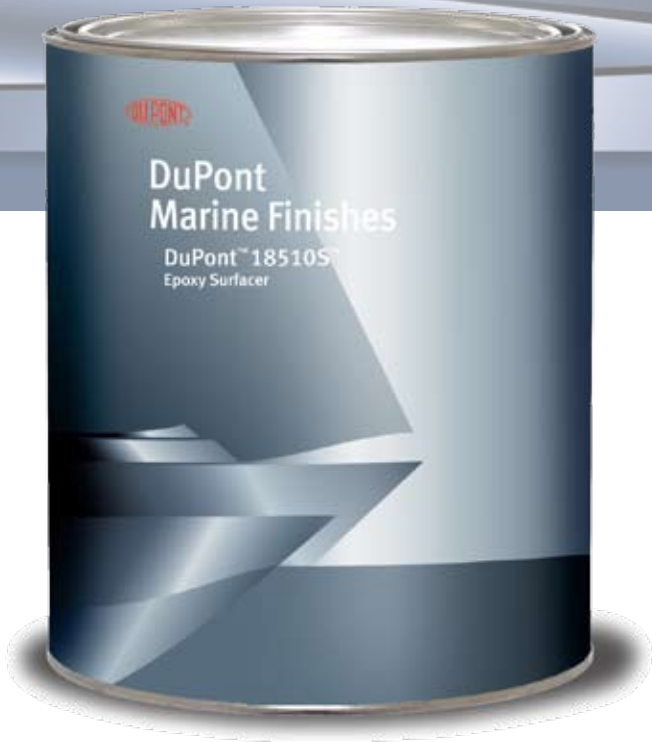


Corlar® 18510S™

EPOXY SURFACER



Corlar® 18510S™ Epoxy Surfacers

Corlar® 18510S™ Epoxy Surfacers is a sanding primer that provides a level, texture-free surface.

Corlar® 18510S™

- Sands easily
- Delivers fast dry times
- Has excellent topcoat holdout
- Provides excellent chemical and solvent resistance.

For temperatures below 70° F, DuPont™ 18810S™ Epoxy Cold Weather Accelerator can be used to speed dry time.

**Contact your local authorized
DuPont Marine Finishes distributor to
place your order.**

**To find a distributor in your area,
call 1-800-GET DUPONT or visit
www.performancecoatings.dupont.com**

Beautiful colors. Excellent results. Outstanding performance.



Marine Finishes

Corlar® 18510S™

EPOXY SURFACER

Highlights from our Technical Data Sheet

Description

Corlar® 18510S™ Epoxy Surfacers is a sanding primer that provides a level, texture-free surface for single or multi-stage topcoats. It has been formulated to sand easily while providing productive dry times and excellent topcoat holdout. This high-solids primer has a ready-to-spray VOC of less than 2.8 lbs/gal.

Components

Corlar® 18510S™ Epoxy Surfacers
Corlar® 18110S™ Epoxy Activator
DuPont™ 18710S™ VOC Exempt Reducer

Mix Ratio

Thoroughly mix Corlar® 18510S™ prior to activation. Filter activated material prior to spray application.

Three Component System Parts by Volume

Corlar® 18510S™ Epoxy Surfacers 4

Corlar® 18110S™ Epoxy Activator 1

DuPont™ 18710S™ VOC-Exempt Reducer 1

Viscosity will be 10 - 13 seconds in a Zahn #3 cup.

Additives/Accelerator:

For temperatures below 70°F, DuPont™ 18810S™ Epoxy Cold Weather Accelerator can be used to replace up to 50% of the 18710S™ VOC Exempt Reducer to speed dry time.

For example:

Component Parts by Volume

Corlar® 18510S™ 4

Corlar® 18110S™ 1

DuPont™ 18710S™ ½

DuPont™ 18810S™ ½

Use of DuPont™ 18810S™ will shorten pot life of Corlar® 18510S™ Epoxy Primer

Substrates and Surface Preparation

Substrate must be properly prepared for application including scuff sanding and cleaning. When applying over fairing or primer, follow cure and recoat window guidelines to ensure proper adhesion. Scuff sand as required.

Gun Setup

Corlar® 18510S™ Epoxy Surfacers can be applied with conventional, HVLP, and electrostatic spray equipment using pressure, siphon, or gravity fluid delivery.

Conventional Fluid Tip

Pressure Pot 1.2 mm – 1.6 mm (.047" - .063")

Siphon Feed 1.4 mm – 1.8 mm (.055" - .071")

Gravity Feed 1.4 mm – 1.8 mm (.055" - .071")

Call your authorized DuPont Marine Finishes distributor for full details. Log on to www.performancecoatings.dupont.com and use the distributor locator to find the jobber in your area.



The miracles of science™

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HVLP

Pressure Pot 1.2 mm – 1.6 mm (.047" - .063")

Siphon Feed 1.4 mm – 1.8 mm (.055" - .071")

Gravity Feed 1.4 mm – 1.8 mm (.055" - .071")

Fluid Delivery

Conventional 12 – 16 oz/min

HVLP 12 – 16 oz/min

Air Pressure

Conventional 50 – 60 psi atomizing air

HVLP 25 – 30 psi atomizing air

Application

Apply using a full-wet coat to achieve 2.5 - 4.0 mils wet film thickness.

Point-to-point flash time between coats should be at least 20 minutes.

Apply a second full-wet coat of 2.5 – 4.0 mils wet film thickness. Total film thickness should be 2.5 – 4.0 mils dry.

Dry Times

Air Dry at 70°F (21°C)

Dry to Touch 2 - 4 hours

Dry to Sand 8 - 12 hours

Recoat Prior to topcoat application, sand with 240-grit or higher using a dual action orbital sander. For optimal topcoat appearance, sand or finish sand with 320-grit or higher. Corlar® 18510S™ Epoxy Surfacers must be sanded prior to topcoat application for proper adhesion.

VOC

Ready-to-Spray Corlar® 18510S™
Epoxy Primer

Less Exempts (LE)

As Packaged (AP)

2.8 lbs/gal

2.1 lbs/gal

Ready-to-Spray

Theoretical Coverage 686.0 ft²/gal at 1 mil dry film thickness

Weight Solids 61.0%

Volume Solids 45.0%

Gallon Weight 11.3 lbs/gal

Coating Performance

Adhesion	Excellent
Chemical and Solvent Resistance	Excellent
Weatherability w/ Topcoat	Excellent
Topcoat Holdout	Excellent
Humidity Resistance	Excellent
Flexibility	Very Good

Safety and Handling

For industrial use only by professional, trained painters. Not for sale to 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.

Do not allow material or overspray to enter drains or waterways.

**Beautiful colors. Excellent results.
Outstanding performance.**