



Corlar[®] 921S[™] / 928S[™] / 929S[™] Primer-Sealer 3.5 VOC LE Option



GENERAL

DESCRIPTION

A two component, epoxy primer-sealer 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

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.

Use VS1, VS4, VS7 as packaged, or mix to create VS2, VS3, VS5, VS6 per below.

ValueShade [®]	Part	Ratio
VS1 (White)	928S	--
VS2	928S : 921S	2:1
VS3	928S : 921S	1:2
VS4 (Gray)	921S	--
VS5	921S : 929S	2:1
VS6	921S : 929S	1:2
VS7 (Dark Gray)	929S	--

Combine the components either by volume to create the desired ValueShade position per the above table, or refer to the ColorNet ValueShade Retrieval function for the scale gram weight mix method.



MIX RATIO (CONTINUED)

Component	Volume
3.5 VOC Ratio	
Corlar 92xS Primer	2
Corlar 822S or 823S Activator	1
Primer	
▪ Corlar 928S Primer – White - ValueShade 1	
▪ Corlar 921S Primer – Gray - ValueShade 4	
▪ Corlar 929S Primer – Dark Gray - ValueShade 7	
Activator	
– for 3.5 VOC mix ratio	
▪ Corlar 822S Medium Activator	
▪ Corlar 823S Slow Activator	

INDUCTION TIME

No induction is required.

POT LIFE - 70°F (21°C)

12 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

Pressure Pot (recommended)
Gravity Feed Gun
Siphon Gun

APPLICATION

- 921S/928S/929S 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.

APPLICATION SOLVENTS

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

CLEANUP SOLVENTS

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

ADDITIONAL COMMENTS

921S/928S/929S 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).



DRY TIMES

AIR DRY

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

Dry to touch:	30 min
Tack free:	30 min
Print free:	1 hr
Dry to topcoat:	30-40 min (1 coat) 50-60 min (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 48 hours.

FORCE DRY

30 min at 140°F (60°C)

RECOAT

When recoating with itself, scuff sanding is required if the primer has been allowed to dry more than 48 hours. For optimum appearance sand with 320 grit or finer until smooth.

Note: Product must be sanded if force dried or allowed to dry for more than 48 hours.



PHYSICAL PROPERTIES

Maximum Service Temperature	200°F (92°C) in continuous service 200°F (92°C) in intermittent heat
Weight Per Gallon (component only)	13.11 – 13.20 lbs.
Weight Per Liter (component only)	1571-1582 grams
Suggested Dry Film Thickness	0.8 – 1.0 mils in 1 coat, 1.6 – 2.0 in 2 coats
Gloss	Satin
Color	White, Gray, Dark Gray
Flash Point (Closed Cup)	See MSDS/SDS
Shelf Life	12 months minimum

3.5 VOC LE mix ratio

RTS mixed 2:1 with 822S / 823S:

	928S	921S	929S
Gallon Weight pounds per gallon - Average	11.17	11.15	11.08
Gallon Weight grams per liter - Average	1339	1336	1328
VOC AP pounds per gallon - Maximum	2.3	2.3	2.3
VOC AP grams per liter - Maximum	271	277	275
VOC LE pounds. per gallon - Maximum	3.4	3.3	3.4
VOC LE grams per liter - Maximum	406	401	403
Weight Solids - Average	51.7%	52.3%	51.6%
Volume Solids - Average	33.6%	35.6%	34.8%
Weight Volatiles - Average	48.4%	47.4%	48.7%
Weight Water - Average	0.0%	0.0%	0.0%
Volume Water - Average	0.0%	0.0%	0.0%
Weight Exempt Solvents - Average	29.3%	27.8%	27.7%
Volume Exempt Solvents - Average	35.7%	32.9%	31.6%
Theoretical Coverage per RTS Gallon at 1 mil DFT	539 ft ² (50.0 m ²)	571 ft ² (53.0 m ²)	558 ft ² (51.8 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

