



IMA - 418
CORO-BOND™
Polyamide Epoxy Primer
1201 Line
Rev. 11/09

Coronado Industrial Coatings - 308 Old County Road · Edgewater, Florida 32132 · 800-883-4193 · FAX 800-394-9022

CORO-BOND™ POLYAMIDE EPOXY PRIMER 1201 Line

Type	Sheen	Theoretical Spread Rate	Recommended Application	Thinner	Clean Up
Polyamide Cured Epoxy	Low	450 - 550 Sq. Ft. Per Gallon*	Airless or Air Spray, Brush or Roll	COROSOLVE™ 45-187	COROSOLVE™ 45-187
Touch Dry Time:		Min Recoat:		Max Recoat:	
3 Hr. @55°F		9 Hrs. @55°F		3 Months @55°F	
1 Hr. @77°F		3 Hrs. @77°F		28 Days @77°F	
30 Min. @100°F		1.5 Hrs. @100°F		14 Days @100°F	

PRODUCT NAME: CORO-BOND™ Polyamide Epoxy Primer 1201 Line	<p>CORO-BOND™ Polyamide Epoxy Primer is designed for professional use in the industrial and commercial applications. This two-component primer is excellent for use on ferrous and non-ferrous metals, and when properly topcoated, exhibit excellent chemical and moisture resistance. Additionally, this primer is formulated with corrosion inhibiting pigments, for long-term rust prevention, and is excellent when used in a system with epoxy intermediates and finishes for immersion service.</p> <p>This is a two-component product that requires 4 parts of the proper "A" or Base Component mixed with 1 part of the proper "B" or Converter Component. Do not mix partial kits.</p>
WHERE TO USE:	<p>Properly prepared Steel, Iron, Galvanized, Aluminum, and other non-ferrous metals</p> <p>CORO-BOND™ Polyamide Epoxy Primer is a multi-use epoxy primer for metal in the industrial maintenance market, food and beverage processing market, general metal finishing and fabrication market, chemical processing market, as well as architectural/structural finishing and refinishing, transportation infrastructure finishing or other areas requiring a two-component, corrosion resistant primer for metal.</p>
SURFACE PREPARATION:	<p>The performance of this product is directly dependent upon the degree of surface preparation employed. All dirt, oils and accumulated salts must be removed prior to employing specific surface preparation methods. Pressure washing with an oil and grease emulsifier (2500 psi) followed by solvent washing in accordance with SSPC-SP1 will best accomplish this task.</p> <p>STEEL: Non-Immersion requires Hand Tool Cleaning (SSPC-SP2) or Power Tool Cleaning (SSPC-SP3) or for best results, Commercial Blast Cleaning (SSPC-SP6). Immersion service requires Near White Metal Blast (SSPC-SP10).</p> <p>NON-FERROUS METALS: Solvent Wash (SSPC-SP1) or pressure wash with an oil and grease emulsifier as indicated above. Rusted areas on galvanized should be removed by Hand Tool Cleaning (SSPC-SP2) or Power Tool Cleaning (SSPC-SP3).</p> <p>Please consult Technical Service for other surface preparations or for use in severe environments.</p>
APPLICATION:	<p>Mix each individual component thoroughly prior to inter-mixing the two. "A" and "B" must be combined together and thoroughly mixed and then allowed to induct for a period of 30 minutes (at 77°F). The use of a drill mixer at low speed will best accomplish this task.</p> <p>Thinning is not normally necessary, however small amounts of COROSOLVE™ Epoxy Thinner 45-187 ONLY may be added if needed. SEE THINNING INSTRUCTIONS ON PAGE THREE.</p> <p>Airless Spray (Preferred Method): Tip range between 13 and 19 thousandths. Total fluid output pressure at tip should not be less than 2100 psi.</p> <p>Air Spray (Pressure Pot): DeVilbiss MBC or JGA gun, with 704 or 765 air cap and Fluid Tip E.</p> <p>NOTE: Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with recommended thinner.</p> <p>Brush: Natural Bristle only.</p> <p>Roller: Industrial Cover with Phenolic core.</p>
*NOTE ON SPREAD RATE:	<p>Actual spread rate will vary based upon numerous factors, including texture of the substrate, application method, waste, surface porosity and thinning. The Theoretical Spread Rate listed on this document has not taken into account these factors and is only based upon the volume solids of this product and the recommended wet film thickness when applied to a smooth substrate.</p>

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STORAGE:	24 months at 77°F in original unopened container. Prolonged storage at higher temperatures can shorten the shelf life. Store in dry, shaded area, away from heat and ignition sources. Protect from frost.
TINTABILITY:	CORO-BOND™ Polyamide Epoxy Primer is available in Red Oxide (-147), and Gray (-211). Ready mixed colors may be further tinted with up to 4 ounces of Prism Industrial Colorants ONLY. Custom colors are also available in minimum batch quantities.
RESIN TYPE:	Polyamide cured epoxy
VOLUME SOLIDS:	49.5 ± 1.0%
WEIGHT PER GALLON:	11.0 Lbs.
MIX RATIO:	4:1 DO NOT MIX PARTIAL KITS. DO NOT VARY THIS RATIO.
INDUCTION TIME:	1.5 hrs. @ 50°F / 30 mins. @ 77°F / 15 mins. @ 90°F
POT LIFE:	12 hrs. @ 50°F / 8 hrs. @ 77°F / 4 hrs. @ 90°F
FLASH POINT:	80°F. (TT-P-141, Method 4293)
SPECULAR GLOSS:	10 - 20 units @ 60°
WET FILM THICKNESS:	2.9 to 3.6 mils
DRY FILM THICKNESS:	1.4 to 1.8 mils
VOC/VOS STATEMENT:	This mixed product contains a maximum of 443 grams VOC/VOS per liter of coating. (3.7 lbs./gal)
OTC CATEGORY:	This product is not compliant under the Ozone Transport Commission regulations except for Shop Applications Only.
CAUTIONS: (This information is based upon a mixed kit of 1201-147 Red. *Other colors may vary.)	<p style="text-align: center;">DANGER! Cancer Hazard!</p> <p style="text-align: center;">FLAMMABLE LIQUID AND VAPOR. HARMFUL IF INHALED. HARMFUL OR FATAL IF SWALLOWED. Do not get in eyes, on skin or clothing. Causes eye and skin burns. May cause allergic skin reaction. and may be harmful if absorbed through skin. Causes eye, nose, throat and skin irritation. Causes lung irritation and may cause allergic respiratory reaction. OVEREXPOSURE MAY CAUSE KIDNEY DAMAGE. Contains Crystalline Silica, which can cause cancer. Risk of cancer depends on duration and level of exposure.</p> <p>NOTICE: Reports have associated repeated and prolonged occupational overexposure to solvent with permanent brain and nervous system damage. Intentional misuse by deliberately concentrating and inhaling the contents may be harmful or fatal.</p> <p>Use only with adequate ventilation. Prevent build-up of vapors by opening all windows and doors to achieve cross-ventilation</p> <p>Do not breathe dust, vapors or spray mist. Ensure fresh air entry during application and drying. If you experience eye watering, headache or dizziness or if air monitoring demonstrates vapor/mist levels are above applicable limits, wear an appropriate, properly fitted respirator (NIOSH approved) during and after application. Follow manufacturer's directions for respirator use. Avoid contact with eyes, skin and clothing. Wash thoroughly after handling. If you experience difficulty in breathing, leave the area to obtain fresh air. If continued difficulty is experienced, get medical attention immediately. Keep away from heat, sparks and flame. Vapors can cause flash fire. Do not smoke. Extinguish all flames and pilot lights, and turn off stoves, heaters, electric motors and other sources of ignition during use and until all vapors are gone. Close container after each use.</p> <p>First Aid: In case of contact, immediately flush eyes or skin with plenty of water for at least 15 minutes. Remove contaminated clothing and shoes. Get medical attention immediately. Wash clothing before reuse. Thoroughly clean contaminated shoes. If inhaled move to fresh air. If not breathing, give artificial respiration. If breathing is difficult, give oxygen. Get medical attention immediately. If spilled, contain spilled material and remove with inert absorbent. Dispose of contaminated absorbent, container and unused contents in accordance with local, state and federal regulations.</p> <p>DANGER – Rags, steel wool or waste soaked with this product may spontaneously catch fire if improperly discarded. Immediately after use, place rags, steel wool or waste in a sealed, water-filled metal container.</p> <p>WARNING: This product contains chemicals known to the state of California to cause cancer, birth defects or other reproductive harm.</p> <p style="text-align: center;">Obtain and read the MSDS prior to using this product.</p> <p style="text-align: center;">KEEP OUT OF REACH OF CHILDREN</p> <p style="text-align: center;">FOR INDUSTRIAL USE ONLY</p>

TEST DATA

Salt Spray (ASTM B117) 1 coat with 2 coats 101 Line (1000 Hours)	Face Corrosion-None Face Blistering-None Rating-10, Rust-0.00%
Humidity (ASTM D4585) (Same system as above 1000 Hours)	Face Corrosion-None Face Blistering-None Rating-10, Rust-0.00%
Steam Resistant	Yes
Dry Heat Resistance	300°F
Wet Heat Resistance	150°F
Flexibility (ASTM D1737)	Pass 3/16" Mandrel
Adhesion (ASTM D3359)	Pass 5B
Sag (ASTM D4400)	8 mils +

**CHEMICAL RESISTANCE GUIDE
(NON-IMMERSION)**

Fresh Water	See specific finish coat data sheets for resistance information.
Salt Water	
Acids	
Alkalis	
Solvents	
Fuel	
Acidic Salt Solutions	
Alkaline Salt Solutions	
Neutral Salt Solutions	

QUALIFICATIONS

Meets performance requirements of MIL-P-53022.
Meets performance requirements of MIL-P-23377.
Meets SSPC Paint 22 (Primer)
Meets FDA qualifications for direct dry food contact.
Meets USDA qualifications for incidental food contact.

**SYSTEMS RECOMMENDATIONS
COMPATIBLE PRIMERS & INTERMEDIATES**

INTERMEDIATES: 111-111, 113 Line, 3821-111
Finishes: 101 Line, 145 Line, 827 Line, 837 Line, 847 Line, 848 Line 3823 Line
For primers / intermediates other than listed above, or for usage in severe environmental conditions, please consult with Coronado Industrial Coatings technical service.

WARRANTY

Coronado Paint Company warrants its products to be free from defects in materials and workmanship. Coronado Paint Company's sole obligation and the purchaser's exclusive remedy shall be limited, at Coronado Paint Company's option, to either replacement of nonconforming products or credit to the purchaser's account in an amount not greater than the original purchase price of the nonconforming products. Any claim under this warranty must be made by the purchaser, in writing to Coronado Paint Company, within ten (10) days of the purchaser's discovery of the claimed defect, but not later than the expiration of the applicable shelf life, or one year from the original delivery date, whichever is earlier. Purchaser's failure to notify Coronado Paint Company of any nonconformance as required shall bar the purchaser from recovery under this warranty.

Coronado Paint Company makes no other warranties, expressed or implied, such as merchantability or fitness for a particular purpose concerning its products. In no event shall Coronado Paint Company be liable for consequential or incidental damages.

Any recommendation or suggestion relating to the usage of products made by Coronado Paint Company, whether in the form of literature, data, or in response to specific inquiry, or otherwise is based upon information believed to be reliable; however the products and information are intended for use by skilled and knowledgeable purchasers, and is therefore for the purchaser to satisfy itself of the suitability of the products for its own specific use, and it shall be deemed that the purchaser has done so, at the sole discretion and risk. Variation in application conditions, ambient conditions or extrapolation of information may cause unsatisfactory results.

LIMITATION OF LIABILITY

Coronado Paint Company's liability on any claim, including claims based upon negligence, or strict liability for loss, or damage arising out of, connected with, or resulting from the use of products, shall in no case exceed the purchase price of the products directly giving rise to the claim. In no event shall Coronado Paint Company be liable for consequential or incidental damages.

THINNING RECOMMENDATIONS:

Thinning is not normally required. Do not thin more than local regulations allow.

DO NOT USE THINNERS OTHER THAN COROSOLVE™ EPOXY THINNER 45-187.

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NOTES: