

Cor Spec Primer 135

Technical Data Sheet: 153-82
P1352

- 1. Introduction** ALEXSEAL Cor Spec Primer 135 is a chromate containing, two component epoxy primer for use on metal substrates. This product is highly resistant to corrosion and chemicals.
- 2. Range of application** ALEXSEAL Cor Spec Primer 135 is designed to prime and seal old and new, properly prepared, metal surfaces prior to the application of ALEXSEAL Topcoats or ALEXSEAL Finish and Surfacing Primers. This product is ideal for masts, parts and metal substrates. It may be top coated directly or primed depending on the application requirements. Cor Spec Primer 135 may be used above and below the waterline.
- 3. Color** Colors of mixture: Yellow Green
- 4. Coverage** Volume Solids catalyzed without reduction: 30 %
Coverage for ALEXSEAL Cor Spec Primer 135 when applying 1 coat or pass in the same application period.
Note: Coverage rates are figured for base and converter. Reducer is added as percent of total quantity of base & converter.

	m ² / liter	m ² / gal	sq. ft. / gal	Rec. DFT in μm (mils)
Theoretical	22	83	893	25 (1)
Practical				
Conventional Air Spray Equipment	7	27	290	25 (1)
HVLP Air Spray Equipment	8	31	333	25 (1)
Brush / Roller and Airless Spray Equipment	22	83	893	25 (1)

- 5. Substrate pre-treatment** The substrate must be clean, dry and free from dust, grease, oil and other contamination. ALEXSEAL Cor Spec Primer 135 may be applied directly to the properly cleaned and prepared Aluminum or Steel substrate.
To achieve optimum adhesion and performance:
- Steel** should be prepared by sandblasting to a minimum of near white metal, Sa2.5 (SSPC – SP10 - 85) or ground 36 to 60 grit to a 50 - 100 micron (2 - 4 mils) profile.
Note: White metal Sa 3 (SSPC-SP5-85 is preferred.
- Aluminium** should be sanded with 180-220 grit.
For application of a finish primer or high build surfacer over Cor Spec Primer 135 the surface should be sanded with 80-180 grit or grit blasted.
For application of a fairing system over Cor Spec Primer 135 the surface should be grit blasted or ground with (36 to 60 grit) to bright clean aluminium with a 50 - 100 micron (2 - 4 mils) profile.
Bright clean aluminium should always be achieved before application. The use of Alumiprep or Alumiprep and Alodine treatment may be used as an option to clean and treat the aluminium. Please contact your Alexseal Representative to discuss additional chemical treatment options.

- 6. Trade names & Packaging**
- | | | |
|-------|--|----------------|
| P1352 | ALEXSEAL Cor Spec Primer 135 Yellow | 1 QT & 3/4 Gal |
| C1357 | ALEXSEAL Cor Spec Primer 135 Converter | 21oz & 1 QT |

- 7. Mixing ratio**
- | | | |
|-------------------|-------|--|
| 3 parts by volume | P1352 | ALEXSEAL Cor Spec Primer 135 Base |
| 1 part by volume | C1357 | ALEXSEAL Cor Spec Primer 135 Converter |
| No reduction | | |

Professional Use Only

Page 1 of 2

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Rev 01/2023

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8. Application

Viscosity	Zahn #2 Signature Cup: ≈ 15 sec, DIN 4 cup 4mm: ≈ 12 - 16 sec
Nozzle Size Gravity Gun	1.0 to 1.4 mm (0.039 to 0.055) - Conventional & HVLP
Fluid Nozzle Size Siphon Cup	1.4 to 1.6mm (0.061 to 0.070) - Conventional & HVLP
Fluid Nozzle Size Pressure Pot	0.8 to 1.2 mm (0.032 to 0.046) - Conventional & HVLP
Pot Pressure	0.7 to 1.5 bar (10 to 15 PSI) - Conventional & HVLP
Atomizing Pressure	2.0 to 4.0 bar (30 to 60 PSI)

Application by Spraying

Apply 1 cross coat to a wet film thickness (WFT) of 60 - 80 microns (2.5 - 3 mil). This will achieve a dry film thickness (DFT) of 20-25 microns (1 mil). Minimum recommended film is 20 microns (1 mil) DFT. Maximum recommended film thickness during a spray application is 1 coat totaling 80 microns (2 mil) WFT, or 25 microns (1 mil) DFT.

9. Pot life and Drying

Optimal application environment range - min. 15°C (60°F) 40% RH, up to max. 30°C (85°F) 80% RH

Temperature for minimum recoat time	15°C (60°F)	20°C (68°F)	25°C (77°F)	30°C (85°F)	Max Dry Time
Pot Life - approx.	8 hrs	6 hrs	6 hrs	6 hrs	N/A
Dust Free	90 min	60 min	45 min	30 min	N/A
Tape Dry	24 hrs	18 hrs	12 hrs	12 hrs	N/A
Fully Cured	10 days	8 days	7 days	6 days	N/A
Recoat with another coat of ALEXSEAL Cor Spec Primer 135	3 hrs minimum	2 hrs minimum	1 hr minimum	1 hr minimum	24 hrs maximum
Overcoat with another product including 161, 442, 302, 414 and 501. Sanding is required after max time.	5 hrs minimum	4 hrs minimum	3 hrs minimum	3 hrs minimum	24 hrs maximum

Note: The above chart reflects approximate minimum and maximum time. Surface temperature, air flow, direct or non-direct sunlight, quantity and or choice of reducer, and film thickness will affect actual tack up, recoat, overcoat, and drying times during application. During the drying phase the minimum temperature is 15°C (60°F). Ideal temperature: 25°C (77°F). The minimum application condition should be 3°C (5.4°F) above dew point.

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Page 2 of 2

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