



IMA – 400  
**CORO-BOND™**  
**Alkyd Metal Primer**  
**M35 Line**  
**Rev. 8/05**

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

## CORO-BOND™ Alkyd Metal Primer

### M35 Line

| Type   | Sheen | Theoretical Spread Rate                        | Recommended Application           | Thinner             | Clean Up        |
|--|-------|--|-----------------------------------|---------------------|-----------------|
| Alkyd  | Flat  | 400 to 500 Sq. Ft. Per Gallon*                 | Brush, Roll, Airless or Air Spray | Mineral Spirits     | Mineral Spirits |
| <b>Touch Dry Time:</b>                       |       | <b>Min Recoat:</b>                             |                                   | <b>Max Recoat :</b> |                 |
| 8 Hrs. @55°F<br>2 Hrs. @77°F<br>1 Hr. @100°F |       | 32 Hrs. @55°F<br>8 Hrs. @77°F<br>4 Hrs. @100°F |                                   | Unlimited           |                 |

|  |   |   |
|--|---|---|
| <b>PRODUCT NAME:</b><br>M35 Line<br>CORO-BOND™<br>Alkyd Metal Primer | CORO-BOND™ Alkyd Metal Primer is designed for industrial or commercial use in mild to moderate exposures. Excellent wetting properties allow for application on marginally prepared substrates. These primers are formulated with corrosion inhibiting pigments which provide years or rust protection when applied properly. These primers may be top-coated with a wide variety of finishes; however, finishes containing strong solvents (ketones, xylene, toluene) may cause wrinkling or lifting of these primers.   |   |
| <b>WHERE TO USE:</b>   | <b>Ferrous Metal</b>  | CORO-BOND™ Alkyd Metal Primers are designed for field or shop application in the General Metal Finishing / Fabrication market, the Industrial Maintenance market and the commercial/architectural/structural market and other areas requiring a rust inhibitive primer. |
| <b>SURFACE PREPARATION:</b>  | <p>The performance of this product is directly dependent upon the degree of surface preparation employed. All dirt, oils, accumulated salts, and other contaminants must be removed prior to employing specific surface preparation methods. Removal of all contaminants should be completed in accordance with SSPC-SP1.</p> <p>Ferrous metal substrates should be free of mill scale and loose rust. Aggregate blasting should be in accordance with SSPC-SP6 Commercial Blast for cleanliness. Conscientious power tool cleaning (SSPC-SP3) may be employed; however, for best results, power tool cleaning to bare metal (SSPC-SP11) is strongly suggested.</p> <p>Existing coatings should be solvent wiped to remove oil, grease, dirt and other contaminants, followed by sanding to remove gloss and finally cleaned again to remove dust from sanding.</p>   |   |
| <b>APPLICATION:</b>  | <p>Mix the product thoroughly before application. The use of a drill mixer at low speed will best accomplish this task. Do not apply CORO-BOND™ Alkyd Metal Primers if air or surface temperatures are below 45°F or above 95°F, or in relative humidities greater than 90%, or if surface or air temperatures are within 5 degrees of the dew point. Product should be allowed to dry tack free prior to air or surface temperatures being within 5 degrees of the dew point.</p> <p>Do not thin more than local regulations allow. SEE THINNING INSTRUCTIONS ON PAGE THREE.</p> <p><b>Airless Spray (Preferred Method):</b> Tip range between 13 and 17 thousandths. Total fluid output pressure at tip should not be less than 2200 psi.</p> <p><b>Air Spray (Pressure Pot):</b> 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><b>Brush:</b> Natural Bristle.</p> <p><b>Roller:</b> Industrial Cover with Phenolic core.</p> |   |
| <b>*NOTE ON SPREAD RATE:</b>   | 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.  |   |

**TAB 4**  
**IMA-400**  
**CORO-BOND™**  
**ALKYD METAL PRIMER**  
**M35 LINE**

| <b>STORAGE:</b>  | 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.   |                   |              |                 |           |                  |            |           |            |                         |            |             |             |
|--|--|-------------------|--------------|-----------------|-----------|------------------|------------|-----------|------------|-------------------------|------------|-------------|-------------|
| <b>TINTABILITY:</b>  | CORO-BOND™ Alkyd Metal Primers are available in -111 White, -147 Red and -153 Yellow as stock items. Special colors are available in minimum batch quantities.   |                   |              |                 |           |                  |            |           |            |                         |            |             |             |
| <b>RESIN TYPE:</b>   | Alkyd  |                   |              |                 |           |                  |            |           |            |                         |            |             |             |
| <b>VOLUME SOLIDS:</b>  | M35-111 White: 56 ± 1.0%;  |                   |              |                 |           |                  |            |           |            |                         |            |             |             |
| <b>WEIGHT PER GALLON:</b>  | M35-111 White: 12.25   |                   |              |                 |           |                  |            |           |            |                         |            |             |             |
| <b>MIX RATIO:</b>  | N/A (One Component Material)   |                   |              |                 |           |                  |            |           |            |                         |            |             |             |
| <b>INDUCTION TIME:</b>   | N/A (One Component Material)   |                   |              |                 |           |                  |            |           |            |                         |            |             |             |
| <b>POT LIFE:</b>   | N/A (One Component Material)   |                   |              |                 |           |                  |            |           |            |                         |            |             |             |
| <b>FLASH POINT:</b>  | 102°F (Seta)   |                   |              |                 |           |                  |            |           |            |                         |            |             |             |
| <b>SPECULAR GLOSS:</b>   | 0-8 @ 60°  |                   |              |                 |           |                  |            |           |            |                         |            |             |             |
| <b>WET FILM THICKNESS:</b>   | 3.2 to 4.0 mils  |                   |              |                 |           |                  |            |           |            |                         |            |             |             |
| <b>DRY FILM THICKNESS:</b>   | 1.8 to 2.2 mils  |                   |              |                 |           |                  |            |           |            |                         |            |             |             |
| <b>CAUTIONS:</b><br>(This information is for M35-111 White; *Other colors may vary)          | <p style="text-align: center;"><b>DANGER!</b></p> <p style="text-align: center;">COMBUSTIBLE LIQUID AND VAPOR. HARMFUL OR FATAL IF SWALLOWED.</p> <p><b>Contains: Mineral Spirits.</b> Vapor harmful. May affect the brain or nervous system causing dizziness, headache or nausea. Causes eye, skin, nose and throat irritation.</p> <p><b>NOTICE:</b> Reports have associated repeated and prolonged occupational overexposure to solvents with permanent brain and nervous system damage. Intentional misuse by deliberately concentrating and inhaling the contents may be harmful or fatal.</p> <p>Keep away from heat and flame. Prevent build-up of vapors by opening all windows and doors to achieve cross-ventilation.</p> <p><b>Use only with adequate ventilation.</b> Do not breathe 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.</p> <p><b>First Aid:</b> In case of eye contact, immediately flush with plenty of water for at least 15 minutes and get medical attention immediately; for skin, wash thoroughly with soap and water. If you experience difficulty in breathing, leave the area to obtain fresh air. If continued difficulty is experienced, get medical attention immediately. If swallowed, do not induce vomiting. Call physician immediately.</p> <p>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><b>ATTENTION!</b> This container hazardous when empty. Empty container retains explosive vapors and flammable residues. All labeled hazard precautions must be observed. Keep away from heat, sparks, and flames. Do not cut, puncture or weld on or near this container. Not rated for pressure, do not apply air or gas pressure. Do not reuse this container for any purpose.</p> <p style="text-align: center;"><b>Obtain and read the MSDS prior to using this product.</b><br/> <b>KEEP OUT OF REACH OF CHILDREN</b></p> <p style="text-align: center;"><b>FOR INDUSTRIAL USE ONLY</b></p> |                   |              |                 |           |                  |            |           |            |                         |            |             |             |
| <b>VOC/VOS STATEMENT:</b><br>(This information is for M35-111 White; *Other colors may vary) | This product contains a maximum of 400 grams of VOC/VOS per liter of coating. (3.3 pounds per gallon)  |                   |              |                 |           |                  |            |           |            |                         |            |             |             |
| <b>OTC CATEGORY:</b>   | This product is compliant under the Ozone Transport Commission regulations as a Rust Preventive Coating.   |                   |              |                 |           |                  |            |           |            |                         |            |             |             |
| <b>CHEMICAL ABSTRACT:</b><br>(This information is for M35-111 White; *Other colors may vary) | <table border="0"> <thead> <tr> <th style="text-align: left;"><u>INGREDIENT</u></th> <th style="text-align: left;"><u>CAS #</u></th> </tr> </thead> <tbody> <tr> <td>Mineral Spirits</td> <td>8052-41-3</td> </tr> <tr> <td>Titanium Dioxide</td> <td>13463-67-7</td> </tr> <tr> <td>Tremolite</td> <td>14567-73-8</td> </tr> <tr> <td>Inorganic Zinc Compound</td> <td>64539-51-1</td> </tr> <tr> <td>Alkyd Resin</td> <td>Proprietary</td> </tr> </tbody> </table>   | <u>INGREDIENT</u> | <u>CAS #</u> | Mineral Spirits | 8052-41-3 | Titanium Dioxide | 13463-67-7 | Tremolite | 14567-73-8 | Inorganic Zinc Compound | 64539-51-1 | Alkyd Resin | Proprietary |
| <u>INGREDIENT</u>  | <u>CAS #</u>   |                   |              |                 |           |                  |            |           |            |                         |            |             |             |
| Mineral Spirits  | 8052-41-3  |                   |              |                 |           |                  |            |           |            |                         |            |             |             |
| Titanium Dioxide   | 13463-67-7   |                   |              |                 |           |                  |            |           |            |                         |            |             |             |
| Tremolite  | 14567-73-8   |                   |              |                 |           |                  |            |           |            |                         |            |             |             |
| Inorganic Zinc Compound  | 64539-51-1   |                   |              |                 |           |                  |            |           |            |                         |            |             |             |
| Alkyd Resin  | Proprietary  |                   |              |                 |           |                  |            |           |            |                         |            |             |             |

**TEST DATA**

|  |   |
|--|---|
| <b>Salt Fog Resistance (ASTM B117) One coat M35-111 with 2 Coats M31-1</b> | 500 Hours-Pass (Rating 10, Rust Area 0.00%) |
| <b>Dry Heat Resistance</b>   | 250°F                                       |
| <b>Wet Heat Resistance</b>   | 150°F                                       |
| <b>Adhesion (ASTM D3359)</b>   | 5B  |
| <b>Flexibility (ASTM D1737)</b>  | Pass 1/4" Mandrel                           |

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

|                                |   |
|--------------------------------|---|
| <b>Fresh Water</b>             | See Finish Coat Data Sheets for Resistance Information. |
| <b>Salt Water</b>              |   |
| <b>Acids</b>                   |   |
| <b>Alkalis</b>                 |   |
| <b>Solvents</b>                |   |
| <b>Fuel</b>                    |   |
| <b>Acidic Salt Solutions</b>   |   |
| <b>Alkaline Salt Solutions</b> |   |
| <b>Neutral Salt Solutions</b>  |   |

**QUALIFICATIONS**

|  |
|--|
| M35-111 Meets MPI #79  |
| M35-147 Meets performance requirements of TT-P-86, Type III    |
| M35-147 Meets performance requirements of TT-P-636             |
| M35-147 Meets performance requirements of SSPC Paint 11        |
| M35-147 Meets performance requirements of SSPC Paint 13        |
| M35-147 Meets performance requirements of SSPC Paint 25        |
| M35-153 Meets performance requirements of TT-P-645             |
| M35 Line Meets MPI #23   |
| M35 Line Meets USDA Qualifications for incidental food contact |

**SYSTEMS RECOMMENDATIONS COMPATIBLE INTERMEDIATES & FINISHES**

|  |
|--|
| Finish Coats: 138, 142, 180, 182, 1280, 55, M31, M13, 80, 90, 1223, 47   |
| For finishes 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:**

Do not thin more than local regulations allow.  
 Thin with Mineral Spirits Only.

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NOTES:

