



IMA – 406
CORO-BOND™
Cold Galvanizing Primer
M35-152
Rev 8/05

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

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Type	Sheen	Theoretical Spread Rate	Recommended Application	Thinner	Clean Up
Thermoplastic Rubber	Flat	300 to 400 Sq. Ft. Per Gallon*	Airless or Air Spray	Xylene	Xylene
Touch Dry Time:	2 Hrs. @55°F 30 Min. @77°F 15 Min. @100°F	Min Recoat:	48 Hrs. @55°F 12 Hrs. @77°F 6 Hrs. @100°F	Max Recoat:	Unlimited (See compatible products)

PRODUCT NAME: CORO-BOND™ Cold Galvanizing Primer M35-152	CORO-BOND™ Cold Galvanizing Primer is a heavy-duty corrosion inhibiting primer designed for use on ferrous metal in industrial applications. The dried film of this product contains 83.4% zinc. Additionally, weathered galvanized metal may be brought back to its' original cathodic protection by using this product. The organic resin used in this product may be left untopcoated or may be finished with a variety of finishes. Note: Due to the thermoplastic resin used, certain finishes will require a tie coat of 180-11 prior to finish coat application.	
WHERE TO USE:	Ferrous Metal Weathered Galvanized	CORO-BOND™ Cold Galvanizing Primer is designed for the General Metal Finishing / Fabrication market, industrial maintenance market, the marine / offshore market and the architectural / structural market.
SURFACE PREPARATION:	<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 all mill scale and rust. Aggregate blasting should be in accordance with SSPC-SP10 Near White 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>Weathered Galvanized substrates should have all rust removed by aggregate blasting in accordance with SSPC-SP10 Near White 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>It is not recommended to apply this coating over previous finishes.</p>	
APPLICATION:	<p>Mix the product thoroughly before application. The use of a drill mixer at low speed will best accomplish this task. Ensure that all zinc is mixed into solution with none remaining on the bottom of the can. Do not apply CORO-BOND™ Cold Galvanizing Primer if air or surface temperatures are below 35°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. Do not thin more than local regulations will allow. See thinning recommendations on Page 3.</p> <p>Airless Spray (Preferred Method): Tip range between 19 and 25 thousandths. Total fluid output pressure at tip should not be less than 2100 psi.</p> <p>Air Spray (Pressure Pot): Must have air agitator. Binks or equivalent equipment. (Gun: #18 or 62; Fluid Nozzle: #66; Air Nozzle: 66 PE).</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 (for small areas only).</p>	

*NOTE ON SPREAD RATE:	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 on the volume solids of this product and the recommended wet film thickness when applied to a smooth substrate.														
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™ Cold Galvanizing Primer is available in gray only.														
RESIN TYPE:	Thermoplastic Rubber														
SOLIDS:	Weight: 79% Volume: 41 ± 1.0%														
WEIGHT PER GALLON:	20.10 lbs.														
MIX RATIO:	N/A (One Component Material)														
INDUCTION TIME:	N/A (One Component Material)														
POT LIFE:	N/A (One Component Material)														
FLASH POINT:	80°F (Seta)														
SPECULAR GLOSS:	0-5 @ 60°														
WET FILM THICKNESS:	3.5 to 5.0 mils														
DRY FILM THICKNESS:	1.4 to 1.9 mils														
CAUTIONS:	<p style="text-align: center;">DANGER! FLAMMABLE LIQUID AND VAPOR. VAPOR HARMFUL. CAUSES EYE IRRITATION. HARMFUL OR FATAL IF SWALLOWED.</p> <p>Contains Xylene, and Ethylbenzene. Vapor harmful. May affect the brain or nervous system causing dizziness, headache or nausea. Causes skin, nose and throat irritation. May be harmful if absorbed through the skin.</p> <p>NOTICE: 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, sparks and flame. Vapors may 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. Prevent build-up of vapors by opening all windows and doors to achieve cross-ventilation.</p> <p>Use only with adequate ventilation. 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 respirator manufacturer's directions for respirator use. Do not get in eyes, on skin or clothing. Wash thoroughly after handling.</p> <p>First Aid: In case of eye contact, flush immediately with plenty of water for at least 15 minutes and get medical attention; 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>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. KEEP OUT OF REACH OF CHILDREN</p> <p style="text-align: center;">FOR INDUSTRIAL USE ONLY</p>														
VOC/VOS STATEMENT:	This product contains a maximum of 400 grams of VOC/VOS per liter of coating. (3.3 pounds per gallon)														
OTC CATEGORY:	This product is compliant under the Ozone Transport Commission regulations as a Rust Preventive Coating.														
CHEMICAL ABSTRACT:	<table border="0"> <thead> <tr> <th style="text-align: left;">INGREDIENT</th> <th style="text-align: left;">CAS #</th> </tr> </thead> <tbody> <tr> <td>Xylene</td> <td>1330-20-7</td> </tr> <tr> <td>Ethylbenzene</td> <td>100-41-4</td> </tr> <tr> <td>Zinc</td> <td>7440-66-6</td> </tr> <tr> <td>Zinc Oxide</td> <td>1314-13-2</td> </tr> <tr> <td>Mica</td> <td>12001-26-2</td> </tr> <tr> <td>Chlorinated Rubber</td> <td>9006-03-5</td> </tr> </tbody> </table>	INGREDIENT	CAS #	Xylene	1330-20-7	Ethylbenzene	100-41-4	Zinc	7440-66-6	Zinc Oxide	1314-13-2	Mica	12001-26-2	Chlorinated Rubber	9006-03-5
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TEST DATA

Salt Fog Resistance (ASTM B117) One coat	500 Hours-Pass (Rating 10, Rust Area 0.00%)
Dry Heat Resistance	200°F
Wet Heat Resistance	125°F
Adhesion (ASTM D3359)	5B

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

Fresh Water	See Finish Coat Data Sheets for Resistance Information.
Salt Water	
Acids	
Alkalis	
Solvents	
Fuel	
Acidic Salt Solutions	
Alkaline Salt Solutions	
Neutral Salt Solutions	

QUALIFICATIONS

Cold Galvanizing Project Qualification
Meets Composition requirements of TT-P-1046
Meets Performance requirements of TT-P-641
Meets Performance requirements of DOD-P-21035
Meets SSPC Paint #5
Meets SSPC Paint #20, type II

**SYSTEMS RECOMMENDATIONS
COMPATIBLE INTERMEDIATES & FINISHES**

Finish Coats (Not using a tie-coat): 180 Line, 182 Line, 1280 Line, 227 Line, 138 Line, 142 Line
Finish Coats (Using 180-11 as a tie coat): M13 Line, M31 Line, 101 Line, 827 Line, 837 Line, 2221 Line
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 Xylene Only.

The use of 4 ounces per gallon of specified thinner will result in a VOC of 529 grams per liter (4.43 lbs./gal.)

The use of 8 ounces per gallon of specified thinner will result in a VOC of 556 grams per liter (4.66 lbs./gal.)

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NOTES: