AMERCOAT®

Protective Coatings

Amercoat 68SA

Zinc-Rich Epoxy

Product Data/ Application Instructions

- **An experience-proven zinc-rich epoxy**
- **Combines epoxy's toughness with zinc's superior protection**
- **Outstanding resistance to water and abrasion**
- **Superior performance on marine hulls, decks and superstructures**
- **Excellent adhesion to inorganic zincs**
- **Easily applied by airless or conventional spray**

Typical Uses

(with suitable topcoats)
INDUSTRIAL - Structural steel, machinery pipes and tank exteriors in paper mills, oil refineries, power plants, chemical process and waste treatment plants.
MARINE - Decks, hulls and superstructures of ships, barges and workboats. Piers, offshore platforms and related structures.

Outstanding Characteristics

The zinc content gives a cathodic protection if film is damaged. Apply a single coat of Amercoat 68SA at 75 µm dry film thickness, overcoated with a recommended epoxy topcoat or topcoat system. With the proper topcoats, Amercoat 68SA withstands splash or spillage of water, solvents, chemicals and petroleum products. For specific recommendations contact your PPG representative.

Approvals and Certificates

Amercoat 68SA is a polyamide cured zinc rich epoxy primer. It conforms to the requirements of US Department of Agriculture (Meat Inspection Division) for coating structural steel in meat packing plants.

Repair

Amercoat 68SA may be used to repair itself or inorganic zinc coatings. Spot blast or power tool clean bear substrate to the requirements shown under surface preparation. Feather edges of intact coating. Remove dust, dirt and contamination before recoating.

Physical Data

Finish	flat
Colour	reddish grey
Components	2
Mixing ratio (by volume)	
resin	4 parts
cure	1 part
Curing mechanism	solvent release and reaction between components
Dry film thickness	75 µm
Number of coats	1
Volume solids	59% (ASTM D2697, modified) *
Calculated coverage	7.8 m²/l at 75 µm

Allow for application losses, surface irregularities, etc.

Specific gravity	2.55 kg/l (mixed product)

Flash points

	ºC	ºF
(Closed Cup)		
resin	23	73
cure	23	73
Amercoat 9HF	26	79

* Volume solids is measured in accordance with ASTM D2697 modified. Slight variations ± 3% may occur due to colour and testing variances.

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Surface Preparation
STEEL - Blast in accordance with ISO 8501 Sa 2½ or Steel Structures Painting Council SP 10.
NOTE: blast to achieve a 25 to 50 µm profile as determined with *Testex* Tape or similar instrument. Remove abrasive residues and dust from surface. Also remove oil or grease with a neutral detergent or emulsion cleaner (like Amercoat 57 oil cleaner).
IMPORTANT - Apply Amercoat 68SA as soon as possible after surface preparation to prevent any contamination. Do not leave blasted steel uncoated overnight. In case of contamination, remove contaminants. Spot blast steel if needed.
DIMETCOTE - Surface must be clean and dry. Remove any contamination. Refer to application instructions for the particular Dimetcote types for any other special topcoating requirements. Remove oil or grease with a neutral detergent or emulsion cleaner (like Amercoat 57 oil cleaner).

Application Equipment
The following equipment is listed as a guide and suitable equipment from other manufacturers may be used. Adjustments of pressure and change of tip size may be needed to obtain the proper spray characteristics.
AIRLESS SPRAY - Standard airless spray equipment, such as Graco, DeVilbiss, Nordson-Bede, Spee-Flo, or others having a 28:1 or higher pump ratio and a fluid tip with a 0.43 to 0.53 mm (0.017 to 0.021 inch) orifice.
CONVENTIONAL SPRAY - Industrial equipment such as DeVilbiss MBC or JGA gun with 78 or 765 air cap and "E" fluid tip and heavy mastic spring or Binks No. 18 or 62 with a 66 x 63 PB nozzle setup. Separate air and fluid pressure regulators, mechanical pot agitator and a moisture and oil trap in the main air supply line are recommended.
MIXER - Use power mixer powered by an air motor or an explosion proof electric motor.

Application Data Summary
Like all high performance coatings, Amercoat 68SA must be applied as recommended to obtain the maximum performance. To obtain the maximum performance for which Amercoat 68SA is formulated, strict adherence to all application instructions, precautions, conditions and limitations is necessary. If conditions exist that are not within the requirements or limitations described, consult your PPG representative.

Application Data

Substrate ..... abrasive blasted steel

Application methods ..... airless or conventional spray, brush or roller

Potlife (at 20°C/68ºF) ..... 8 hours

Drying Times
(in hours at 75 µm dry film thickness)

ºC/ºF	10/50	20/68	30/86
dry to handle.....	16	4	2
dry to topcoat.....	16	4	2

NOTE: drying times are dependent on air and steel temperature, applied film thickness, ventilation and other environmental conditions. Times are proportionally shorter at higher temperature and longer at lower temperatures. Prior to recoating, ensure the surface is clean. Maximum recoating time depends on coating system to be used. Consult your PPG representative for specific recommendations.

Environmental Conditions
(during application and drying)

Air temperature:	5 to 50°C	41 to 122ºF
Surface temperature:	5 to 60°C	41 to 140ºF

To prevent moisture condensation during application, surface temperature must be at least 3°C/5ºF above dew point. Never apply coatings under reverse environmental conditions. Ensure good ventilation when applied in confined areas, to assist evaporation and elimination of solvents.

Recoat Times

(in hours) ºC/ºF	10/50	20/68	30/86
minimum.....	16	4	2
maximum.....	-	-	- *

* Coating must be in good condition, free of contamination, dust, oil and grease.

Thinner/cleaner ..... Amercoat 9HF

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Application Procedure
Amercoat 68SA is packaged in the proper mixing proportions of resin and cure.
Resin 4 l in 5 l can
Cure 1 l in 1 l can

1. Flush equipment with Amercoat 9HF.
2. Stir each of the components prior to mixing to an even consistency with a power mixer.
3. Add cure to resin and continue stirring for 5 minutes. Strain material through 250 µm (60 mesh) screen to prevent possible clogging of equipment.
   NOTE: Since the potlife is limited and shortened by high temperatures, do not mix more material than will be used within the potlife period.
4. For conventional spray, thin only as needed for workability 10 vol % of Amercoat 9HF. Thinning is normally not needed for airless spray.
5. Stir during application to maintain uniformity of material. Apply a wet coat by even, parallel passes. Overlap each pass 50% to avoid bare areas, pinholes or holidays.
6. Give special attention to welds, rough spots, sharp edges and corners, rivets, bolts, etc.
7. Application at 130 µm wet film thickness will normally provide 75 µm dry film.
8. Check thickness of dry coating with a non-destructive dry film thickness gauge, such as Mikrotest or Elcometer. If less than specified thickness, apply additional material as needed.
9. Small damaged or bare areas and random pinholes or holidays can be touched up by brush. Repair larger areas by spray.
10. In confined areas ventilate with clean air during application and drying until all solvents are removed. Temperature and humidity of ventilating air must be such that moisture condensation will not form on surface.
11. Clean all equipment with Amercoat 9HF immediately after use or at least at the end of each working day or shift. When left in spray equipment, Amercoat 68SA will cure and cause clogging.

Shipping Data

Packaging	
resin	8 l in 10 l can
cure	2 l in 2½ l can
Shipping weight	
resin	approx. 24 kg
cure	approx. 2½ kg
Shelf life	
resin	1 year from shipment date when stored indoors in unopened, original containers at 5 to 40°C (41 to 104ºF).
cure	1 year from shipment date when stored indoors in unopened, original containers at 5 to 40°C (41 to 104ºF).

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Caution
This product is flammable. Keep away from heat and open flame. Keep container closed. Use with adequate ventilation. Avoid prolonged and repeated contact with skin. If used in confined areas, observe the following precautions to prevent hazards of fire or explosion or damage to the health:

1. circulate adequate fresh air continuously during application and drying;
2. use fresh air masks and explosion proof equipment;
3. prohibit all flames, sparks, welding and smoking.

Do not empty into drains. Take precautionary measures against static discharges. For specific information on hazardous ingredients, required ventilation, possible consequences of contact, exposure and safety measures see Safety Data Sheet.

Safety
Since improper use and handling can be hazardous to health and cause of fire or explosion, safety precautions included with Product Data/Application Instruction and Material Safety Data Sheet must be observed during all storage, handling, use and drying periods.

Warranty
PPG warrants its products to be free from defects in material and workmanship. PPG's sole obligations and Buyer's exclusive remedy in connection with the products shall be limited, at PPG's option, to either replacement of products not conforming this warranty or credit to Buyer's account in the invoiced amount of the non-conforming products. Any claim under this warranty must be made by Buyer to PPG in writing within five (5) days of Buyer's discovery of the claimed defect, but in no event later than the expiration of the applicable shelf life, or one year from the delivery date, whichever is earlier. Buyer's failure to notify PPG of such non-conformance as required herein shall bar Buyer from recovery under this warranty.

PPG makes no other warranties concerning the product. No other warranties, whether express, implied or statutory, such as warranties of merchantability or fitness particular purpose, shall apply. In no event shall PPG be liable for consequential or incidental damages.

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To avoid any confusion that may arise through translation into other languages, the English version of the Product Data/Application Instructions will be the governing literature and must be referred to in case of deviations with product literature in other languages.

Condition of Sale
All our transactions are subject to our Terms and Conditions of Sale.