



High-build epoxy intermediate coating

Product Data/ Application Instructions

- High build epoxy intermediate coating
- Reduced volatile organic compounds (VOC)
- High-build and High-solids
- · Tough and durable
- Also available with 40% MIO pigmentation

Typical uses

Amercoat 383H is used as an intermediate coating for atmospheric exposure in marine and industrial environments. Amercoat 383H is normally applied over an inorganic zinc-silicate or epoxy primer

Typical Global Systems using Amercoat 383H

ISO 12944 classifica- tion	First coat	Intermediate	Finish Coat
C5	Dimetcote	Amercoat 383H	Amercoat 450 Series
C5	Amercoat 68 Series	Amercoat 383H	Amercoat 450 Series
C4	Amercoat 385PA	Amercoat 383H	Amercoat 450 Series

Amercoat 383H is not recommended for direct to metal applications, for use at continuous immersion conditions and is normally topcoated for optimal performance

Approvals and Certificates

Amercoat 383H has been successfully tested to/ and meets the requirements of Norsok M501-rev.5 system1 as an intermediate coating in conjunction with Amercoat 68 Series primer and Amercoat 450 series topcoats. Consult your PPG representative for full system details.

Physical Data

Finish	semi gloss	
Colour	Off White, Light Grey, MIO Pearl Grey, GR-3	
Components	2	
Mixing ratio (by volume)	1 part Resin 1 part Cure	
Curing mechanism	solvent release and chemical reaction between components	
Volume solids	77% (ISO 3233)*	
VOC** EC SED 1999/13/EC UK PG6/23(92) Appendix 3 .	148 g/kg (225 g 180 g/l (1.5 lbs	
Dry film thickness	100 – 200 μm per coat 4 –8 mil per coat	
Number of coats	1	
Theoretical coverage At 100 microns/4 mil dft At 200 microns/6 mil dft		314 ft²/gal 157 ft²/gal
Flashpoints Cure Resin Mixed Amercoat 65 Amercoat 12	°C 47 47 47 24 21	°F 117 117 117 75 75
Thinners	Amercoat 65	
Cleaner	Amercoat 12	

^{*} Volume solids is measured in accordance with ISO 3233. Slight variations ±3% may occur due to colour and testing variances.

^{**} VOC figures are quoted according to both the EC directive 1999/13/EC which are theoretically calculated figures and the UK PG6/23(92) Appendix 3 which are practically determined figures.

Chemical Resistance Guide

When applied over suitable primer or intermediate coat and topcoated with Amercoat 450 Series:

Splash and Environment	Fumes and Spillage	Weather
Acidic	Very good	Excellent
Alkaline	Very good	Excellent
Salt solutions		
Acidic	Excellent	Excellent
Neutral	Excellent	Excellent
Alkaline	Excellent	Excellent
Water	Excellent	Excellent

This table is only a guide. For specific recommendations, contact your PPG representative for your particular corrosion protection needs.

Surface Preparation

PRIMED STEEL - Coating performance is proportional to the degree of surface preparation. Refer to specifications of the specific primer being used. Prior to coating, primed surface must be clean, dry, undamaged and free of all contaminants including salt deposits. Round of all rough welds and remove weld spatter.

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, having a 0.019 to 0.027 inch (0.38 to 0.53 mm) fluid tip.

CONVENTIONAL SPRAY

Industrial equipment with 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

Substrate	, ,	d steel coated with PA, Dimetcote 9, Series
Application method	Airless or conv	ventional spray.
Environmental conditions Air temperature Surface temperature	5-50 °C 5-60 °C	41-122 °F 41-140 °F
Surface temperature must be a	nt least 3°C / 5°I	= above the dew

Surface temperature must be at least 3°C / 5°F above the dew point to prevent moisture condensation on the surface.

Potlife (°C/°F)	32/90 1 hrs	21/70 2hrs	10/50 4 hrs
Drying times (°C/°F) Dry to touch Dry through	3 hrs	21/70 6 hrs 16 hrs	10 hrs
Recoat or topcoat times (°C/°F)32/9 Minimum			s 24 hrs
with Amercoat 450 Series 30 days		ıys	

Maximum recoating/topcoating time intervals are dependent on temperature, degree of weathering, type of topcoat, and service conditions of the complete coating system. Consult your PPG representative for specific recommendations.

Drying times are dependent on temperature, ventilation and film thickness.

Application Procedure

Amercoat 383H is packaged in the proper mixing proportions of resin and cure.

Resin 10 L (2.6 gal) in 20 L can Cure 10 L (2.6 gal) in 10L can

Thinner: Of 18 æ 1 Cleaner: Amercoat 12

- 1. Flush equipment with recommended cleaner before use.
- 2. Mix, resin (in the larger container) to an even consistency with a power mixer.
- Add cure to resin and stir to an even consistency. 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. If thinning is necessary for workability do not add more than 10% of recommended thinner.
- 5. Mix during application to maintain uniformity of material. Apply a wet even coat in parallel passes. Overlap each pass 50% to avoid bare areas, pinholes or holidays.
- 6. Double coat all welds, rough spots, sharp edges and corners, rivets, bolts, etc.
- Application at 170 μm wet film thickness will normally provide 125 μm dry.
- 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.
- 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 recommended cleaner immediately after use or at least at the end of each working day or shift. When left in spray equipment, the product will cure and cause clogging.

Shipping Data

Packaging Resin Cure	10 L (2.6 gal) in 20 L can 10 L (2.6 gal) in 10 L can
Shipping weight Resin Cure	kg lb approx. 18 40 approx. 16 36
Shelf life Resin and cure	1 year from shipment date when stored indoors in unopened, original containers at 5 to 40°C (41 to 104°F)

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;
- prohibit all flames, sparks, welding and smoking.
 not empty into drains. Take precautionary measures

against static discharges. For specific information on hazardous ingredients, required ventilation, possible consequences of contact 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.

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