



# Amercoat 385PM

## Epoxy Flow Coating

### Product Data/ Application Instructions

- High solids epoxy flow coating
- Conforms to API 5L2 specification requirement
- Reduces frictional resistance in gas pipelines
- Rust inhibitive formulation
- No lead pigments added
- Easy application with 1:1 mixing ratio
- Compliant with all solvent emission guidelines

#### Typical Uses

Gas pipe lining internal flow coating at thicknesses from 40 µm up to 75 µm. Amercoat 385PM requires no induction time before application and is compatible for use with fusion bonded epoxies applied after the flow coating.

#### Approvals and Certificates

Conforms to API 5L2 specification requirements.

#### Repair

Remove oil, grease and other contaminants. Spot blast areas to Sa 2½, feathering edges of intact coating. Thoroughly remove dust or abrasive residue before touch up.

#### Physical Data

|  |  |    |
|--|--|----|
| Finish .....   | satin  |    |
| Colour .....   | oxide red  |    |
| Components .....   | 2  |    |
| Mixing ratio (by volume)                                   |  |    |
| resin .....  | 1 part   |    |
| cure .....   | 1 part   |    |
| Curing Mechanism .....                                     | solvent evaporation and chemical reaction between components |    |
| Volume solids .....  | 66% (ASTM-D2697; modified) *                                 |    |
| VOC .....  | 25.2% by weight/ 336 g/l                                     |    |
| Dry film thickness .....                                   | 50 µm per coat   |    |
| Number of coats .....                                      | 1  |    |
| Calculated coverage .....                                  | 13.2 m <sup>2</sup> /l at 50 µm                              |    |
| Allow for application losses, surface irregularities, etc. |  |    |
| Specific gravity .....                                     | 1.33 kg/l (mixed product)                                    |    |
| Flash points   |  |    |
| (Closed Cup) .....   | °C   | °F |
| resin .....  | 26   | 79 |
| cure .....   | 29   | 84 |
| Amercoat 65 .....  | 24   | 75 |
| Amercoat 12 .....  | 24   | 75 |

\* Volume solids is measured in accordance with ASTM-D2697. Slight variations may occur due to colour and testing variances.

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## Surface Preparation

STEEL - Blast steel surfaces to a minimum of Sa 2½ in accordance with Swedish Standard SIS 05 5900 - 1967 or ISO 8501-1). NOTE: Blast to achieve a surface profile not to exceed 75 µm as determined with a Keane Tator Surface Profile Comparator or similar instrument. Remove abrasive residues and dust from surface.

IMPORTANT - Apply Amercoat 385PM 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.

## 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 0.015 to 0.021 inch (0.38 to 0.53 mm) fluid tip.

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. Mixer must be powered by an air motor or an explosion proof electric motor.

## Application Data Summary

Like all high performance coatings, Amercoat 385PM must be applied as recommended to obtain the maximum protection for which this coating is formulated. To obtain the maximum performance for which Amercoat 385PM 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 .....   | steel                         |
| Application methods .....                                 | airless or conventional spray |
| Potlife (at 20°C/68°F) .....                              | 3 hours                       |
| Potlife is dependent on temperature and quantities mixed. |                               |
| Induction time (at 20°C/68°F)                             | not applicable                |
| Environmental Conditions<br>(during application)          |                               |
| Air temperature .....                                     | 10 to 50°C 50 to 122°F        |
| Surface temperature .....                                 | 10 to 50°C 50 to 122°F        |
| Material temperature.....                                 | 10 to 30°C 50 to 86°F         |

To prevent moisture condensation during application, surface temperature must be at least 3°C/5°F above dew point.

|                           |             |        |       |
|---------------------------|-------------|--------|-------|
| Drying Times (ASTM D1640) |             |        |       |
| (at 50 µm dft)            | °C/°F       | 30/86  | 20/68 |
|                           |             | 10/50  |       |
| dry to touch.....         | 15 min 1 hr | 3 hrs  |       |
| dry through .....         | 2 hrs 8 hrs | 16 hrs |       |
| dry to recoat             |             |        |       |
| or topcoat .....          | 2 hrs 6 hrs | 12 hrs |       |

NOTE: Drying and curing 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.

|               |                                 |
|---------------|---------------------------------|
| Thinner ..... | Amercoat 65                     |
| Cleaner ..... | Amercoat 12<br>(or Amercoat 65) |

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## Application Procedure

Amercoat 385PM is packaged in the proper 1:1 mixing proportions of resin and cure. Mix only in this ratio. Metering pumps may be used for handling. Since no induction time is required for Amercoat 385PM, plural component spray equipment can be used in place of mixing.

Resin: 25 l in 27.5 l can or 190 l in 200 l drum  
Cure: 25 l in 30 l polyethylene pail or 190 l in 200 l polyethylene drum

1. Flush equipment with recommended cleaner before use.
2. Stir resin to an even consistency with a power mixer.
3. Add cure to resin and continue stirring for 5 minutes. NOTE: Since the pot life is limited and shortened by high temperatures, do not mix more material than will be used in 3 hours at 20°C/68°F.
4. Thin only if necessary for workability. Add up to 10 vol. % of recommended thinner.
5. Apply a wet coat in even, parallel passes. Overlap each pass 50% to avoid bare areas, pinholes or holidays. Consult your PPG representative for further information.
6. Application at 75-80 µm wet film thickness will normally provide 50 µm dry film.
7. 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.
8. Small damaged or bare areas and random pinholes or holidays can be touched up by brush. Repair larger areas by spray.
9. 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.

## Shipping Data

### Packaging

|                    |                                    |
|--------------------|------------------------------------|
| 50 l: resin .....  | 25 l in a 27.5 l can               |
| cure .....         | 25 l in a 30 l polyethylene pail   |
| 400 l: resin ..... | 190 l in a 200 l drum              |
| cure .....         | 190 l in a 200 l polyethylene drum |

### Shipping weight

|                    |  |
|--------------------|--|
| 50 l: resin .....  | approx. 37 kg  |
| cure .....         | approx. 34 kg  |
| 400 L: resin ..... | approx. 293 kg   |
| cure .....         | approx. 275 kg   |
| Shelf life .....   | 1 year from shipment date when stored indoors in unopened, original containers at 5 to 40°C (41 to 104°F). |

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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 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.**

Any recommendations or suggestion relating to the use of the products made by PPG, whether in its technical literature, or response to specific enquiry, or otherwise, is based on data believed to be reliable; however, the products and information are intended for use by Buyer's having requisite skill and know-how in the industry, and therefore it is Buyer to satisfy itself of the suitability of the products for its own particular use and it shall be deemed that Buyer has done so, as its sole discretion and risk. Variation in environment, changes in procedures of use, or extrapolation of data may cause unsatisfactory results.

## Limitation of Liability

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In no event shall PPG be liable for consequential or incidental damages.

Due to PPG's policy of continuous product improvement, the information contained in this Product Data/Application Instructions sheet is subject to change without notice. It is the Buyer's responsibility to check that this issue is current prior to using the product. For the most up-to-date Product Data/Application Instructions always refer to the PPG Protective & Marine Coatings website at [www.ppgpmc.com](http://www.ppgpmc.com)

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.