



# Amercoat 1972B

## 100% Solids Epoxy Coating

### Product Data/ Application Instructions

- Solvent free, 100% solids epoxy seal-coat designed for protection of buried and subaqueous concrete pipelines
- Durable, abrasion-resistant, exterior pipe coating with high dielectric strength unaffected by moisture or soil chemicals
- Designed for production line application on moist surfaces of freshly placed or cured cement-mortar coated pipe and concrete pipe

#### Typical Uses

Amercoat 1972B is used as an exterior seal-coating for cement-mortar coated and concrete pipe to protect installed pipelines against stray current electrolysis, to provide a barrier against aggressive soils and ground waters, and to reduce current requirements for cathodically protected pipelines. When applied to freshly placed or partially cured cement-mortar and concrete surface, it also serves as a curing membrane.

Amercoat 1972B was first used in 1969 on a large-diameter prestressed concrete water transmission pipeline in the southwestern U.S.A. to protect against cathodic interference. Subsequently, Amercoat 1972B has been used to protect 24 million square meters of pipe on several other large pipeline projects around the world where cathodic interference or unusually corrosive soils were of major concern.

In the Middle East, Amercoat 1972B has been used extensively since 1980 as an exterior sealcoat on cementmortar coated pipelines and on concrete pipelines to provide a barrier to aggressive soils and ground waters.

#### Outstanding Characteristics

Amercoat 1972B, a solvent-free, 100% solids epoxy, is a high-performance, chemical and corrosion resistant concrete pipe exterior seal-coat. It is chemically compatible with hydrating cement mortar and concrete and can be applied to moist surfaces of freshly placed or cured cement mortar and concrete without special surface treatment. Its smooth, hard, abrasion-resistant finish facilitates the handling, transportation and installation of the pipe without damage to the coating. Amercoat 1972B does not depend upon solvent evaporation during the curing process which enables high film buildup in a single application without running, sagging or shrinking. The solvent-free, 100% solids composition facilitates applying a continuous coating to the required thickness in one application over relatively rough mortar or concrete surfaces. It is a two component coating using in-line static mixing during application, allowing the use of fast reacting resin and cure materials for rapid production line processing of the pipe being coated.

#### Physical Data

Finish .....	gloss
Colour .....	black, white *
Components .....	2
Mixing ratio (by volume)	
resin .....	1 part
cure .....	1 part
Curing mechanism .....	chemical reaction between components
Volume solids .....	100% (ASTM D2697)
VOC .....	0
Dry film thickness .....	16 - 36 mils / 400 - 900 µm per coat
Number of coats .....	1
Theoretical coverage .....	1 mil (25 µm) 1604 ft <sup>2</sup> /gal (39.4 m <sup>2</sup> /l)
Recommended coverage	
rough surface .....	36 mils (900 µm) 46 ft <sup>2</sup> /gal (1.1 m <sup>2</sup> /l)
smooth surface .....	16 mils (400 µm) 100 ft <sup>2</sup> /gal (2.5 m <sup>2</sup> /l)

Allow for application losses, surface irregularities, etc.

Flash points		
(Closed Cup) .....	°C	°F
resin .....	76	169
cure .....	85	185
Amercoat 12 .....	21	30

\* Amercoat 1972B black contains coal tar, Amercoat 1972B white is coal tar free.

# Amercoat 1972B

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## Surface Preparation

CONCRETE - Impacted cement mortar or cast concrete needs no special surface treatment. Smooth, dense, steel-trowelled surfaces must be roughened by abrasive blast or acid etch. All surfaces must be clean and free of dirt, other contaminants and loose laitance.

## Application Equipment

The following equipment is a partial guide and suitable equipment from other manufacturers may be used. Adjustments of pressures and change of tip size may be needed to achieve the proper spray characteristics.

AIRLESS SPRAY - Plural-component metering, mixing and spraying apparatus, such as Graco Variable Ratio Hydra-Cat, with a 0.021 - to 0.035 inch (0.53 to 0.88 mm) tip and 60 to 120 psi (4.2 to 8.4 kg/cm<sup>2</sup>) inbound air pressure to a 28:1 or 34:1 pump.

## Application Data Summary

Amercoat 1972B is a solvent-free 100% solids, high-build, epoxy seal-coat for protection of buried and subaqueous concrete, pipelines. It provides a durable, abrasion resistant coating with high dielectric strength and full film thickness in one application. Refer to Amercoat 1972B product data sheet for properties and uses. To obtain the maximum performance for which Amercoat 1972B is formulated, strict adherence to all application instructions, precautions, conditions and limitations is necessary

## Application Data

Substrate .....	moist surface of fresh or cured cement-mortar or concrete
Application method .....	heated 2-component metering airless spray
Potlife (at 21°C/70°F) .....	20 minutes in 1 gallon (4 litre) quantities

Potlife is dependent on temperature and quantities mixed.

### Drying Times

Amercoat 1972B reaches a dry through time in 12 hours at 24°C/75°F. Higher curing temperatures will reduce dry through times; lower temperatures will prolong dry through time. If the coating is applied when the ambient temperature is below 10°C/50°F, the coated pipe should be placed in a heated enclosure for coating cure at an elevated temperature.

Thinner .....	not applicable
Cleaner .....	Amercoat 12

# Amercoat 1972B

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## Application Procedure

Amercoat 1972B is packaged in the proper mixing proportions of resin and cure.

Resin: 190 l in 200 l drum

Cure: 190 l in 200 l drum

1. Flush equipment with Amercoat 12 before use.
2. Inline heat resin and cure components separately to 49 to 66°C (120 -150°F) Stir each component to a uniform consistency. Do not add thinner.
3. Adjust equipment to provide 1:1 ratio mixing
4. Apply a heavy, wet coat in even, parallel passes overlapping each pass 50% to avoid bare areas.
5. Apply material at a rate to achieve specified thickness.
6. Clean equipment immediately with Amercoat 12 after use.
7. For touch-up purposes, small amounts approximately 1 pint (0.5 litre) may be hand mixed and brush applied. Clean equipment promptly with Amercoat 12 after use.

CAUTION: Amercoat 1972B, when mixed and held in containers of 1 pint (0.5 Litre) or more, reacts rapidly, solidifying with generation of excessive heat. Once applied to the substrate at recommended thickness, curing takes place at normal rates

## Shipping Data

Packaging  
resin ..... 190 l in 200 l drum  
cure ..... 190 l in 200 l drum

Shipping weight  
resin ..... approx. 300 kg  
cure ..... approx. 305 kg

Shelf life  
resin/cure ..... 1 year from shipment date when stored indoors in unopened, original containers at 5 to 55°C (41 to 131°F).

# Amercoat 1972B

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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.

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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

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