February 7, 2024 (Revision of May 2, 2018)

AMERCOAT® 320 HSA

DESCRIPTION

High Solids Epoxy Coating

PRINCIPAL CHARACTERISTICS

- High build epoxy coat
- Good slip and release
- Chemically resistant in many environments
- VOC compliant
- Maintains more flexibility than typical epoxies
- Amercoat 320 HSA meets the requirements for FDA 175.300

COLOR AND GLOSS LEVEL

- Light Blue, White
- Semi-gloss

Note: Epoxy coatings will chalk and fade upon exposure to sunlight, elevated temperatures, or chemical exposure. Discoloration and normal chalking do not impact performance. Light colors will darken over time. Some batch-to-batch variation in color is to be expected. Color matches are approximate.

BASIC DATA AT 68°F (20°C)

Data for mixed product	
Number of components	Two
Volume solids	72 ± 2%
VOC (Supplied)	max. 2.0 lb/US gal (approx. 240 g/l)
Temperature resistance (Continuous)	To 200°F (93°C)
Temperature resistance (Intermittent)	To 250°F (121°C)
Recommended dry film thickness	4.0 - 8.0 mils (100 - 200 µm) per coat
Theoretical spreading rate	192 ft^2/US gal for 6.0 mils (4.8 m^2/l for 150 µm)
Shelf life	Base: at least 24 months when stored cool and dry Hardener: at least 24 months when stored cool and dry

Notes:
- See ADDITIONAL DATA – Overcoating intervals
- See ADDITIONAL DATA – Curing time
- Intermittent temperature resistance should be less than 5% of the time, and maximum 24 hours
- Color will drift at elevated temperatures

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RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

Mild steel

- Remove all surface contaminants, oil and grease in accordance with SSPC SP-1
- Abrasive blast clean to SSPC-SP10 (ISO8501-1 Sa 2.5). Blast with an angular abrasive to achieve an anchor profile of 1.5 – 4.0 mils (38 – 100 µm) as indicted by a Keane-Tator Surface profile Comparator or Testex Tape
- Contact PPG for maximum allowable salt containment levels

Repair

- Remove all rust, loose paint, grease or other contaminants preferably by spot abrasive blast from damaged areas abraded to bare steel. For smaller areas, abrade the steel in accordance with SSPC SP-11 standards to create a uniform and dense anchor profile
- Taper abrade the perimeter of the repair area to a feathered edge extending 1 – 3 inches from the steel
- Apply AMERCOAT 320 HSA to the repair area in 2 coats to achieve a minimum of 8.0 mils (200 µm) dry film thickness. Overlap the previously feathered edge

Substrate temperature and application conditions

- Surface temperature during application should be between 32°F (0°C) and 120°F (49°C)
- Surface temperature during application should be at least 5°F (3°C) above dew point
- Ambient temperature during application and curing should be between 32°F (0°C) and 120°F (49°C)
- Relative humidity during application should be above 0% and below 85%

INSTRUCTIONS FOR USE

Mixing ratio by volume: base to hardener 50:50 (1:1)

- Jiffy mixer with 1/4 hp pneumatic drive

Pot life

2 hours at 70°F (21°C)

Note: See ADDITIONAL DATA – Pot life

Application

- Area should be sheltered from airborne particulates and pollutants
- Avoid combustion gases or other sources of carbon dioxide that may promote amine blush and ambering of light colors
- Ensure good ventilation during application and curing
- Provide shelter to prevent wind from affecting spray patterns

Material temperature

Material temperature during application should be between 40°F (4°C) and 90°F (32°C)

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Airless spray

- 30:1 pump or larger

Recommended thinner
THINNER 21-06 (AMERCOAT 65)

Nozzle orifice
0.017 – 0.019 in (approx. 0.43 – 0.48 mm)

Brush/roller

- If needed for touch up, collect a small quantity from the static mixer and apply to the repair area with a well loaded, natural bristle brush

Recommended thinner
AMERCOAT 65 (xylene), AMERCOAT T10

Cleaning solvent
Amercoat 12 Cleaner (Thinner 90-58)

ADDITIONAL DATA

Overcoating interval for DFT up to 200 µm (8.0 mils)					
Overcoating with...	**Interval**	**50°F (10°C)**	**70°F (21°C)**	**90°F (32°C)**	**120°F (49°C)**
itself	Minimum	18 hours	6 hours	3.5 hours	2 hours
	Maximum	2 months	2 months	30 days	14 days

Notes:

- Prior to overcoating, solvent wipe surface with AMERCOAT 65 or AMERCOAT 12 Cleaner
- Roughen surface when maximum recoat or topcoating time is exceeded

Curing time for DFT up to 8.0 mils (200 µm)		
Substrate temperature	**Dry to touch**	**Dry to handle**
50°F (10°C)	9 hours	18 hours
70°F (21°C)	2.5 hours	6 hours
90°F (32°C)	1.5 hours	3.5 hours
120°F (49°C)	30 minutes	2 hours

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Pot life (at application viscosity)	
Mixed product temperature	**Pot life**
50°F (10°C)	4.5 hours
70°F (21°C)	2 hours
90°F (32°C)	1 hour

SAFETY PRECAUTIONS

- For paint and recommended thinners see INFORMATION SHEETS 1430, 1431 and relevant Material Safety Data Sheets

WORLDWIDE AVAILABILITY

It is always the aim of PPG Protective and Marine Coatings to supply the same product on a worldwide basis. However, slight modification of the product is sometimes necessary to comply with local or national rules/circumstances. Under these circumstances an alternative product data sheet is used.

REFERENCES

• CONVERSION TABLES	INFORMATION SHEET	1410
• EXPLANATION TO PRODUCT DATA SHEETS	INFORMATION SHEET	1411
• SAFETY INDICATIONS	INFORMATION SHEET	1430
• SAFETY IN CONFINED SPACES AND HEALTH SAFETY, EXPLOSION HAZARD – TOXIC HAZARD	INFORMATION SHEET	1431

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AMERCOAT® 320 HSA

Packaging: Available in 5-gallon kits

Product code	Description
AT320-10	Bahama Beige Base
AT320-218	Gray RAL 7035
AT320-419	Railcar Blue Base
AT320-B	Hardener