AMERCOAT® 68 HS VOC

DESCRIPTION

Low VOC Zinc Rich Epoxy Primer

PRINCIPAL CHARACTERISTICS

- >85% zinc in dry film
- Provides outstanding corrosion resistance
- Fast dry times for rapid topcoating
- AMERCOAT 861 accelerator can be used for low temperature curing
- Compliant with California SCAQMD Rule 1113

COLOR AND GLOSS LEVEL

- Reddish gray
- Flat

BASIC DATA AT 68°F (20°C)

Data for mixed product	
Number of components	Three
Volume solids	70 ± 2%
VOC (Supplied)	max. 0.7 lb/US gal (approx. 84 g/l)
Recommended dry film thickness	2.0 - 5.0 mils (50 - 125 µm) depending on system
Theoretical spreading rate	374 ft^2/US gal for 3.0 mils (14.0 m^2/l for 76 µm)
Shelf life	Base: at least 36 months when stored cool and dry Hardener: at least 24 months when stored cool and dry Powder: at least 36 months when stored cool and dry

Notes:
- See ADDITIONAL DATA – Overcoating intervals
- See ADDITIONAL DATA – Curing time

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

- Coating performance is proportional to the degree of surface preparation. All previous coats must dry and free of contaminants

AMERCOAT® 68 HS VOC

Steel

- Abrasive Blast to SSPC SP-6 or higher with a 1.0-3.0 mil surface profile
- Higher surface profiles up to 5 mils (125 µm) are acceptable, but the product must be applied in a thickness great enough to achieve a minimum of 2.5 mils (65 µm) dry film thickness
- Apply this product as soon as possible to prevent blasted surface from rusting.
- Keep moisture, oil, grease and other organic matter off surface before coating
- For touch up and repair, power tool cleaning in accordance with SSPC SP-11 is acceptable

Substrate temperature and application conditions

- Surface temperature during application should be between 50°F (10°C) and 120°F (49°C)
- With accelerator: Surface temperature during application should be between 32°F (0°C) and 100°F (38°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 50°F (10°C) and 120°F (49°C)
- With accelerator: Ambient temperature during application and curing should be between 32°F (0°C) and 100°F (38°C)
- Relative humidity during application and curing should not exceed 85%

Note: Product can be applied without accelerator at surface and air temperatures down to 40°F. Material temperature must be maintained at 60 to 90°F at the time of application. Due to the long curing time at this temperatures when accelerator is not used, it is recommended that temperatures above 50°F are expected within 12 hours of application. Coated surfaces should be protected from moisture until dry through time is reached.

SYSTEM SPECIFICATION

- Primers: Direct to metal, can be used to touch up inorganic zincs such as DIMETCOTE 9-SERIES
- Topcoats: AMERSHIELD VOC, PSX 700, AMERCOAT 450H, AMERLOCK 2/400 VOC, AMERCOAT 385, AMERCOAT 370, PITTHANE Series Urethanes, PITTGUARD Epoxies

INSTRUCTIONS FOR USE

Mix as packaged

- Pre-mix base component with a pneumatic air mixer at moderate speeds to homogenize the container. Add hardener to base and agitate with a power mixer for 1-2 minutes until completely dispersed. Add powder component slowly under agitation until fully mixed. Strain the mixture from one container to another through a 30 mesh filter/strainer to remove any undispersed lumps

Pot life

9 hours at 70°F (21°C)

Notes:

- Maintain agitation throughout application to prevent settling of the zinc. Protect product from moisture contamination
- See ADDITIONAL DATA – Pot life

AMERCOAT® 68 HS VOC

Application
- Area should be sheltered from airborne particulates and pollutants
- 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 50°F (10°C) and 90°F (32°C)

Air spray
- Use standard conventional equipment
- Separate air and fluid pressure regulators and a moisture and oil trap in the main air supply line are recommended.
- Hoses should normally be kept as short as possible
- Maintain continuous agitation to keep zinc in suspension

Recommended thinner
THINNER 21-85 (PPG 97-739 (exempt)), THINNER 21-06 (AMERCOAT 65 (xylene)), THINNER 21-25 (AMERCOAT 101) recommended for > 90°F (32°C))

Volume of thinner
0 - 10%

Nozzle orifice
Approx. 0.070 in (1.8 mm)

Airless spray
- 45:1 pump or larger
- Hoses should normally be kept as short as possible
- Maintain continuous agitation to keep zinc in suspension

Recommended thinner
THINNER 21-85 (PPG 97-739 (exempt)), THINNER 21-06 (AMERCOAT 65 (xylene)), THINNER 21-25 (AMERCOAT 101) recommended for > 90°F (32°C))

Volume of thinner
0 - 5%

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

AMERCOAT® 68 HS VOC

Brush/roller

- Use a high-quality natural-bristle brush. Brush application is only recommended for small touch-up and/or repair areas. Roller application is not recommended
- Ensure the brush/roller is well-loaded to avoid air entrainment. Level air bubbles with a brush. Multiple coats may be necessary to achieve adequate film build

Recommended thinner

PPG 97-739 (exempt), AMERCOAT 65 (xylene), AMERCOAT 101 (recommended for > 90°F (32°C))

Cleaning solvent

AMERCOAT 12, 12E, or 12V Cleaner, 97-739, AMERCOAT 65 thinner (xylene)

ADDITIONAL DATA

Overcoating interval for DFT up to 3.0 mils (75 µm)					
Overcoating with...	**Interval**	**32°F (0°C)**	**50°F (10°C)**	**70°F (21°C)**	**90°F (32°C)**
various two-pack epoxy and polyurethane coatings	Minimum	Not recommended	6 hours	2 hours	1 hour
	Maximum	Unlimited	Unlimited	Unlimited	Unlimited

Note: Surface must be power washed as needed to remove all surface contaminants including zinc salts. Surface must be clean and dry

overcoating interval for dft up to 3.0 mils using Amercoat 861 Accelerator					
Overcoating with...	**Interval**	**32°F (0°C)**	**50°F (10°C)**	**70°F (21°C)**	**90°F (32°C)**
various two-pack epoxy and polyurethane coatings	Minimum	24 hours	4 hours	1.5 hours	45 minutes
	Maximum	Unlimited	Unlimited	Unlimited	Unlimited

Notes:

- Surface must be power washed as needed to remove all surface contaminants including zinc salts. Surface must be clean and dry
- With force cure capabilities (oven temperatures of 140°F (60°C) to 180°F (82°C)), product can be overcoated after 5-15 minutes. Allow 5-10 minutes flash off prior to heating past 120°F (49°C). Addition of AMERCOAT 861 accelerator is recommended for this procedure.

Curing time for DFT up to 3.0 mils (75 µm)		
Substrate temperature	**Dry to touch**	**Dry to handle**
40°F (4°C)	6 hours	3 days
50°F (10°C)	1 hour	36 hours
70°F (21°C)	30 minutes	8 hours
90°F (32°C)	15 minutes	4 hours

AMERCOAT® 68 HS VOC

Curing time with AMERCOAT 861 accelerator for DFT up to 3.0 mils (75 µm)		
Substrate temperature	**Dry to touch**	**Dry to handle**
32°F (0°C)	2 hours	4 days
50°F (10°C)	30 minutes	16 hours
70°F (21°C)	20 minutes	4 hours
90°F (32°C)	10 minutes	1.5 hours

Pot life (at application viscosity)	
Mixed product temperature	**Pot life**
50°F (10°C)	24 hours
70°F (21°C)	16 hours
90°F (32°C)	8 hours

Pot life (at application viscosity) with AMERCOAT 861 accelerator	
Mixed product temperature	**Pot life**
50°F (10°C)	16 hours
70°F (21°C)	9 hours
90°F (32°C)	5 hours

Product Qualifications

- SSPC Paint 20, Type IC, Level 1
- Zinc dust meets ASTM D520 type 2 standards

SAFETY PRECAUTIONS

- For paint and recommended thinners see INFORMATION SHEETS 1430, 1431 and relevant Material Safety Data Sheets
- This is a solvent-borne paint and care should be taken to avoid inhalation of spray mist or vapor, as well as contact between the wet paint and exposed skin or eyes

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.

AMERCOAT® 68 HS VOC

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

WARRANTY

PPG warrants (i) its title to the product, (ii) that the quality of the product conforms to PPG's specifications for such product in effect at the time of manufacture and (iii) that the product shall be delivered free of the rightful claim of any third person for infringement of any U.S. patent covering the product. THESE ARE THE ONLY WARRANTIES THAT PPG MAKES AND ALL OTHER EXPRESS OR IMPLIED WARRANTIES, UNDER STATUTE OR ARISING OTHERWISE IN LAW, FROM A COURSE OF DEALING OR USAGE OF TRADE, INCLUDING WITHOUT LIMITATION, ANY OTHER WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE OR USE, ARE DISCLAIMED BY PPG. 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 of the product, or one year from the date of the delivery of the product to the Buyer, whichever is earlier. Buyer's failure to notify PPG of such non-conformance as required herein shall bar Buyer from recovery under this warranty.

LIMITATIONS OF LIABILITY

IN NO EVENT WILL PPG BE LIABLE UNDER ANY THEORY OF RECOVERY (WHETHER BASED ON NEGLIGENCE OF ANY KIND, STRICT LIABILITY OR TORT) FOR ANY INDIRECT, SPECIAL, INCIDENTAL, OR CONSEQUENTIAL DAMAGES IN ANY WAY RELATED TO, ARISING FROM, OR RESULTING FROM ANY USE MADE OF THE PRODUCT. The information in this sheet is intended for guidance only and is based upon laboratory tests that PPG believes to be reliable. PPG may modify the information contained herein at any time as a result of practical experience and continuous product development. All recommendations or suggestions relating to the use of the PPG product, whether in technical documentation, or in response to a specific inquiry, or otherwise, are based on data, which to the best of PPG's knowledge, is reliable. The product and related information is designed for users having the requisite knowledge and industrial skills in the industry and it is the end-user's responsibility to determine the suitability of the product for its own particular use and it shall be deemed that Buyer has done so, as its sole discretion and risk. PPG has no control over either the quality or condition of the substrate, or the many factors affecting the use and application of the product. Therefore, PPG does not accept any liability arising from any loss, injury or damage resulting from such use or the contents of this information (unless there are written agreements stating otherwise). Variations in the application environment, changes in procedures of use, or extrapolation of data may cause unsatisfactory results. This sheet supersedes all previous versions and it is the Buyer's responsibility to ensure that this information is current prior to using the product. Current sheets for all PPG Protective & Marine Coatings Products are maintained at www.ppgpmc.com. The English text of this sheet shall prevail over any translation thereof.

Packaging: Available in 1-gallon and 5-gallon kits

Product code	Description
AT68HSV-A	Base
AT68HSV-B	Hardener
AT68HSV-P	Zinc Powder