

AMERLOCK® 400 BF

DESCRIPTION

Two-component, epoxy masonry block filler

PRINCIPAL CHARACTERISTICS

- Low VOC
- Suitable for wet environments

COLOR AND GLOSS LEVEL

- Offwhite

Note: Epoxy coatings will characteristically chalk and fade upon exposure to sunlight. Light colors are prone to ambering to some extent

BASIC DATA AT 68°F (20°C)

Data for mixed product	
Number of components	Two
Volume solids	75 ± 2%
VOC (Supplied)	max. 1.7 lb/US gal (approx. 199 g/l)
Recommended dry film thickness	10.0 - 20.0 mils (250 - 500 µm) depending on system
Theoretical spreading rate	120 ft ² /US gal for 10.0 mils (3.0 m ² /l for 250 µm)
Shelf life	Base: at least 36 months when stored cool and dry Hardener: 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

Masonry

- Clean surface in accordance with ASTM D 4261 requirements to remove any surface contaminants and loose particles
- Test for moisture by conducting a plastic sheet test in accordance with ASTM D4263
- Moisture levels (including grout) should be a maximum of 12%

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Concrete

- Clean surface in accordance with ASTM D4258. Abrade the surface per ASTM D4263 guidelines. The surface should pass a plastic sheet test per ASTM D4263. Fill large voids, surface cracks, and bug holes with Amercoat 114A epoxy filler or Amercoat 965 acrylic cement.
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Substrate temperature and application conditions

- Surface temperature during application should be between 50°F (10°C) and 122°F (50°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 40°F (4°C) and 122°F (50°C)
 - Relative humidity during application should be above 0% and below 85%
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SYSTEM SPECIFICATION

- Primers: Direct to substrate
 - Topcoats: AMERCOAT 450-series polyurethanes, AMERSHIELD, PITTHANE polyurethanes, PSX 700, PSX One, AMERCOAT 220-series acrylics, PITT TECH, PITT TECH Plus, PPG Epoxies, AQUAPON WB
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INSTRUCTIONS FOR USE

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

- 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
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Induction time

None

Pot life

2.5 hours at 70°F (21°C)

Note: See ADDITIONAL DATA – Pot life

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
- Avoid combustion gases or other sources of carbon dioxide that may promote amine blush and ambering of light colors

Material temperature

Material temperature during application should be between 50°F (10°C) and 90°F (32°C)



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Airless spray

- 45:1 pump or larger
- Can be applied with plural component equipment
- Spray a wet coat over block surface
- Back roll with a saturated roller to work into block porosity

Recommended thinner

THINNER 21-06 (AMERCOAT 65) or THINNER 21-25 (AMERCOAT 101) (to reduce dry spray))

Volume of thinner

0 - 5%, depending on required thickness and application conditions

Nozzle orifice

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

Brush/roller

- Use a high quality natural bristle brush and/or solvent resistant, 3/8" nap roller. Ensure brush/roller is well loaded to avoid air entrainment. Multiple coats may be necessary to achieve adequate film-build

Recommended thinner

AMERCOAT 65 or AMERCOAT 101 (to reduce dry spray)

Volume of thinner

Up to 5% THINNER can be added if desired

Cleaning solvent

AMERCOAT 12 CLEANER or AMERCOAT 65 THINNER (xylene)



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ADDITIONAL DATA

Overcoating interval for DFT up to 10.0 mils (250 µm)				
Overcoating with...	Interval	50°F (10°C)	70°F (21°C)	90°F (32°C)
itself	Minimum	18 hours	9 hours	5 hours
	Maximum	4 months	3 months	30 days
urethane and PSX	Minimum	18 hours	9 hours	5 hours
	Maximum	30 days	21 days	14 days
Acrylics	Minimum	18 hours	9 hours	5 hours
	Maximum	7 days	4 days	48 hours

Notes:

- Dry times are dependent on air and surface temperatures as well as film thickness, ventilation, and relative humidity. Maximum recoating time is highly dependent upon actual surface temperatures – not simply air temperatures. Surface temperatures should be monitored, especially with sun-exposed or otherwise heated surfaces. Higher surface temperatures shorten the maximum recoat window
- Surface must be clean and dry. Any contamination must be identified and removed. A detergent wash with PREP 88 or equivalent is required prior to application of topcoats after 30 days of exposure. However, particular attention must be paid to surfaces exposed to sunlight where chalking may be present. In those situations, a further degree of cleaning may be required. PPG Technical Service can advise on suitable cleaning methods. If maximum recoat/topcoat time is exceeded, then roughen surface.

Curing time for DFT up to 10.0 mils (250 µm)			
Substrate temperature	Dry to touch	Dry to handle	Full cure
50°F (10°C)	6 hours	18 hours	14 days
70°F (21°C)	3 hours	9 hours	7 days
90°F (32°C)	1 hour	5 hours	4 days

Pot life (at application viscosity)	
Mixed product temperature	Pot life
50°F (10°C)	4 hours
70°F (21°C)	2.5 hours
90°F (32°C)	1.5 hours

Product Qualifications

- Compliant with USDA Incidental Food Contact Requirements
- NFPA Class A for Flame Spread and Smoke Development
- MPI Category #116
- LEED's compliant for Anti-corrosive Paint category
- Nuclear Service Level 2 (ANSI N 5.12, ANSI N 101.2)



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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.

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.

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Packaging: Available in 2-gallon and 5-gallon kits; (2-gallon kits have 1 full gallon of base and 1 full gallon of hardener; 5 gallon kits have 2.5 gallons of base and 2.5 gallons of hardener)

Product code	Description
AK400B-30	Base
AK400B-B	Hardener

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