

AMERCOAT® 68HS VOC

February 2012
Revision of November 2011

DESCRIPTION	Zinc Rich Epoxy
PRINCIPAL CHARACTERISTICS	<ul style="list-style-type: none"> – >80% zinc in dry film – Provides outstanding corrosion resistance – Fast dry times for rapid topcoating – <i>Amercoat</i> 861 accelerator can be used for low temperature curing – Complaint with California SCAQMD Rule 1113
COLOR* AND GLOSS	Flat Reddish Gray
BASIC DATA	
Volume solids	70% ± 3%
VOC	0.7 lbs/gal (84 g/L)
Recommended Dry film thickness (per coat)	2 – 5 mils (50 – 125 microns)
Theoretical Spread Rate	@ 1 mils 1123 ft ² /gal @ 3 mils 374 ft ² /gal
Components	3 (base, hardener, zinc powder)
Shelf Life	3 years from date of manufacture
SURFACE PREPARATION	<p>Coating performance is proportional to the degree of surface preparation. All previous coats must dry and free of contaminants.</p> <ul style="list-style-type: none"> – Abrasive blast to SSPC SP-6 or higher with a 1.0-3.0 mil surface profile. Higher surface profiles up to 5 mils are acceptable, but the product must be applied in a thickness great enough to achieve a minimum of 2.5 mils dry film thickness. Apply <i>Amercoat</i> 68HSVOC as soon as possible to prevent the blasted surface from rusting. Keep moisture, oil, grease, or other organic matter off surface before coating. For touch up and repair, power tool cleaning in accordance with SSPC SP-11 is acceptable.
ENVIRONMENTAL CONDITIONS	
Ambient temperatures	<p><i>Amercoat</i> 68HS VOC 50°F to 120°F (10°C to 49°C) <i>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.</i></p> <p>With <i>Amercoat</i> 861 Accelerator 32° to 100°F (0°C to 36°C) Surface temperature must be at least 5°F above the dew point temperature.</p>
Material temperatures	50°F to 90°F (10°C to 32°C)
Relative humidity	85% maximum
Surface temperature	50°F to 120°F (10°C to 49°C) With <i>Amercoat</i> 861 Accelerator 32°F to 100°F (0°C to 36°C) Surface temperature must be at least 5°F above the dew point temperature.
General air quality	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.

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INSTRUCTIONS FOR USE

Mixing

Only mix full kits.

Pre-mix base component with a pneumatic air mixing 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

Temperature	50°F	70°F	90°F
Amercoat 68HS VOC	24 hours	16 hours	8 hours
Amercoat 68HS VOC with 861 accelerator	16 hours	9 hours	5 hours

Airless spray

45:1 pump or larger, 0.017-0.019 fluid tip

Air spray

Thin up to 10%, standard conventional equipment, 0.070" fluid orifice. A moisture and oil trap in the main line is recommended. Separate regulators for air and fluid pressure are recommended.

Brush & roll

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

Thinner

97-739 (exempt thinner), Amercoat 65 (xylene), Amercoat 101 (recommended for > 90°F),

Cleaning solvent

Amercoat 12, 12E, or 12V Cleaner, 65 thinner, 97-739 thinner

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

Safety precautions

For paint and recommended thinners see safety sheet 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.

DRY/CURE TIMES*

Amercoat 68HS VOC @ 3 mils dft

	40°F	50°F	70°F	90°F
Dry to touch	6 hours	1 hours	30 minutes	15 minutes
Dry through	72 hours	36 hours	8 hours	4 hours
Dry to overcoat*	36 hours	6 hours	2 hours	1 hour
Maximum overcoat	Unlimited**			

* With force cure capabilities (oven temperatures of 140-180°F), product can be overcoated after 5-15 minutes. Allow 5-10 minutes flash off prior to heating past 120°F. Addition of Amercoat 861 accelerator is recommended for this procedure.

Amercoat 68HS VOC with 861 Accelerator @ 3 mils dft

	32°F	50°F	70°F	90°F
Dry to touch	2 hours	30 minutes	20 minutes	10 minutes
Dry through	96 hours	16 hours	4 hours	1.5 hours
Dry to overcoat	24 hours	4 hours	1.5 hours	45 minutes
Maximum overcoat	Unlimited**			

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

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PRODUCT QUALIFICATIONS

- SSPC Paint 20, Type II , Level 2
- Zinc Dust meets ASTM D520 Level 2 standards

AVAILABILITY

Packaging

Available in 1-gallon and 5-gallon kits

Product codes

AT68HSV-A Base component
AT68HSV-B Hardener component
AT68HSV-P Zinc Powder component

Worldwide statement

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