

AMERCOAT® 68HS

May 2013
Revision of April 2013

DESCRIPTION	Zinc Rich Epoxy Primer
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 861</i> accelerator can be used for low temperature curing
COLOR AND GLOSS	Flat Reddish Gray, Green <i>* Green color will be Made-To-Order.</i>
BASIC DATA	
Volume solids	70% ± 3%
VOC*	2.4 lbs/gal (288 g/L) <i>* For compliance with regulations which require <100 g/L, Amercoat 68HS VOC can be specified interchangeably.</i>
Recommended Dry film thickness	2 – 5 mils per coat (50 – 125 microns)
Theoretical Spread Rate	@ 1 mils 1123 ft ² /gal @ 3 mils 374 ft ² /gal
Components	3
Dry Temperature Resistance*	Continuous — 400°F (<5% of the time, max 24 hours) <i>* Color will drift at elevated temperatures.</i>
Shelf Life	Base and Hardener – 3 years from date of manufacture Zinc Powder – 2 years from date of manufacture <i>* when stored in original sealed containers in dry conditions between 40-100°F</i>
SURFACE PREPARATION	Coating performance is proportional to the degree of surface preparation. All previous coats must dry and free of contaminants.
Steel	<ul style="list-style-type: none"> – Abrasive blast to SSPC SP-6 or higher with a 1.0 – 3.0 mils 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 68HS</i> 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	<i>Amercoat 68HS</i> 32°F to 120°F (0°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 for application below 50°F. 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> Surface temperature must be at least 5°F above the dew point temperature.
Material temperatures	50°F to 90°F (10°C to 32°C)
Relative humidity	85% maximum
Surface temperature	<i>Amercoat 68HS</i> 40°F to 120°F (5°C to 49°C) With <i>Amercoat 861</i> Accelerator 32°F to 100°F (0°C to 36°C) Surface temperature must be at least 5°F above the dew point temperature. Extreme caution should be taken to ensure there is no ice on the surface in cold weather.

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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.

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	24 hours	16 hours	8 hours
Amercoat 68HS with 861 accelerator	16 hours	9 hours	5 hours

Airless spray

45:1 pump or larger, 0.017 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

Amercoat 65 (xylene), Amercoat 101 (recommended for > 90°F),

Cleaning solvent

Amercoat 12 Cleaner or Amercoat 65 thinner (xylene)

Primers

Direct to metal, can be used to touch up inorganic zincs such as Dimetcote 9-Series.

Topcoats

Amershield, PSX 700, Amercoat 450H, Amerlock 2/400, Amercoat 385, Amercoat 370, Amercoat Epoxies, Pittguard Epoxies, Durathane DTM, Pitthane Ultra

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 @ 3 mils dft

	40°F	50°F	70°F	90°F
Dry to touch	6 hours	1 hour	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 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
- RCSC Class B Slip Coefficient for High Strength Bolted Connections
- Zinc Dust meets ASTM D520 Type 2 standards

AVAILABILITY

Packaging*

Available in 1-gallon, 4-gallon and 5-gallon** units

Component	1-gallon kit Codes	4-gallon kit Codes	5-gallon kit Codes
Reddish Gray Base component	AT68HS-A/01	AT68HS-A4G/05	AT68HS-A/05
Green Base component	AT68HS-5/01		AT68HS-5/05
Hardener component	AT68HS-B/04	AT68HS-B4G/01	AT68HS-B/01
Zinc Powder component	AT68HS-P/01	AT68HS-P4G/05	AT68HS-P/05

* Do not mix components of different kit sizes.

** 5-gallon units are to be discontinued Jan 2013

Product codes

AT68HS-A Reddish Gray Base component
 AT68HS-5 Green Base component
 AT68HS-B Hardener component
 AT68HS-P Zinc Powder component

Worldwide statement

While it is always the aim of PPG Protective & Marine Coatings to supply the same product on a worldwide basis, 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.

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