

AMERCOAT® 450H

October 2012
Revision of June 2012

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|--|---|---------|------|------|---------|---------|---------|
| DESCRIPTION | Gloss Acrylic Aliphatic Polyurethane Topcoat | | | | | | |
| PRINCIPAL CHARACTERISTICS | <ul style="list-style-type: none"> - High gloss topcoat with unlimited recoatability - Outstanding weather resistance with excellent color and gloss retention - VOC compliant - Hard, flexible, and abrasion resistant - Cures through a wide temperature range | | | | | | |
| COLOR AND GLOSS | Gloss Standard Color Offering, Safety Colors, Custom Colors | | | | | | |
| BASIC DATA | | | | | | | |
| Volume solids | 67% ± 3% | | | | | | |
| VOC | 2.6 lbs/gal (311 g/L) | | | | | | |
| Recommended Dry film thickness (per coat) | 2 – 5 mils (50 – 125 microns) | | | | | | |
| Theoretical Spread Rate | @ 1 mils dft 1074 ft ² /gal @ 2 mils dft 537 ft ² /gal | | | | | | |
| Components | 2 | | | | | | |
| Dry Temperature Resistance* | Continuous — 200°F Intermittent — 250°F (<5% of the time, max 24 hours) * Color will drift at elevated temperatures. | | | | | | |
| Shelf Life | 2 years from date of manufacture * when stored in original sealed containers in dry conditions between 40-100°F | | | | | | |
| SURFACE PREPARATION | Coating performance is proportional to the degree of surface preparation. Refer to the application instructions for specific primers and intermediate coats for application and curing procedures. Ensure epoxies are free from amine blush prior to overcoating. All previous coats must dry and free of contaminants. Adhere to all minimum and maximum topcoat times for specific primers and intermediate coats. Aged epoxy coatings may require abrading prior to applying <i>Amercoat</i> 450H. | | | | | | |
| ENVIRONMENTAL CONDITIONS | | | | | | | |
| Ambient temperatures | 20°F to 120°F (-6°C to 49°C) Surface temperature must be at least 5°F above dew point temperature. | | | | | | |
| Material temperatures | 40°F to 90°F (5°C to 32°C) | | | | | | |
| Relative humidity | 85% maximum | | | | | | |
| Surface temperature | 20°F to 120°F (-6°C to 49°C) | | | | | | |
| 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 ratio by volume | 4 parts base to 1 part hardener 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. | | | | | | |
| Pot life | <table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 33%;">50°F</td> <td style="width: 33%;">70°F</td> <td style="width: 33%;">90°F</td> </tr> <tr> <td>6 hours</td> <td>4 hours</td> <td>2 hours</td> </tr> </table> | 50°F | 70°F | 90°F | 6 hours | 4 hours | 2 hours |
| 50°F | 70°F | 90°F | | | | | |
| 6 hours | 4 hours | 2 hours | | | | | |
| Airless spray | 28:1 pump or larger, 0.013-0.015 fluid tip Can be applied with plural component equipment | | | | | | |
| Air spray | Thin up to 20%, standard conventional equipment, 0.070" fluid orifice. A moisture and oil trap in the main line is essential. Product is sensitive to moisture contamination. | | | | | | |

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- Brush & roll Use a high quality natural bristle brush and / or solvent resistant, 1/4" or 3/8" nap roller. Ensure brush / roller is well loaded to avoid air entrainment. Multiple coats may be necessary to achieve adequate film build. *Amercoat* 851 flow control additive can be used to for enhanced flow and leveling with brush and roll application.
- Thinner *Amercoat* 923, *Amercoat* 65, *Amercoat* 101 (recommended for > 90°F)
- Cleaning solvent *Amercoat* 12 Cleaner or thinner
- Primers *Amercoat* 68HS, *Amercoat* 68MCZ, *Amercoat* 370, *Amercoat* 385, *Amercoat* 399, *Amerlock* 2/400, *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 450H @ 2 mils dft

| | 32°F | 50°F | 70°F | 90°F |
|----------------|-----------|------------|------------|------------|
| Dry to touch | 4 hours | 90 minutes | 45 minutes | 20 minutes |
| Dry through | 72 hours | 24 hours | 8 hours | 4 hours |
| Dry to recoat | 24 hours | 12 hours | 4 hours | 2 hours |
| Maximum recoat | Unlimited | | | |

Amercoat 450H with 866M Accelerator @ 2 mils dft

| | 20°F | 32°F | 50°F | 70°F | 90°F |
|----------------|-----------|----------|------------|------------|------------|
| Dry to touch | 8 hours | 4 hours | 75 minutes | 25 minutes | 10 minutes |
| Dry through | 72 hours | 36 hours | 8 hours | 2.5 hours | 1.75 hours |
| Dry to recoat | 32 hours | 16 hours | 4 hours | 1.5 hours | 1 hour |
| Maximum recoat | Unlimited | | | | |

PRODUCT QUALIFICATIONS

- Compliant with USDA Incidental Food Contact Requirements
- SSPC Paint 36 Level 3

AVAILABILITY

Packaging

Available in 1-gallon and 5-gallon kits
 1-gallon kits have 0.8 gallons of base and 0.2 gallons of hardener
 5- gallon kits have 4 gallons of base and 1 gallon of hardener

Product codes

- AT 45H-23 Pearl Gray base
- AT 45H-3 White base
- AT 45H-9 Black base
- AT 45H-T1 Deep tint base *
- AT 45H-T2 Light tint base *
- AT 45H-T3 Neutral tint base *
- AT 45H-T4 Red tint base *
- AT 45H-T5 High Hiding Yellow tint base *
- AT 45H-71 Safety Red base
- AT 45H-81 Safety Yellow base
- AT 45H-B Hardener component

* Tintable using UCD V-Line colorants only.

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