

AMERCOAT® 68 G

DESCRIPTION

Two-component, high solids polyamide adduct cured zinc rich epoxy primer

PRINCIPAL CHARACTERISTICS

- Designed as a system primer for various paint systems
- Excellent anticorrosive properties
- Quick-drying, can be overcoated after a short interval
- Can serve as a holding primer for various maintenance systems for a total repair
- Very good primer for systems with high solids epoxy buildcoats
- Complies with SSPC-Paint 20 level 2 and ISO 12944.5

COLOR AND GLOSS LEVEL

- Gray, reddish gray
- Flat

BASIC DATA AT 20°C (68°F)

| Data for mixed product | |
|--------------------------------|--|
| Number of components | Two |
| Mass density | 2.8 kg/l (23.4 lb/US gal) |
| Volume solids | 66 ± 2% |
| VOC (Supplied) | Directive 1999/13/EC, SED: max. 106.0 g/kg max. 299.0 g/l (approx. 2.5 lb/US gal) |
| Recommended dry film thickness | 50 - 150 µm (2.0 - 6.0 mils) depending on system |
| Theoretical spreading rate | 11.0 m ² /l for 60 µm (441 ft ² /US gal for 2.4 mils) |
| Dry to touch | 2.5 hours |
| Overcoating Interval | Minimum: 4 hours See overcoating tables |
| Full cure after | 7 days |
| Shelf life | Base: at least 24 months when stored cool and dry Hardener: at least 24 months when stored cool and dry |

Notes:

- See ADDITIONAL DATA – Spreading rate and film thickness
- See ADDITIONAL DATA – Overcoating intervals
- See ADDITIONAL DATA – Curing time

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RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

Immersion exposure

- Steel; blast cleaned to ISO-Sa2½, blasting profile 40 – 70 µm (1.6 – 2.8 mils)
 - Steel with approved zinc silicate shop primer; pretreated according to SPSS-Ss
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Atmospheric exposure conditions

- Steel; blast cleaned to ISO-Sa2½, blasting profile 40 – 70 µm (1.6 – 2.8 mils)
 - Steel with approved zinc silicate shop primer pretreated according to SPSS or power tool cleaned to SPSS-Pt3
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Substrate temperature

- Substrate temperature during application and curing should be above 5°C (41°F)
 - Substrate temperature during application and curing should be at least 3°C (5°F) above dew point
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SYSTEM SPECIFICATION

Standard system

- Topcoats: AMERSHIELD, PSX 700, AMERLOCK 2/400, AMERCOAT 385, AMERCOAT 370, AMERCOAT 240, AMERCOAT 235, others
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INSTRUCTIONS FOR USE

Mixing ratio by volume: base to hardener 80:20 (4:1)

- The temperature of the mixed base and hardener should preferably be above 15°C (59°F), otherwise extra thinner may be required to obtain application viscosity
 - Adding too much thinner results in reduced sag resistance and slower cure
 - Thinner should be added after mixing the components
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Induction time

None

Pot life

6 hours at 20°C (68°F)

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Air spray

Recommended thinner

THINNER 91-92

Volume of thinner

0 - 15%, depending on required thickness and application conditions

Nozzle orifice

1.8 – 2.2 mm (approx. 0.070 – 0.087 in)

Nozzle pressure

0.3 - 0.6 MPa (approx. 3 - 6 bar; 44 - 87 p.s.i.)

Airless spray

Recommended thinner

THINNER 91-92

Volume of thinner

0 - 15%, depending on required thickness and application conditions

Nozzle orifice

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

Nozzle pressure

15.0 MPa (approx. 150 bar; 2176 p.s.i.)

Brush/roller

Recommended thinner

THINNER 91-92

Volume of thinner

0 – 10%

Cleaning solvent

THINNER 90-53

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ADDITIONAL DATA

| Spreading rate and film thickness | |
|-----------------------------------|--|
| DFT | Theoretical spreading rate |
| 60 µm (2.4 mils) | 11.0 m ² /l (441 ft ² /US gal) |
| 75 µm (3.0 mils) | 8.8 m ² /l (353 ft ² /US gal) |
| 100 µm (4.0 mils) | 6.6 m ² /l (265 ft ² /US gal) |
| 150 µm (6.0 mils) | 4.4 m ² /l (176 ft ² /US gal) |

| Overcoating interval for DFT up to 100 µm (4.0 mils) | | | | | |
|--|----------|-------------|-------------|-------------|--------------|
| Overcoating with... | Interval | 10°C (50°F) | 20°C (68°F) | 30°C (86°F) | 40°C (104°F) |
| subsequent coating | Minimum | 8 hours | 4 hours | 3 hours | 2 hours |
| | Maximum | 3 months | 3 months | 3 months | 3 months |

Notes:

- Amercoat 68G may be used to repair itself or inorganic zinc coatings
- Zinc rich primers can form zinc salts on the surface; preferably they should not be weathered for long periods before overcoating
- In clean exterior conditions, a maximum interval of 3 months can be tolerated, but in industrial or marine conditions this interval should be reduced to the practical minimum
- An interval of several months can be allowed under clean interior exposure conditions
- Before overcoating visible surface contamination must be removed by high-pressure water cleaning, sweep blasting or mechanical cleaning

| Curing time for DFT up to 100 µm (4.0 mils) | | | |
|---|--------------|---------------|-----------|
| Substrate temperature | Dry to touch | Dry to handle | Full cure |
| 10°C (50°F) | 5 hours | 6 hours | 20 days |
| 15°C (59°F) | 3 hours | 4 hours | 10 days |
| 20°C (68°F) | 2.5 hours | 3 hours | 7 days |
| 30°C (86°F) | 1 hour | 1.5 hours | 5 days |

Notes:

- This product can be applied at temperatures between 5°C (41°F) and 10°C (50°F), but the curing rate will be very slow
- Adequate ventilation must be maintained during application and curing (please refer to INFORMATION SHEETS 1433 and 1434)

| Pot life (at application viscosity) | |
|-------------------------------------|-----------|
| Mixed product temperature | Pot life |
| 10°C (50°F) | 12 hours |
| 20°C (68°F) | 6 hours |
| 30°C (86°F) | 4.5 hours |
| 40°C (104°F) | 3 hours |

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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 |
| • SAFE WORKING IN CONFINED SPACES | INFORMATION SHEET | 1433 |
| • DIRECTIVES FOR VENTILATION PRACTICE | INFORMATION SHEET | 1434 |
| • CLEANING OF STEEL AND REMOVAL OF RUST | INFORMATION SHEET | 1490 |
| • SPECIFICATION FOR MINERAL ABRASIVES | INFORMATION SHEET | 1491 |
| • RELATIVE HUMIDITY – SUBSTRATE TEMPERATURE – AIR TEMPERATURE | INFORMATION SHEET | 1650 |

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