

# AMERCOAT® 71 TC

## DESCRIPTION

Two-component, polyamide-cured epoxy tiecoat

## PRINCIPAL CHARACTERISTICS

- Forms durable coating systems with a wide range of topcoats for immersion and non-immersion services
- Excellent adhesion to steel, shop primer, galvanized steel and non-ferrous metals
- Suitable as tiecoat over DIMETCOTE

## COLOR AND GLOSS LEVEL

- Offwhite
- Flat

## BASIC DATA AT 20°C (68°F)

Data for mixed product	
Number of components	Two
Mass density	1.3 kg/l (10.7 lb/US gal)
Volume solids	51 ± 2%
VOC (Supplied)	Directive 2010/75/EU, SED: max. 381.0 g/kg UK PG 6/23(92) Appendix 3: max. 435.0 g/l (approx. 3.6 lb/US gal)
Recommended dry film thickness	50 - 100 µm (2.0 - 4.0 mils)
Theoretical spreading rate	10.2 m²/l for 50 µm (409 ft²/US gal for 2.0 mils) 5.1 m²/l for 100 µm (205 ft²/US gal for 4.0 mils)
Dry to touch	2 hours
Overcoating Interval	Minimum: 4 hours
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 – Overcoating intervals
- See ADDITIONAL DATA – Curing time

## RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

### Substrate conditions

- Steel; blast cleaned to ISO Sa 2½ or SSPC-SP-10, blasting profile 25 – 50 µm (1.0 – 2.0 mils)
- Previous suitable coat must be dry and free from any contamination
- Refer to application instructions for the particular DIMETCOTE for any other special topcoating requirements

Note: Apply primer as soon as possible after surface preparation to prevent any contamination.



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## **Galvanized steel and aluminum**

- Galvanized steel must be free from grease, salts and any contamination
- If galvanizing has been exposed to exterior weathering for 6 months or more, remove zinc corrosion products by mechanical means (like power sander or a light blast).
- Aluminum must be dry and free from any contamination
- A light blast with fine abrasive is required

Note: Apply primer as soon as possible after surface preparation to prevent any contamination.

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## **Substrate temperature and application conditions**

- Surface temperature during application should be between 5°C (41°F) and 60°C (140°F)
  - Surface temperature during application should be at least 3°C (5°F) above dew point
  - Ambient temperature during application and curing should be between 5°C (41°F) and 50°C (122°F)
  - Relative humidity during application should not exceed 85%
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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
  - Add hardener to base and continue stirring until homogeneous
  - The thinner should be added after mixing the two components
  - Adding too much thinner results in reduced sag resistance
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### **Induction time**

None

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### **Pot life**

4 hours at 20°C (68°F)

Note: See ADDITIONAL DATA – Pot life

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### **Air spray**

#### **Recommended thinner**

THINNER 91-83

#### **Volume of thinner**

0 - 10%, depending on required thickness and application conditions

#### **Nozzle orifice**

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

#### **Nozzle pressure**

0.40 - 0.60 MPa (approx. 4 - 6 bar; 58 - 87 p.s.i.)

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## Airless spray

### **Recommended thinner**

THINNER 91-83

### **Volume of thinner**

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

### **Nozzle orifice**

Approx. 0.38 – 0.53 mm (0.015 – 0.021 in)

### **Nozzle pressure**

20.7 MPa (approx. 207 bar; 3003 p.s.i.)

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## Brush/roller

### **Recommended thinner**

THINNER 91-83

### **Volume of thinner**

0 – 10%

Note: Typically 40–50 microns (1.6–2.0 mils) dry film thickness can be applied in one coat

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## Cleaning solvent

THINNER 90-53 or THINNER 90-58

Note: All application equipment must be cleaned immediately after use

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## **ADDITIONAL DATA**

Overcoating interval for DFT up to 50 µm (2.0 mils)					
Overcoating with...	Interval	10°C (50°F)	20°C (68°F)	30°C (86°F)	40°C (104°F)
various two-pack epoxy and polyurethane coatings	Minimum	8 hours	4 hours	2 hours	1 hour
	Maximum	Unlimited	Unlimited	Unlimited	Unlimited

Note: This product has an unlimited maximum overcoating interval provided the surface is free from chalking and other contamination, in which case it should be cleaned and roughened up to ensure good adhesion of subsequent coat

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**Curing time for DFT up to 50 µm (2.0 mils)**

Substrate temperature	Dry to touch	Dry to handle
10°C (50°F)	4 hours	8 hours
20°C (68°F)	2 hours	4 hours
30°C (86°F)	1 hour	2 hours
40°C (104°F)	30 minutes	1 hour

**Notes:**

- Drying times are dependent on air and steel temperature, applied film thickness, ventilation and other environmental conditions
- Times are proportionally shorter at higher temperature and longer at lower temperatures

**Pot life (at application viscosity)**

Mixed product temperature	Pot life
20°C (68°F)	4 hours
30°C (86°F)	3 hours
35°C (95°F)	2 hours

Note: The pot life and drying/curing times are dependent on site conditions: volume of material mixed, ambient and substrate temperatures, weather and ventilation

**SAFETY PRECAUTIONS**

- Since improper use and handling can be hazardous to health and cause of fire or explosion, safety precautions included with Product Data/Application Instruction and Material Safety Data Sheet must be observed during all storage, handling, use and drying periods
- Adequate ventilation to remove solvent must be maintained during application and curing

**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.

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