



AMERCOAT 68HS

Two Pack Epoxy Zinc Rich Primer

Data Sheet No: 68 HS

Supersedes: 09/07

Revised: 05/08

Composition	Epoxy resin heavily pigmented with zinc dust pigment, polyamide cured.			
Approvals	Complies with SSPC Paint specification No. 20, Type II AISC – specification for structural joints using ASTM A325 or A490 Bolts RCSC specification for structural joints table 3 class B. Slip coefficient 0.59.			
Uses and Properties	AMERCOAT 68HS is an organic zinc rich primer with excellent adhesion to prepared steel. The high zinc content of the dry film offers cathodic protection. The epoxy resin confers moisture and abrasion resistance and ability to retain many heavy-duty topcoats. AMERCOAT 68HS primes steel in the field or is used in the yard as an excellent primer for multi-coat systems. May be left for extended time without topcoating in non-acidic conditions. AMERCOAT 68HS may be topcoated with a wide variety of coatings, including epoxy, iso-free, polyurethane and PSX 700 engineered polysiloxane.			
Typical Applications	Steel industry - Paper industry - Shipping industry - Oil industry - Chemical industry – Mining industry - Rolling stock - Food and beverage Industry - Marine and industrial environment -Repair to galvanizing			
Typical Systems	Substrate	Surface Preparation	Typical Systems	DFT μm
	Steel Atmospheric Service ②	For long life in severe or very severe environment, blast clean to AS 1627.4 Class 2½ ①	AS/NZS 2312-System EHB4 1st Coat: AMERCOAT 68HS 2nd/3rd Coats: AMERLOCK 2K MIO	75 200
		For long life service in severe marine or tropical environments blast clean to AS1627.4 Class 2 ½	AS/NZS 2312-System PSL1 1 st Coat: AMERCOAT 68HS 2 nd Coat: PSX 700	75 125
		For medium life in severe environment blast to AS1627.4 Class 2 or better, acid descale to AS 1627.5 or power tool clean to AS1627.2 (thorough).	AS/NZS 2312-System PUR4 1st Coat: AMERCOAT 68HS 2nd Coat: AMERCOAT 385 3rd Coat: AMERCOAT 450K	75 100 50
	Post-fabrication ③	Grind welds, scrub and wash, then power tool clean to AS1627.2 (thorough). Abrasive blast cleaning does give superior life. Spot prime with AMERCOAT 68HS.	Further coat AMERCOAT 68HS Subsequent coats of selected system	50
<p>① Coating performance, in general is proportional to the degree of surface preparation. Surface must be clean, dry and free of all contaminants. Apply Amercoat 68HS as soon as possible to prevent blasted surface from rusting.</p> <p>② This phrase and the terms relating to "Life" and "environment" are as defined in AS 2312 "Protection of Iron and Steel against Atmospheric Corrosion".</p> <p>③ That is after welding or gas cutting has burnt the pre-fab primer.</p>				
Finish	Matt			
Colour	Metallic Grey			
Weathering	Excellent			
Chemical Resistance	Good. Consult PPG Protective and Marine Coatings for specific information. Not resistant to acids or alkalis			
Immersion	Not recommended.			
Abrasion Resistance	Good			
Temperature Range	Up to 200°C (dry heat)			
Topcoating	May be top coated with AMERCOAT 385, AMERCOAT 370, AMERLOCK 400 / 2K, AMERSHIELD and PSX 700. AMERCOAT 68HS may be used to repair itself, inorganic zinc primers or galvanizing.			
Shelf Life	12 months from date of shipment if stored indoors between 4 to 38 °C for both the Base and Hardener.			

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Application Data					
Volume Solids	70% ± 3% (ASTM D2697 modified)				
Theoretical Coverage	8.8 m ² per litre at 75 µm DFT. Material losses during mixing and application will vary and must be considered when estimating requirements.				
Pot Life (hours)		32°C	21°C	10°C	
	Non-accelerated	8	16	24	
	Accelerated	5	9	16	
Environmental	Air	0 to 49°C			
	Surface	0 to 60°C			
	Material (minimum)	10°C			
	Base and Hardener must be a minimum of 10 °C before mixing. For satisfactory cure, air and surface temperatures must be above 10 °C. Use AMERCOAT 861 Accelerator when air and surface temperatures are below 10 °C. Surface temperatures must be a minimum of 3 °C above the dew point to prevent condensation.				
Drying Time (hours) (ASTM D1640)		32°C	21°C	10°C	0°C
	Non-accelerated - Touch	¼	½	1	NR (1)
	Through	4	8	36	NR
	Topcoat (minimum)	1	2	6	NR
	Topcoat (maximum months)	6	6	6	
	Accelerated (2) - Touch	-	⅓	½	2
	Through	1 ½	4	16	96
	Topcoat (minimum)	¾	1½	4	24
	Topcoat (maximum months)	6	6	6	6
(1) NR = Not Recommended. (2) Accelerated using Amercoat 861 at 30 mL per 5 L of mixed material.					
The figures quoted for pot life and drying / curing times are not definitive. They are dependent on site conditions, such as volume of material mixed, ambient and steel temperatures, weather and ventilation.					
Mixing	Stir each component separately, then mix the Hardener into the Base and power mix until uniform. Allow material to digest for 15 minutes before thinning and use. Only use an air or explosion proof electric motor.				
Mixing Ratio	4 Parts Base to 1 part Hardener by volume.				
Thinners	Thin up to 10% by volume using THINNER 737. Use THINNER 304 for clean up.				
Equipment	The following is a guide; suitable equipment from other manufacturers may be used. Changes in pressure, hose and tip size may be needed for proper spray characteristics.				
Conventional Spray	Industrial equipment such as DeVilbiss MBC or JGA. A moisture and oil trap in the main air supply, mechanical pot agitator, separate regulators for air and fluid pressure are recommended.				
Airless Spray	Standard equipment such as Graco Bulldog Hydra-Spray or larger with a 0.017-inch tip with pre-orifice or fine finish tip.				
	Notes: (1) Maintain slow agitation during application to ensure the material remains uniformly blended. (2) Typical DFT is 75 µm in one coat, however, DFT up to 150 µm in one coat is acceptable. Do not exceed 175 µm in one coat as excess dry film thickness may result in increased mechanical damage during handling or shipping. (3) If AMERCOAT 68HS is not overcoated for some time, it is important that surface be washed and scrubbed with a nylon brush prior to topcoating to remove deposits and white rust.				
Safety Precautions	Always read the label and Material Safety Data Sheet before use. When applying by brush or roller, provide adequate ventilation. When applying by spray, users must comply with relevant spray painting regulations and wear appropriate respirator to avoid inhaling vapours and spray mist.				

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