

SYSTEM 12



DOMESTIC FLEET

CONVERSION FROM VINYL & ENAMELS TO EPOXY/URETHANE

AREAS TO BE COATED:

SPOT MAINTENANCE

Existing Vinyl System or Enamel System

All areas on an aged existing vinyl or enamel system that will be converted to an epoxy/urethane system.

SURFACE PREPARATION:

1. Pressure detergent wash all surfaces to remove all surface contaminants. Freshwater rinse to remove all soap residues.
2. Abrasive blast all corrosion to Commercial standards (SSPC-SP10).
3. If blasting cannot be done, power tool clean all areas of rust and loose paint to bare metal(SSPC-SP11).

Coating System								
Coating Sequence	Product Identification	Film Thickness Per Coat		Overcoat interval @ 70°F		thinner	VOC	% Solids
		Wet	Dry	Min.	Max.			
1st Coat (spot prime bare metal)	Amerlock 400 Haze Green	6-8	5-6	16 hrs	3 mos.	#65	1.5	83%
Stripe Coat & spot prime	Amerlock 400 DODI Gray	6-8	5-6	16 hrs	3 mos	#65	1.5	83%
2nd Coat Tie Coat	Amerlock 400 Ivory	4-5	3-4	12 hrs	3 mos	#65	1.5	83%
3rd Coat	Amercoat 450H (color desired)	3 to 4	2-3	4 hrs	unlimited	#101	2.6	67

1. Amerlock 400 Haze Green to be applied over bare metal areas with only a 2-3 inch overlap over the existing coating.
2. Stripe coat all weldseams, edges, lips, crevices, nuts and bolts and hard to get areas in addition to the spot primed areas with Amerlock 400 Oxide Red.
3. Apply a thin coat of Amerlock 400 Ivory to all areas to be painted.