



## **MIXING & APPLICATION INSTRUCTIONS**

### **Amercoat 450H Urethane**

**(Mixing ratio: 4 parts resin to 1 part cure)**

- A. Power agitate Amercoat 450H Resin using an explosion proof power mixer to disperse settled pigments in bottom of can.**
- B. Add 4 parts Amercoat 450H Resin and 1 part Amercoat 450H Cure and mix well until a uniform consistency is achieved.**
- C. Add a small amount of #101 thinner 0-5% only if needed for spray application and power agitate again. Thinner is not normally needed for brush or roll application.**
- D. The Amercoat 450H is now ready to be applied. This material has a pot life of approximately 4 hours at 70°F and should be used within this time. Pot life will be shortened at higher temperatures.**
- E. For spray application use approximately 40 psi of pot pressure and 55-60 psi of atomization pressure. Depending on temperature the pressures may need to be adjusted up or down.**
- F. When spraying overlap each pass approximately 50% to achieve uniform film build.**
- G. Use a wet film guage to check the wet film thickness of the applied coating. A 3-4 mil wet film thickness will achieve about 2-3 dry mils of unthinned material.**
- H. If application is by brush or roller it may take two coats to achieve the proper dry film thickness as compared to spray application.**
- I. Gun, pot and spray lines should be cleaned using #65 thinner.**