



MIXING & APPLICATION INSTRUCTIONS

Amerlock 400 Epoxy

(Mixing ratio: 1 part resin to 1 part cure)

- A. Power agitate Amerlock 400 Resin using an explosion proof power mixer to disperse settled pigments in bottom of can.**
- B. Add 1 part Amerlock 400 Resin to 1 part Amerlock 400 Cure and mix well until a uniform consistency is achieved.**
- C. Add a small amount of #65 thinner 5-10% only if needed for spray application and power agitate again. Thinner is not normally needed for brush or roll application.**
- D. The Amerlock 400 is now ready to be applied. This material has a pot life of approximately 2 1/2 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 mil guage to check the wet film thickness of the applied coating. A 6-8 mil wet film thickness will achieve about 5-6 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.**