

AMERCOAT 240LT

February 2012
Revision of November 2011

DESCRIPTION Low Temperature Cure Universal Epoxy

- PRINCIPAL CHARACTERISTICS**
- Multi-purpose epoxy for industrial and marine applications
 - Ballast tanks, voids, bilge, and underwater hull application
 - Heavy industry, structural steel
 - Surface tolerant, compatible with water jetted surfaces
 - Abrasion resistant
 - Low VOC, extremely low HAPs
 - Up to 12 mils dft in one coat

COLOR* AND GLOSS Off White, Buff, Light gray, Oxide red, Black
Semi-gloss

** Epoxy coatings will chalk and fade upon exposure to sunlight, elevated temperatures, or chemical exposure. Discoloration and normal chalking does not impact performance. Light colors will darken over time. Some batch-to-batch variation in color is to be expected. Color matches are approximate.*

BASIC DATA

Volume solids	82% ± 3%
VOC	1.6 lbs/gal (192 g/L) (EPA Method 24)
Recommended Dry film thickness (per coat)	4 – 12 mils (100 – 300 microns)
Theoretical Spread Rate	@ 6 mils (5.6 m ² /l) 219 ft ² /gal
Components	2
Shelf Life	3 years from date of manufacture

SURFACE PREPARATION

- Steel
- Coating performance is, in general, proportional to the degree of surface preparation.
 - Remove weld spatter, protrusions, and laminations in steel. Grind welds smooth in accordance with NACE RP-0178. Remove all surface contaminants, oil and grease in accordance with SSPC SP-1.
 - Abrasive blast with an angular abrasive to an SSPC SP-10 cleanliness or higher for tank lining service. Achieve a surface profile of 2.0-4.0 mils.
 - The product may be applied over an SSPC SP-12 WJ-2(L) for non-tank lining applications where a previous blast profile can be exposed.
 - For maintenance and repair in atmospheric service, the product can be applied over surfaces prepared in accordance with SSPC SP-2 or SSPC SP-3 (hand and power tool cleaning).
 - Amercoat 114A may be used as a pit filler for severely pitted steel and surface discontinuities.
 - Check with PPG technical service for the maximum allowable soluble salt level for water immersion service. This will vary based on the water chemistry and service temperatures.
- Concrete
- Remove all surface contaminants such as oil, grease, and embedded chemicals. Abrade the surface per ASTM D 4259 to remove all chalk and surface glaze or laitance. Mechanical surface preparation should expose sub-surface voids and provide a surface profile equivalent to 60 grit sandpaper or coarser. Surface should be free from moisture in accordance with ASTM D4263. Refer to Information Sheet # 1496ACUS for further details regarding moisture measurements.

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- Non-ferrous metals – Lightly abrasive blast in accordance with SSPC SP-16 to achieve a uniform and dense 1.5-4.0 mil anchor profile.
- Stainless Steel – Abrasive blast with a hard angular abrasive to achieve a uniform and dense anchor profile of 1.5-4.0 mils.
- Aged Coatings and Repairs – Ensure the coating system is sound and well adhered. Do not apply over acrylic coatings or coatings that exhibit poor solvent resistance. A test patch is recommended. Sweep blast or otherwise thoroughly abrade the existing coating in accordance with SSPC SP-7. Alternately, Prep 88 may be used to prepare some existing coatings. Please refer to Prep 88 data sheet for details. Feather the edges of tightly adhered, in-tact coatings at the perimeter of repair areas. Power tool clean the existing steel in accordance with SSPC SP-3 (atmospheric service) or SSPC SP-11 (immersion service).

ENVIRONMENTAL CONDITIONS

- Ambient temperatures 20°F to 122°F (-7°C to 50°C)
- Material temperatures 40°F to 80°F (5°C to 27°C)
- Relative humidity 0 – 85%
- Surface temperature Surface temperature must be at least 5°F above the dew point temperature. Maximum 140°F unless a lower maximum is specified
- General air quality Area should be sheltered from airborne particulates and pollutants. Avoid combustion gases or other sources of carbon dioxide that may promote amine blush. Ensure good ventilation during application and curing. Provide shelter to prevent wind from affecting spray patterns.

INSTRUCTIONS FOR USE

- Mixing ratio by volume 4 parts base to 1 part hardener
Pre-mix pigmented components with a pneumatic air mixing at moderate speeds to homogenize the container. Add hardener to base and agitate with a power mixer for 1-2 minutes until completely dispersed.

Pot life

50°F	70°F	90°F
90 minutes	60 minutes	40 minutes

- Induction time 5 minutes at 70°F, 15 minutes at 50°F
- Airless spray 45:1 pump or larger, 0.019 - 0.023 fluid tip, 2,500 - 3,000 psi.
- Air spray Thin up to 15%, standard conventional equipment
- Brush & roll Use a high quality natural bristle brush and / or solvent resistant, 3/8" nap roller. Ensure brush / roller is well loaded to avoid air entrainment. Multiple coats may be necessary to achieve adequate film build.
- Thinner Amercoat T-10
- Cleaning solvent 12 Cleaner
- Primers Inorganic zinc primers or zinc rich epoxies (atmospheric service)
- Topcoats Amercoat 450H, Amershield, PSX-700, Amercoat 229T
- Safety precautions For paint and recommended thinners see safety sheet 1430, 1431 and relevant material safety data sheets

This is a solvent borne paint and care should be taken to avoid inhalation of spray mist or vapor as well as contact between the wet paint and exposed skin or eyes.

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DRY/CURE TIMES

@ 6 mils dft

	20°F	32°F	50°F	70°F	90°F
Dry to touch	8 hours	5 hours	3 hours	1.5 hours	45 minutes
Dry hard	22 hours	10 hours	7 hours	3 hours	1.5 hours
Dry to recoat/ topcoat*	24 hours	16 hours	8 hours	4 hours	2 hours
Max recoat, self	90 days	60 days	30 days	14 days	7 days
Max topcoat, urethanes, PSX**	30 days	14 days	10 days	5 days	2 days
Cure to immersion***	14 days	10 days	7 days	5 days	3 days

* Antifouling coatings should be applied when the previous coat of epoxy is tack free, but impressionable with moderate finger tip pressure.

Alkyd coatings and waterborne acrylic coatings should be applied after the film is dry through and no greater than three times the dry through time

** Dry times are dependent on air and surface temperatures as well as film thickness, ventilation, and relative humidity. Maximum recoating time is highly dependent upon actual surface temperatures – not simply air temperatures. Surface temperatures should be monitored, especially with sun-exposed or otherwise heated surfaces. Higher surface temperatures shorten the maximum recoat window.

Surface must be clean and dry. Any contamination must be identified and removed. A detergent wash with Prep 88 or equivalent is required prior to application of topcoats after 30 days of exposure. However, particular attention must be paid to surfaces exposed to sunlight where chalking may be present. In those situations, a further degree of cleaning may be required. PPG Technical Service can advise on suitable cleaning methods. If maximum recoat/topcoat time is exceeded, then roughen surface.

AVAILABILITY

Packaging

1-gallon and 5-gallon kits

Product codes

AT 240LT-1 Buff base
 AT 240LT-2 Light Gray base
 AT 240LT-20 F/S 23270 Haze gray
 AT 240LT-3 White base
 AT 240LT-72 Oxide red base
 AT 240LT-9 Black base
 AT 240LT-B Hardener

Worldwide statement

While it is always the aim of PPG Protective & Marine Coatings to supply the same product on a worldwide basis, 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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