

Amercoat® 242HB

Universal glass flake epoxy

Product Data/ Application Instructions

Two component glassflake reinforced amine cured epoxy coating

- One coat protection for cargo holds with excellent corrosion resistance
- Excellent abrasion and impact resistance, especially to hard angular cargoes
- Good resistance to various chemicals
- Good visibility due to light colour
- Reduce explosion risk and fire hazard
- Can be applied by heavy duty single feed airless spray equipment (60:1)

Physical Data

Finish	Gloss
Color	Gray
Volume Solids	100%
VOC	1.1 lb/gal (137 g/L)
Dry film thickness	12-20 mils
Theoretical spreading rate	100 ft ² / gallon at 16 mils
Touch dry after	8 hours
Overcoating interval	min. 24 hours max 20 days
Full cure after	5 days (data for components)

Surface Preparation

Abrasive blast clean to an SSPC SP-10 with an angular 2.0-4.0 mil anchor profile.

Environmental Conditions

Temperature	°F	°C
air	50 to 100	10 to 43
surface	50 to 100	10 to 43
material	68 to 100	20 to 43

Surface temperature must be at least 5°F (3°C) above dew point to prevent condensation.

Instructions for Use

Mixing ratio by volume: base to hardener 4:1

- when mixing the temperature of the base and hardener should be at least 68°F (20°C)
- at lower temperature the viscosity will be too high for spray application
- no thinner should be added

Induction time none

Pot life 30 minutes at 70°F

Airless Spray

- Heavy duty single feed airless spray equipment preferably 60:1 pump ration and suitable high pressure hoses
- In-line heating or insulated hoses may be necessary avoid cooling down of paint in hoses at low air temperature
- Application with 45:1 airless spray equipment is possible provided in-line heated high pressure hose are used
- In case of using 45:1 airless spray equipment the paint must be heated to approx. 90°F in order to obtain the right application viscosity
- Length of hoses should be as short as possible

Recommended thinner no thinner should be added

Nozzle orifice 0.021" minimum

Nozzle pressure 4000 psi at 70 °F, 3,000 psi at 90 °F

Brush/Roller

For stripe coating and spot repair only

Recommended Thinner no thinner should be added

Cleaning Solvent

Amercoat 12 Cleaner

- All application equipment must be cleaned immediately after use.
- Paint inside the spraying equipment must be removed before the pot life time has expired .

Additional Data

Measuring wet film thickness

- A deviation is often obtained between the measured apparent wft and the real applied wft.
- This is due to the thixotropy and the surface tension of the paint which retards the release of air trapped in the paint film for some time.
- Recommendation is to apply a wft which is equal to the specified dft plus 2 mils

Maximum dry film thickness

- Because of low initial hardness the dft cannot be measured for some days (depending on ambient temperature) after application due to the penetration of the measuring device into the paint film.
- The dft should be measured using a calibration foil of known thickness placed in between the coating and the measuring device.

Overcoating table for Amercoat 242HB for dft up to 20 mils

Substrate temperature	50°F	70°F	90°F	105°F
minimum interval	36 hrs	24 hrs	16 hrs	12 hrs
maximum interval	20 days	20 days	14 days	7 days

- surface should be dry and free from any contamination

Curing table

Substrate temperature	50°F	70°F	90°F	105°F
dry to handle	30 hrs	16 hrs	10 hrs	8 hrs
full cure	7 days	5 days	3 days	2 days

- Adequate ventilation must be maintained during application and curing

Pot life (at application viscosity)

70°F	90°F
30 min.	15 min.

- Due to exothermic reaction, temperature during and after mixing may increase.

Shelf life 12 months from date of manufacture

Safety Precautions

Read each component's material safety data sheet before use. Mixed material has hazards of both components. Safety precautions must be strictly followed during storage, handling, and use.

Caution – Improper use and handling of this product can be hazardous to health and cause fire or explosion.

Do not use this product without first taking all appropriate safety measures to prevent property damage and injuries. These measures may include, without limitation: implementation of proper ventilation, use of proper lamps, wearing of proper protective clothing and masks, tenting and proper separation of application areas. Consult your supervisor. Proper ventilation and protective measures must be provided during application and drying to keep solvent vapor concentrations within safe limits and to protect against toxic hazards. Necessary safety equipment must be used and ventilation requirements carefully observed, especially in confined or enclosed spaces, such as tank interiors and buildings.

This product is to be used by those knowledgeable about proper application methods. PPG makes no recommendation about the types of safety measures that may need to be adopted because these depend on application and space, of which PPG is unaware and over which it has no control.

If you do not fully understand the warnings and instructions or if you cannot strictly comply with them, do not use the product.

This product is for industrial use only. Not for residential use in California.