

AMERCOAT 450H

March 2012
Revision of November 2011

DESCRIPTION	Acrylic Aliphatic Polyurethane						
PRINCIPAL CHARACTERISTICS	<ul style="list-style-type: none"> - High gloss topcoat with unlimited recoatability - Outstanding weather resistance with excellent color and gloss retention - VOC compliant - Hard, flexible, and abrasion resistant - Cures through a wide temperature range 						
COLOR AND GLOSS	Gloss Standard Color Offering, Safety Colors, Custom Colors						
BASIC DATA							
Volume solids	67% ± 3%						
VOC	2.6 lbs/gal (311 g/L)						
Recommended Dry film thickness (per coat)	2 – 5 mils (50 – 125 microns)						
Theoretical Spread Rate	@ 1 mils dft 1074 ft ² /gal @ 2 mils dft 537 ft ² /gal						
Components	2						
Shelf Life	3 years from date of manufacture						
SURFACE PREPARATION	Coating performance is proportional to the degree of surface preparation. Refer to the application instructions for specific primers and intermediate coats for application and curing procedures. Ensure epoxies are free from amine blush prior to overcoating. All previous coats must dry and free of contaminants. Adhere to all minimum and maximum topcoat times for specific primers and intermediate coats. Aged epoxy coatings may require abrading prior to applying Amercoat 450H.						
ENVIRONMENTAL CONDITIONS							
Ambient temperatures	20°F to 120°F (-6°C to 49°C) Surface temperature must be at least 5°F above dew point temperature.						
Material temperatures	40°F to 90°F (5°C to 32°C)						
Relative humidity	85% maximum						
Surface temperature	20°F to 120°F (-6°C to 49°C)						
General air quality	Area should be sheltered from airborne particulates and pollutants. 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 base component 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	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 33%;">50°F</td> <td style="width: 33%;">70°F</td> <td style="width: 33%;">90°F</td> </tr> <tr> <td>6 hours</td> <td>4 hours</td> <td>2 hours</td> </tr> </table>	50°F	70°F	90°F	6 hours	4 hours	2 hours
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6 hours	4 hours	2 hours					
Airless spray	28:1 pump or larger, 0.013-0.015 fluid tip Can be applied with plural component equipment						
Air spray	Thin up to 20%, standard conventional equipment, 0.070" fluid orifice. A moisture and oil trap in the main line is essential. Product is sensitive to moisture contamination.						

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Brush & roll Use a high quality natural bristle brush and / or solvent resistant, 1/4" or 3/8" nap roller. Ensure brush / roller is well loaded to avoid air entrainment. Multiple coats may be necessary to achieve adequate film build. Amercoat 851 flow control additive can be used to for enhanced flow and leveling with brush and roll application.

Thinner Amercoat 923, Amercoat 101 (recommended for > 90°F)

Cleaning solvent Amercoat 12 Cleaner or thinner

Primers Amercoat 68HS, Amercoat 68MCZ, Amercoat 370, Amercoat 385, Amercoat 399, Amerlock 2/400, Pittguard Epoxies

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.

DRY/CURE TIMES

Amercoat 450H @ 2 mils dft

	32°F	50°F	70°F	90°F
Dry to touch	4 hours	90 minutes	45 minutes	20 minutes
Dry through	72 hours	24 hours	8 hours	4 hours
Dry to recoat	24 hours	12 hours	4 hours	2 hours
Maximum recoat	Unlimited			

Amercoat 450H with 866M Accelerator @ 2 mils dft

	20°F	32°F	50°F	70°F	90°F
Dry to touch	8 hours	4 hours	75 minutes	25 minutes	10 minutes
Dry through	72 hours	36 hours	8 hours	2.5 hours	1.75 hours
Dry to recoat	32 hours	16 hours	4 hours	1.5 hours	1 hour
Maximum recoat	Unlimited				

PRODUCT QUALIFICATIONS

– Compliant with USDA Incidental Food Contact Requirements

AVAILABILITY

Packaging

Available in 1-gallon and 5-gallon kits
 1-gallon kits have 0.8 gallons of base and 0.2 gallons of hardener
 5- gallon kits have 4 gallons of base and 1 gallon of hardener

Product codes

AT 45H-23 Pearl Gray base
 AT 45H-3 White base
 AT 45H-9 Black base
 AT 45H-T1 Deep tint base
 AT 45H-T2 Light tint base
 AT 45H-T3 Neutral tint base
 AT 45H-T4 Red tint base
 AT 45H-T5 High Hiding Yellow tint base
 AT 45H-71 Safety Red base
 AT 45H-81 Safety Yellow base
 AT 45H-B Hardener component

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Worldwide statement

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