AMERCOAT®

Amerlock® 400BF

Epoxy masonry block filler

Product Data/ Application Instructions

- Block filler for use on prepared interior or exterior masonry block

Application Data

Adhere to all application instructions, precautions, conditions and limitations to obtain maximum performance. For conditions outside the requirements or limitations described, contact your PPG representative.

Surface Preparation

Surface must be clean and free of all contaminants. Refer to ASTM D4258 for cleaning.

Application Equipment

The following is a guide; suitable equipment from other manufacturers may be used. Changes in pressure and tip size may be needed for proper spray characteristics.

Airless spray – Standard equipment such as Graco Bulldog Hydra-Spray or larger, with a 0.021 to 0.029-inch fluid tip.

Brush or roller – For touchup or texturing coating.

Power mixer – Jiffy Mixer with an explosion-proof motor.

Application Procedures

1. Flush all equipment with thinner or Amercoat 12 before use.
2. Stir resin using an explosion-proof power mixer to disperse pigments.
3. Add cure to resin. Mix thoroughly until uniformly blended to a workable consistency.
4. Do not mix more material than can be used within the expected pot life.
5. For optimum application material should be from 50 to 90°F (10 to 32°C). Above 110°F (43°C) sagging may occur.
6. Thin only for workability; thin no more than 1/2 pint of Amercoat 65 per gallon of Amerlock 400BF. A small amount of thinner greatly reduces viscosity; running or sagging may occur.
7. Apply in even, parallel passes; overlap 50 percent to avoid holidays, bare areas and pinholes. If required, cross spray at right angles.
8. After spraying, it is often advantageous to back roll with a short nap roller to work the product into masonry block.
9. Ventilate confined spaces with clean air between curing application coats and while curing final coat.
10. Repair any damaged areas by brushout or spray.
11. Clean equipment with thinner of Amercoat 12 immediately after use.

Physical Data

Color	Off-white
Components	2
Curing mechanism	Solvent release and chemical reaction between components
Volume solids (calculated)	75% ± 3%
Dry film thickness per coat	10-20 mils (250-500 microns)
Coats	1

Theoretical coverage	ft²/gal	m²/L
1 mil (25 microns)	1203	29.5
10 mils (250 microns)	120.3	2.9

VOC	< 1.66 lb/gal	< 200 g/L

Temperature resistance, Dry	°F	°C
continuous	200	93
intermittent	350	177

Flash point (SETA)	°F	°C
Amerlock 400BF resin	135	58
Amerlock 400BF cure	80	27
Amercoat 65	78	25
Amercoat 12	2	-17

Application Data

Applied over	Concrete; concrete cinder, or masonry block
Surface preparation	Dry, clean, well prepared surface
Method	Airless spray, brush (touch-up), roller (back-up)
Mixing ratio (by volume)	1 part resin to 1 part cure

Pot life (hours)	°F/°C		
	90/32	70/21	50/10
Amerlock 400BF	1½	2½	4

Environmental conditions

Temperature	°F	°C
air and surface	20 to 122	-7 to 50
material	50 to 90	10 to 32

Surface temperatures must be at least 5°F (3°C) above dew point to prevent condensation. At freezing temperatures, surface must be free of ice.

Drying time (ASTM D1640) (hours)

		°F/°C		
		90/32	70/21	50/10
touch	10 mils	1	3	6
	20 mils	1½	4	8
through	10 mils	5	9	18
	20 mils	6	11	24

Thinner	Amercoat 65
Equipment cleaner	Amercoat 12

Safety Precautions

Read each component's material safety data sheet before use. Mixed material has hazards of each component. 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 spray mists and 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 environment and space, of which PPG is unaware and over which it has no control.

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

Note: Consult Code of Federal Regulations Title 29, Labor, parts 1910 and 1915 concerning occupational safety and health standards and regulations, as well as any other applicable federal, state and local regulations on safe practices in coating operations.

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

Shipping Data

Packaging units	2 and 5 gal	
cure	1 gal in 1-gal can 2.5 gal in 3 gal can	
resin	1 gal in 1-gal can 2.5 gal in 5-gal can	
Shipping weight (approx)	lb	kg
2-gal unit		
cure	14.7	6.7
resin	14.2	6.4
5-gal unit		
cure	37.4	17.0
resin	36.4	16.5

Shelf life when stored indoors at 40 to 100°F (4 to 38°C)
1 year from shipment date

Numerical values are subject to normal manufacturing tolerances, color and testing variances. Allow for application losses and surface irregularities.

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This mixed product is photochemically reactive as defined by the South Coast Air Quality Management District's Rule 102 or equivalent regulations.

PPG Protective & Marine Coatings
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