

AMERCOAT® 229 T

DESCRIPTION

Gloss Epoxy Acrylic Topcoat

PRINCIPAL CHARACTERISTICS

- High gloss topcoat with unlimited recoatability
- Outstanding weather resistance
- VOC compliant
- Hard, tough, flexible, and abrasion resistant
- Cures through a wide temperature range
- Non-isocyanate
- Smooth and easy cleanable

COLOR AND GLOSS LEVEL

- Standard Color Offering, Safety Colors, Custom Colors
- Gloss

Note: Certain colors, especially red, orange, and yellow may require additional coats for adequate hiding, especially if applied over primers with a significant color contrast

BASIC DATA AT 68°F (20°C)

Data for mixed product	
Number of components	Two
Volume solids	56 ± 2%
VOC (Supplied)	max. 3.2 lb/US gal (approx. 384 g/l)
Temperature resistance (Continuous)	To 200°F (93°C)
Temperature resistance (Intermittent)	To 250°F (121°C)
Recommended dry film thickness	2.0 - 4.0 mils (50 - 100 µm) depending on system
Theoretical spreading rate	449 ft ² /US gal for 2.0 mils (11.2 m ² /l for 50 µm)
Shelf life	Base: at least 36 months when stored cool and dry Hardener: at least 24 months when stored cool and dry

Notes:

- See ADDITIONAL DATA - Overcoating intervals
- See ADDITIONAL DATA - Curing time
- Intermittent temperature resistance should be less than 5% of the time, and maximum 24 hours
- Color will drift at elevated temperatures

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RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

- 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 require abrading prior to applying the product. A test patch over unknown coatings is recommended.

Substrate temperature and application conditions

- Surface temperature during application should be between 40°F (4°C) and 120°F (49°C)
- Surface temperature during application should be at least 5°F (3°C) above dew point
- Ambient temperature during application and curing should be between 40°F (4°C) and 120°F (49°C)
- Relative humidity during application should not exceed 90%

SYSTEM SPECIFICATION

- Primers: AMERCOAT 370, AMERCOAT 385, AMERCOAT 399, AMERLOCK 2/400, AMERCOAT 235, AMERCOAT 240

INSTRUCTIONS FOR USE

- Agitate with a power mixer for 1 – 2 minutes until completely dispersed. Ensure good off-bottom mixing

Mixing ratio by volume: base to hardener 80:20 (4:1)

- Pre-mix base component with a pneumatic air mixer 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

6 hours at 70°F (21°C)

Note: See ADDITIONAL DATA – Pot life

Application

- Area should be sheltered from airborne particulates and pollutants
- Avoid combustion gases or other sources of carbon dioxide that may promote amine blush and ambering of light colors
- Ensure good ventilation during application and curing
- Provide shelter to prevent wind from affecting spray patterns

Material temperature

Material temperature during application should be between 50°F (10°C) and 90°F (32°C)

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Air spray

- A moisture and oil trap in the main line is essential. Product is sensitive to moisture contamination
- Use standard conventional equipment

Recommended thinner

THINNER 21-06 (AMERCOAT 65) (xylene), THINNER 21-25 (AMERCOAT 101) (recommended for > 90°F (32°C)), THINNER 60-12 (AMERCOAT 911)

Volume of thinner

0 - 20%

Nozzle orifice

Approx. 0.070 in (1.8 mm)

Airless spray

- 28:1 pump or larger

Recommended thinner

THINNER 21-06 (AMERCOAT 65) (xylene), THINNER 21-25 (AMERCOAT 101) (recommended for > 90°F (32°C)), THINNER 60-12 (AMERCOAT 911)

Volume of thinner

0 - 5%

Nozzle orifice

0.013 - 0.015 in (approx. 0.33 - 0.38 mm)

Brush/roller

- 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

Recommended thinner

AMERCOAT 65 (xylene), AMERCOAT 101 (recommended for > 90°F (32°C)), AMERCOAT 911

Volume of thinner

0 - 5%

Cleaning solvent

AMERCOAT 12 CLEANER or AMERCOAT 65 THINNER (xylene)



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ADDITIONAL DATA

Overcoating interval for DFT up to 2.0 mils (51 µm)				
Overcoating with...	Interval	50°F (10°C)	70°F (21°C)	90°F (32°C)
itself	Minimum	10 hours	6 hours	4 hours
	Maximum	Unlimited	Unlimited	Unlimited

Curing time for DFT up to 2.0 mils (51 µm)		
Substrate temperature	Dry to touch	Dry to handle
50°F (10°C)	4 hours	16 hours
70°F (21°C)	2 hours	8 hours
90°F (32°C)	1 hour	6 hours

Pot life (at application viscosity)	
Mixed product temperature	Pot life
50°F (10°C)	8 hours
70°F (21°C)	6 hours
90°F (32°C)	3 hours

Product Qualifications

- Compliant with USDA Incidental Food Contact Requirements
- Mil-PRF-24667 (Color topping qualified over AMERCOAT 138G non-skid)

SAFETY PRECAUTIONS

- For paint and recommended thinners see INFORMATION SHEETS 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

WORLDWIDE AVAILABILITY

It is always the aim of PPG Protective and Marine Coatings to supply the same product on a worldwide basis. However, 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.

REFERENCES

- | | | |
|--------------------------------------|-------------------|------|
| • CONVERSION TABLES | INFORMATION SHEET | 1410 |
| • EXPLANATION TO PRODUCT DATA SHEETS | INFORMATION SHEET | 1411 |



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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 code	Description
AT22920	Haze gray
AT22923	Pearl Gray
AT229265	F/S 36076
AT2293	White
AT2299	Black
AT229T1	Deep Tint Base *
AT229T2	Light Tint Base *
AT229T3	Neutral Tint Base *
AT229T4	Red Tint Base *
AT229T5	High Hiding Yellow Tint Base *
AT229B	Hardener

Note: * Tintable using UCD V-Line colorants only