



# AMERLOCK 2K GF

## High Solids High Build Epoxy Glass Flake

### Data Sheet: 2K GF

Supersedes: 06/06

Revised: 03/08

<b>Composition</b>	Two-pack, high solids, high performance epoxy coating reinforced with glass flake for use on new or old steel.			
<b>Uses and Properties</b>	<ul style="list-style-type: none"> <li>◆ High build glass flake epoxy coating</li> <li>◆ Suitable for sea water immersion.</li> <li>◆ Surface tolerant self priming top coat.</li> <li>◆ Up to 500 um in one coat.</li> <li>◆ Self-priming topcoat over most existing coatings.</li> <li>◆ Compatible with prepared damp surfaces.</li> <li>◆ Can be overcoated with a wide range of topcoats.</li> <li>◆ Resists high humidity and moisture.</li> <li>◆ Can be used on insulated pipe to 218 °C.</li> <li>◆ Low solvent content minimises risk of pinholing and solvent entrapment.</li> <li>◆ Suitable for use with potable water (NSF 61 CLD23).</li> <li>◆ Suitable for incidental food contact.</li> </ul>			
<b>Typical Applications</b>	For the protection of steel and concrete structures in severe environments, including marine structures, petroleum processing and storage facilities and other heavy industrial facilities. On offshore platforms, AMERLOCK 2K GF is suitable for use in splash and tidal zones, under deck areas and helidecks as well as sub-sea facilities.			
<b>Typical Systems</b>	<b>Substrate</b>	<b>Surface Preparation</b>	<b>Typical Systems</b>	<b>dft µm</b>
	Rusted steel, previously coated steel, weathered galvanised steel	<i>For atmospheric exposure:</i> Power tool or hand tool clean. Ensure surface is free from all loose paint, rust, dust, dirt, oil, grease or soluble salts. ③	1 <sup>st</sup> Coat: AMERLOCK 2K GF 2 <sup>nd</sup> Coat: AMERLOCK 2K GF (optional) ① ④	200-300 200-300
	New steel	<i>For atmospheric exposure:</i> Abrasive blast clean to A.S.1627.4 to Class 2½.	1 <sup>st</sup> Coat: AMERLOCK 2K GF ② 2 <sup>nd</sup> Coat: AMERLOCK 2K GF (optional) ① ④	200-300 200-300
	New steel, to be immersed	Abrasive blast clean to A.S.1627.4 Class 3.	1 <sup>st</sup> Coat: AMERLOCK 2K GF 2 <sup>nd</sup> Coat: AMERLOCK 2K GF ⑤	250-350 250-350
	Concrete	Acid etch or whip blast. Concrete must be cured minimum 14 days	1 <sup>st</sup> Coat: AMERLOCK 2K GF 2 <sup>nd</sup> Coat: AMERLOCK 2K GF	100-200 100-200
	Galvanised steel	Degrease and light abrasive blast .	1 <sup>st</sup> Coat: AMERLOCK 2K GF 2 <sup>nd</sup> Coat: AMERLOCK 2K GF (optional) ①	200-300 200-300
<p>① The shape and size of surfaces to be coated and the method of application may allow adequate protection in one coat.</p> <p>② Prime coats such as D9 SB ZINC SILICATE, AMERCOAT 68HS, AMERCOAT 385P, AMERCOAT 471,AMERCOAT 182ZPK AND AMERCOAT 474 may be used depending on exposure requirements.</p> <p>③ Wet abrasive blasting readily coated.</p> <p>④ For improved chalk resistance and colour retention 2<sup>nd</sup> coat may be replaced with AMERCOAT 450K, ISO-FREE 977, LUSTERTHANE 988, PSX 700 and AMERSHIELD.</p> <p>⑤ Film builds up to 750 um may be achieved in one coat by repeated wet on wet applications.</p>				

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<b>General Data</b> <b>Weathering</b> <b>Finish</b> <b>Chemical Resistance</b> <b>Solvent Resistance</b> <b>Abrasion Resistance</b> <b>Immersion</b> <b>Temperature Range</b>  <b>Colour</b> <b>Topcoating</b> <b>Shelf Life</b>	<p>Excellent. Chalks on exterior exposure without detracting from durability.</p> <p>Semigloss.</p> <p>Very good resistance to splash of acids, alkalis and chemicals.</p> <p>Good resistance to most hydrocarbon solvents, distillates, oils and greases.</p> <p>Good.</p> <p>Suitable fresh water or sea water.</p> <table border="1"> <tr> <td></td> <td>Wet</td> <td>Dry</td> </tr> <tr> <td>Continuous</td> <td>38 °C</td> <td>218 °C</td> </tr> <tr> <td>Intermittent</td> <td>38 °C</td> <td>232 °C</td> </tr> </table> <p>Mid Grey N52, Light Grey N35, Black. (Other colours batch quantity only)</p> <p>Normally none, though may be topcoated with most other two pack enamels.</p> <p>12 months from date of shipment if stored indoors at 4°C to 38°C – Base and Hardener.</p>		Wet	Dry	Continuous	38 °C	218 °C	Intermittent	38 °C	232 °C											
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<b>Application Data</b> <b>Theoretical Coverage</b>  <b>Volume Solids</b> <b>Drying Time</b>  <b>Maximum Recoat Time</b> <b>Mixing Ratio</b> <b>Pot Life</b>  <b>Mixing</b>  <b>Thinners</b> <b>Equipment</b>  <b>Safety Precautions</b>	<p>6.8 sq.m. per litre at 125 µm dry film thickness depending on colour. (Wet film thickness 150 µm). Material losses during mixing and application will vary and must be considered when estimating requirements.</p> <p>85% ± 2% (theoretical).</p> <table border="1"> <tr> <td></td> <td>0°C</td> <td>10°C</td> <td>20°C</td> <td>30°C</td> </tr> <tr> <td>Touch Dry</td> <td>18 hrs</td> <td>14 hrs</td> <td>3 hrs</td> <td>2 hrs</td> </tr> <tr> <td>Through Dry</td> <td>2 ½ days</td> <td>20 hrs</td> <td>5 hrs</td> <td>3 hrs</td> </tr> <tr> <td>Minimum Recoat Time</td> <td>2 days</td> <td>16 hrs</td> <td>4 hrs</td> <td>2.5 hrs</td> </tr> </table> <p>Maximum recoat time at 20°C with itself and PSX700, 1 month. Polyurethane and PSX 1001: 1 week, Iso-cyanate free acrylic 48 hrs and alkyd enamel 24 hours.</p> <p>1 part Base to 1 part Hardener.</p> <p>30 minutes @ 25°C. (20 L).</p> <p><i>NOTE: The figures quoted for pot life and drying/curing times are not definitive. They are dependent on site conditions, such as volume of material mixed, ambient and steel temperatures, weather and ventilation.</i></p> <p>Power stir the Base and Hardener, then add the Hardener to the Base with stirring. Allow to digest 10 minutes maximum before thinning (if required) and using.</p> <p>Use THINNER 737 for thinning and THINNER 304 for clean up.</p> <p><i>Airless Spray:</i> Use a 0.79 mm to 1.09 mm (0.031" to 0.043") tip size and 12 to 14 MPa pressure.</p> <p><i>Conventional Spray:</i> DeVilbiss JGA 502 GUN WITH "D" needle and fluid tip, 64 aircap, or equivalent. Use 200-270 kPa pot pressure and 400 kPa atomising pressure. Additional coats may be required for brush or roller application.</p> <p>Recommended only for application by experienced industrial operators in industrial coating operations. When applying by brush or roller, provide adequate ventilation. When applying by spray, users must comply with relevant spray painting regulations and wear appropriate respirator to avoid inhaling vapours and spray mist. Material Safety Data Sheet is available and should be consulted.</p>		0°C	10°C	20°C	30°C	Touch Dry	18 hrs	14 hrs	3 hrs	2 hrs	Through Dry	2 ½ days	20 hrs	5 hrs	3 hrs	Minimum Recoat Time	2 days	16 hrs	4 hrs	2.5 hrs
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