

PRODUCT DATA SHEET

AMERLOCK® 400 / SIGMACOVER™ 400

DESCRIPTION

Two-component, high solids epoxy coating

PRINCIPAL CHARACTERISTICS

- High performance self priming universal epoxy
- High solids, low VOC
- Surface tolerant and abrasion resistant
- Compatible with prepared, damp surfaces
- Good adhesion on most existing coatings
- Available in a wide color range
- Also available with MID pigmentation
- Good resistance to splash- and spillage of chemicals

COLOR AND GLOSS LEVEL

- RAL colors (other colors available on request)
- Semi-gloss

BASIC DATA AT 20°C (68°F)

Data for mixed product	
Number of components	Two
Mass density	1.4 kg/l (11.7 lb/US gal)
Volume solids	85 ± 2%
VOC (Supplied)	Directive 1999/13/EC, SED: max. 114.0 g/kg max. 163.0 g/l (approx. 1.4 lb/US gal) EPA Method 24: 180.0 g/ltr (1.5 lb/USgal)
Recommended dry film thickness	100 - 200 µm (4.0 - 8.0 mils)
Theoretical spreading rate	8.5 m ² /l for 100 µm (341 ft ² /US gal for 4.0 mils)
Dry to touch	6 hours
Overcoating interval	Minimum: 16 hours See overcoating tables
Shelf life	Base: at least 36 months when stored cool and dry Hardener: at least 36 months when stored cool and dry

Notes:

- See ADDITIONAL DATA - Spreading rate and film thickness
- See ADDITIONAL DATA - Overcoating intervals
- See ADDITIONAL DATA - Curing time

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RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

Substrate conditions

- Steel; blast cleaned to ISO-Sa2½, power tool cleaned to min. ISO-St3 or hand tool clean to ISO-St2 or ultra high pressure water jet to WJ2L
 - For immersion exposure: steel; blast cleaned to ISO-Sa2½
 - Concrete and other cement bonded substrates must be hard, dry and free from laitance and any contamination
 - Aged coatings may require abrading prior to applying this product
 - For single-pack coatings, extra precautions are necessary
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INSTRUCTIONS FOR USE

Mixing ratio by volume: base to hardener 50:50 (1:1)

- The paint should be stirred well before use, preferably by means of a mechanical mixer, to ensure homogeneity
 - Add hardener to base and continue stirring until homogeneous
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Pot life

2 hours at 20°C (68°F)

Note: See ADDITIONAL DATA – Pot life

Air spray

Recommended thinner

THINNER 91-92

Volume of thinner

0 - 10%, depending on required thickness and application conditions

Airless spray

Recommended thinner

No extra thinner needed

Nozzle orifice

Approx. 0.48 mm (0.019 in)

Nozzle pressure

15.0 - 18.0 MPa (approx. 150 - 180 bar; 2176 - 2611 p.s.i.)

Brush/roller

- Brush: apply evenly using a clean, well-loaded brush
 - Application by brush or roller will provide approximately 80 µm (3.1 mils) DFT in a single-coat application
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Cleaning solvent

THINNER 90-58

ADDITIONAL DATA

Spreading rate and film thickness	
DFT	Theoretical spreading rate
100 µm (4.0 mils)	8.5 m ² /l (341 ft ² /US gal)
125 µm (5.0 mils)	6.8 m ² /l (273 ft ² /US gal)
200 µm (8.0 mils)	4.3 m ² /l (170 ft ² /US gal)

Overcoating interval for DFT up to 125 µm (5.0 mils)					
Overcoating with...	Interval	10°C (50°F)	20°C (68°F)	30°C (86°F)	40°C (104°F)
itself	Minimum	36 hours	16 hours	6 hours	4 hours
	Maximum	3 months	3 months	2 months	1 month
polyurethanes	Minimum	36 hours	16 hours	6 hours	4 hours
	Maximum	1 month	1 month	14 days	7 days

Curing time for DFT up to 125 µm (5.0 mils)			
Substrate temperature	Dry to touch	Dry to handle	Full cure
10°C (50°F)	24 hours	48 hours	21 days
20°C (68°F)	6 hours	20 hours	7 days
30°C (86°F)	3 hours	12 hours	4 days
40°C (104°F)	1 hour	8 hours	3 days

Note: Adequate ventilation must be maintained during application and curing (please refer to INFORMATION SHEETS 1433 and 1434)

Pot life (at application viscosity)	
Mixed product temperature	Pot life
10°C (50°F)	3 hours
21°C (70°F)	2 hours
32°C (90°F)	1 hour
40°C (104°F)	30 minutes