



AMERICAN COATINGS

EM SERIES HIGH BUILD EPOXY PRIMERS

Excellent high build, rust inhibitive epoxy primers for severe environments.

GENERAL FEATURES

- GOOD CHEMICAL RESISTANCE
- APPLY IN LOW TEMPERATURES USING WINTER CATALYST (EXP-LTC)
- NON-TOXIC CORROSION INHIBITORS
- USER FRIENDLY APPLICATION PROPERTIES

DESCRIPTION

American EM Series High Build Epoxy Primers are high performance epoxy polyamide primers and have excellent adhesion to steel and concrete. Four to six dry mils can be easily applied in one application.

USES

American EM Series primers are an excellent basecoats for high performance paint systems. EM epoxy primers may be topcoated with epoxies, or polyurethanes.

NOTE: Topcoat within 3 – 5 days @ 77°F to be assured of good adhesion.

COLOR AVAILABLE

EM 8301	Red Oxide
EM 8442	Gray
EM 12820	Buff

PHYSICAL DATA

Finish -----	Semi-Gloss
Color -----	Red Oxide, Gray, Buff
Applied Over-----	Steel
Components -----	Two
Mixing Ratio -----	4:1

Volume Solids ± 2% ----- 65%

Recommended Wet Film

Thickness -----6 – 9 mils

Recommended Dry Film

Thickness----- 4 – 6 mils

Number of Coats ----- One

Application Method ----- Conventional or Airless Spray

*Theoretical Coverage at ----- 260 – 173 sq. ft/gal

Thinning Required----- 10 – 15% TH 760

Approx. dry times at 50% R.H.

Using – EXP ----- EXPLTC ----- EXPLTC

Temp ----- 77 F ----- 77 F ----- 40 F

Touch -----2 hrs ----- 2 hrs ----- 3 hrs

Topcoat --12 hrs ----- 6 hrs ----- 15 hrs

Through --24 hrs ----- 12 hrs ----- 36 hrs

Temperature Limit

Immersed ----- 180°F

Atmospheric ----- 220°F

Miscellaneous Properties

Shelf Life -----1 year

Pot Life – Mixed @ 77°F using EXP----- 6 – 8 hours

using EXPLTC ----- 4 hrs

SURFACE PREPARATION

Immersion Service and/or Severe Service ----- White

Metal Blast (SSPC-SP5-63) (Sa3)

Anchor Profile: 1.0-1.5 mil max

Non Immersion Service and/or Moderate Service

Commercial Blast (SSPC-SP6-63) (Sa2)

Aluminum or Galvanize ----- Acid etch with

TH 950 Chemical Cleaner or Sandblast.

*Coverages are theoretical and do not make provision for spray losses



AMERICAN COATINGS

EM SERIES

APPLICATION INFORMATION

Do not apply if the metal temperatures are below 50° F and/or humidity is above 85%.

*Cold cure Catalyst is Available (EXP LTC)

APPLICATION METHOD

Airless spray preferred. Can be applied with brush or roller.

MIXING

Thoroughly mix 4 parts A Base to 1 part EXP Catalyst Part B using a mechanical mixer. In cooler weather 1 part EXP-LTC catalyst. Allow an induction time of 30 minutes before application if using the EXP Catalyst. No induction time is necessary with EXP-LTC.

CAUTION: Elevated temperature will shorten pot life

CLEAN-UP AND THINNING

Clean all equipment immediately with TH 760 Epoxy Thinner. Thin as required with TH 760 Epoxy Thinner.

SPRAY EQUIPMENT

FOR AIRLESS SPRAY

Pump Ratio ----- 28:1
Air Supply (in) ----- 100 psi
Hose Diameter (ID) ----- ¼"
Hose Length ----- 100'
Hose Length (in elevated temperature) ----- 50'
Tip Size ----- .013 - .019
Atomization Pressure ----- 2,200

FOR CONVENTIONAL SPRAY

Spray Pot Dual with dual Regulated
Air Gauges for Pot Pressure and Atomization Air
Air Supply (in) ----- 100 psi
Material Hose (ID) ----- ½"
Material Hose Length (max) ----- 25'
Air Hose (ID) ----- 5/16"
Fluid Pressure (psi) ----- 10 – 25 psi
Atomization Pressure (psi) ----- 40 – 70 psi
Fluid Tip Orifice Size (in) ----- .070" – 80"

SAFETY INFORMATION

WARNING! FLAMMABLE, HARMFUL IF INHALED, CAUSES IRRITATION

Keep away from heat, sparks or flame. Vapors may cause flash fire. Use with adequate ventilation. Do not breathe vapors or spray mist. Wear an appropriate, properly fitted respirator during and after applications unless air monitoring demonstrates vapor/mist levels are below applicable limits. Avoid contact with eyes, skin, and clothing. Wash thoroughly after handling.

SHIPPING DATA

Proper Shipping Name ----- Paint Liquid
Hazard Class----- Flammable Liquid

Flash Pt. °F SETA ----- 75°F Part A
45°F Part B

UN No.----- 1263

PACKAGING

Shipping WT.	<u>PART A</u>	<u>PART B</u>
	Fives 45.4 lbs.	Gallons 8.5 lbs.

DISCLAIMER

The facts stated and the recommendations and suggestions herein are based upon experiments and supplier information believed to be reliable. No guarantee is made of their accuracy, however, and American Coatings ASSUMES NO LIABILITY FOR PRODUCT FAILURE OTHER THAN TO SUPPLY REPLACEMENT MATERIAL FOR PRODUCTS SHOWN TO BE DEFECTIVE WHEN DELIVERED OR TO REFUND THE PURCHASE PRICE. Except as stated, THERE ARE NO WARRANTIES, EITHER EXPRESSED OR IMPLIED, OF MERCHANTABILITY, FITNESS OR OTHERWISE. AMERICAN COATINGS SHALL NOT BE LIABLE FOR SPECIAL, INCIDENTAL AND CONSEQUENTIAL DAMAGES. No statement contained herein shall be construed as an inducement to infringe existing patents or as an endorsement of specific manufacturers. Req 10/06



AMERICAN COATINGS