

# 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) OPTION
- 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 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/Primer Finish
EM8442	White
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

**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**

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

DISCLAIMER

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