

AMERICAN COATINGS

EM SERIES HIGH BUILD EPOXY FINISHES

High build epoxy finishes for moderate and severe environments.

GENERAL FEATURES

- TWO COMPONENT HIGH BUILD EPOXIES
- EXCELLENT AS A MIDCOAT OVER INORGANIC ZINC
- EXCELLENT CHEMICAL RESISTANCE AND ABRASIVE RESISTANCE
- GOOD FLEXIBILITY

DESCRIPTION

American EM Series High Build Epoxy Coatings are polyamide epoxies exhibiting excellent chemical resistance and abrasive resistance. EM Series render twice the film thickness of EX finishes.

USES

American EM Series High Build Epoxy Polyamide Coatings are excellent when topcoating inorganic zinc. EM Series coatings offer the durability for new construction as well as maintenance and can be utilized as a midcoat or primary finish. EM series coatings may be overcoated with EX, EM, or PU finishes. EM finishes also make durable tank linings.

Note: Finishes should be applied over EM products in 3 to 5 days.

PHYSICAL DATA

Finish ----- Semi Gloss
 Color ----- Various
 Applied Over ----- Properly, primed steel,
 aluminum, galvanize, masonry
 Components ----- Two
 Cure ----- Catalytic 4:1
 Volume Solids ± 2% ----- 65%

Recommended Dry Film Thickness ----- 4 – 6 mils
Number of Coats ----- One
Application Method ----- Conventional, airless,
 brush or roller

Thinning Required----- 10 – 15% TH 760
Dry Time @ 77°F and 50% relative humidity.
 Touch ----- 1 – 2 hours
 Through ----- 6 – 8 hours
 Topcoat ----- 8 – 10 hours

Theoretical Coverage at:
Recommended Thickness----- 208 – 173 sq.ft/gal.*
Temperature Limit

Immersed ----- 175°F
 Atmospheric ----- 225°F

Miscellaneous Properties
Shelf Life ----- 1 year
Pot Life – mixed @ 77°F ----- 6 – 8 hours

PERFORMANCE DATA

TEST	RESULTS
PENCIL HARDNESS ASTM D-3363	HB
WEIGHT PER GALLON ASTM D-1200	Varies with color 10.5 pounds/gallon.
WEIGHT SOLIDS % ASTM D-2369	Varies with color 66% average
IMPACT RESISTANCE ASTM G-14	80 inch-lb. direct 40 inch-lb. reverse
SOLVENT RESISTANCE ASTM D-5402	200+ after 7 days
TAPE ADHESION ASTM D-3359 A or B	5A and 5B
PULL OFF ADHESION ASTM D-4541	With AZ76/EM8301/SU5000 System, 600 psi (Elcometer)
SPECULAR GLOSS ASTM D-523	5 gloss units at 60°
SAG RESISTANCE ASTM D-4400	16 mils minimum
OIL IMMERSION D ASTM D-1308	Passes 1000 hours
SALT FOG RESISTANCE ASTM B-117	Passes 1000 hours

EM HB Series

SURFACE PREPARATION:

Apply over properly primed steel, aluminum, galvanize, or masonry surfaces. Primer should be free of dirt, dust, oil, or grease.

<u>Substrate</u>	<u>Recommended Surfaces</u>
Steel	AZ 76, AZ 86, AZ 82, AZ 83, RL, EX, or EM Primers
Aluminum	WP 9521 or SSPC-SP7
Galvanize	WP 9521 or SSPC-SP7
Masonry	Apply TH 950 Chemical Cleaner. Prime coat with EX or EM finish thinned 50% with TH 760

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

APPLICATION INFORMATION

Do not apply at temperatures below 40°F or humidities above 85%.

APPLICATION METHOD

Conventional or Airless spray preferred. Brush or roller application acceptable.

MIXING

Mix 4 parts Part A to 1 part EXP catalyst Part B. Allow an induction time of 30 minutes before application.

CLEAN-UP AND THINNING

Clean-up with TH 315 or TH 790 thinners. Thin with TH 760 epoxy thinner.

SPRAY EQUIPMENT

FOR AIRLESS SPRAY

Pump Ratio -----	30:1
Air Supply (in) -----	100 psi
Hose Diameter (ID) -----	1/4"
Hose Length -----	100'
Tip Size (in) -----	.013-.021"
Atomization Pressure (psi) -----	2,400 psi

FOR CONVENTIONAL SPRAY

Spray Pot Dual Regulation Air Gauges	
Separate Air Gauges for Pot Pressure and Atomizing Air	
Air Supply (in) -----	100 psi
Material Hose (ID) -----	1/4"
Material Hose Length -----	50'
Air Hose (ID) -----	5/16"
Fluid Pressure (psi) -----	10 – 25
Atomization Pressure (psi) -----	50 – 75
Fluid Tip Orifice Size (in) -----	.070

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 SET-----	80°F Part A 45°F Part B
UN No.-----	1263

PACKAGING

<u>Shipping WT.</u>	<u>PART A</u>	<u>PART B</u>
Ones	12.75 lbs.	Quart 2 lbs.
Fives	53 lbs.	Pint .75 lbs.

PRODUCTS

EM8442	Light Gray
EM8443	White
EM8444	Tan*
EM8451	Cat Yellow
EM12323	Black*
EM12820	Buff
Others available upon request.	

* Made to order product, 50 gallon minimum order

DISCLAIMER

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