



AMERCOAT 385

High Build Two Pack Epoxy

Data Sheet: 385

Supersedes 09/07

Revised 05/08

Composition	Two-pack high performance epoxy coating			
Uses and Properties	<ul style="list-style-type: none">◆ Multi purpose high build epoxy coating.◆ Suitable for overcoating with a wide range of topcoats.◆ Suitable for immersion service.◆ Excellent adhesion to inorganic zinc silicates.◆ Can be applied in a wide range of film builds.◆ Compatible with a variety of substrates and surface preparations.◆ Easy application			
Typical Applications	Decks, hulls and superstructures of ships, barges and work boats – Piers, offshore platforms and related structures – Tank exteriors in oil refineries, paper mills, chemical processing facilities and waste water treatment plants – industrial structural steel, machinery and piping. Can be used as a tank lining for alkaline, salt solutions, petroleum, fuel and sewerage waste.			
Typical Systems	Substrate	Surface Preparation	Typical Application	dft µm
	Structural Steel	Abrasive blast clean to AS1627.4 Class 2½ min.	1 st Coat: D9 SB ZINC SILICATE ❶ 2 nd Coat: AMERCOAT 385 3 rd Coat: AMERCOAT 450N ❷	60-75 100-150 40-50
	Mild steel	Abrasive blast clean to AS1627.4 Class 2.	1 st Coat: AMERCOAT 385P 2 nd Coat: AMERCOAT 450N ❷	40-50 40-50
	Galvanised steel	Degrease, whip blast or acid etch.	1 st Coat: AMERCOAT 385 2 nd Coat: AMERCOAT 450N ❷	100-150 40-50
	Aluminium	Degrease, whip blast or acid etch	1 st Coat: AMERCOAT 385 2 nd Coat: AMERCOAT 450N ❷	100-150 40-50
	Concrete	Whip blast or acid etch.	1 st Coat: AMERCOAT 385 2 nd Coat: AMERCOAT 450N ❷	100-150 40-50
	Steel (for tank lining use)	Abrasive blast clean to A.S.1627.4 Class 3 with profile of 50-75 mm.	1 st Coat: AMERCOAT 385 2 nd Coat: AMERCOAT 385	150 150
<p>❶ Other primers such as AMERCOAT 68HS, AMERCOAT 307, AMERCOAT 182ZPK, AMERCOAT 370ZP may be used depending on exposure conditions.</p> <p>❷ Other topcoats such as LUSTERTHANE 988 and ISO-FREE 977 may be used depending on exposure conditions.</p>				

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<div>General Data</div> <div><div>Weathering Finish</div><div>Chemical Resistance</div><div>Solvent Resistance</div><div>Abrasion Resistance</div><div>Immersed Conditions</div><div>Temperature Range</div><div>Colour</div><div>Top Coating</div><div>Shelf Life</div></div>	<div>Excellent for a primer. Must be topcoated before deterioration.</div> <div>Suitable for mild acidic splashing.</div> <div>Resists splashing of oils, alcohols, hydrocarbons.</div> <div>Excellent. (For transport and erection.)</div> <div>Suitable for immersion.</div> <div>Up to 93°C (dry), 60°C (wet) - splash.</div> <div>White</div> <div>AMERCOAT 450N, LUSTERTHANE 988, ISO-FREE 977, PSX 700 and most other two pack coatings</div> <div>12 months from date of shipment if stored indoors at 4°C to 38°C - Base and Hardener.</div>																				
<div>Application Data</div> <div><div>Covering Capacity (Theoretical)\</div><div>Volume Solids</div><div>Drying Times at 150µm</div><div>Maximum Recoat Time</div><div>Mixing Ratio</div><div>Pot Life at 25 °C</div><div>Note:</div><div>Thinner</div><div>Method</div><div>Safety Precautions</div></div>	<div>5.2 square metres per litre at 125 µm dry film thickness. (Wet film thickness 190 µm). Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.</div> <div>66% ± 2%.</div> <table><tr><td></td><td>0°C</td><td>10°C</td><td>21°C</td><td>32°C</td></tr><tr><td>Touch Dry</td><td>6 hrs</td><td>3 hrs</td><td>2 hrs</td><td>1 hr</td></tr><tr><td>Through Dry</td><td>7 days</td><td>24 hrs</td><td>16 hrs</td><td>10 hrs</td></tr><tr><td>Minimum Recoat Time</td><td>3 days</td><td>10 hrs</td><td>8 hrs</td><td>6 hrs</td></tr></table> <div>Maximum recoat time at 20°C with itself and PSX700, 1 month.</div> <div>Polyurethane: 1 week.</div> <div>Iso-cyanate free acrylic 48 hrs and alkyd enamel 24 hours.</div> <div>1 part Base to 1 part Hardener</div> <div>2 hours, shorter at higher temperatures.</div> <div>The figures quoted for pot life and drying/curing times after mixing the components are not definitive. They are dependent on job site conditions such as volume of mixed material, ambient and steel temperature variations, weather and ventilation, and influenced by the previous storage conditions.</div> <div>THINNER 737 Use 304 THINNER for clean up.</div> <div>Stir Base and Hardener thoroughly, then combine Base and Hardener and power stir to a uniform consistency. Application by conventional or airless spray, thinning up to 10% with THINNER 737. Apply by repeated wet on wet applications to required thickness. Clean equipment immediately after use.</div> <div>Recommended only for application by experienced industrial operators in industrial coating operations. Avoid contact with skin. Protective gloves are recommended. 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.</div>		0°C	10°C	21°C	32°C	Touch Dry	6 hrs	3 hrs	2 hrs	1 hr	Through Dry	7 days	24 hrs	16 hrs	10 hrs	Minimum Recoat Time	3 days	10 hrs	8 hrs	6 hrs
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