



605 AMERCOAT

MARCH 2003

Alkyd Enamel

Product Data

A single pack alkyd enamel

- Air dry
- High gloss
- Formulated for brush / roller application

Uses

For internal / external use on agricultural equipment or timber, over suitable primers. Not suitable for aggressive chemical environment.

Colour Availability

Black, White and Tinted Colours available at Point of Sale.

Packaging

Available 1L, 4L.

Substrates

Steel and Ferrous Metals.

Aluminium / Galvanised Steel – MUST be etch primed before applying rest of system.

Wood / MDF.

Total Solids Content

63.4% (wt), 44.7% (vol) – for white

Theoretical Coverage

Approximately 9.8 sq. m/litre @ 50µm DFT – for White.

Practical coverage ranges will be lower than theoretical and this must be taken into consideration when calculating costs.

Thinning and Clean Up

No thinning required for brush / roller application.

Clean gun and equipment with 254 or 475 Reducer.

Application

Brush / roller.

Drying

Dust free: 2.5 hours

Print free: 4 hours

Hard dry: Overnight (may take longer under very cold conditions).

Recoat time: Wet on wet, under 3 hours OR 24 hours to 3 days with sanding (depends on ambient conditions and film build).

Dry times may be reduced by using 600B Hardener. Mix 1L 605 with 125ml 600B. Wear and air fed mask or hood when spraying, as 600B contains ISOCYANATE. Once catalysed with 600B the paint must be used the same day.

Surface Preparation

Steel – Remove rust by blasting to SA2.5, or by using power tools or sanding. Degrease, prime.

Aluminium – Degrease, then scour with Scotchbrite. Degrease, prime.

Galv – Clean and degrease. Use a proprietary acid wash if surface has been chromate treated. Prime.

Wood – Sand and dust down. Prime.

MDF – Sand faces with 150 grit, edges with 120 grit followed by 180 grit in the opposite direction, then prime.

Safety Precautions

Read each component's material safety data sheet before use. Mixed material has hazards of each component. Safety precautions must be strictly followed during storage, handling and use.

Health & Safety

Avoid breathing vapour. Use with adequate ventilation. High concentrations of vapour may cause headache or nausea, affect the nervous system and respiration.

Do not use in the presence of naked flame or other sources of ignition. Store away from heat.

Wear safety glasses/goggles, an air supplied respirator or hood and PVC or nitrile chemical handling gloves.

If spraying in a confined area, a positive pressure air respirator should be worn.

Store/dispose of residues in accordance with local body regulations.

First Aid

If poisoning occurs, contact a doctor. The Poisons Information Centre may be of assistance – telephone 0800 POISON (NZ), 13-11-26 (Australia).

If swallowed, do NOT induce vomiting. Give a glass of water to drink and get medical attention urgently. If affected by vapour, get into fresh air immediately. If splashed into the eyes, flush them with copious quantities of clean water for 15 minutes and get urgent medical attention.

If splashed onto skin, wash with soap and water.

For further information, refer to the Material Safety Data Sheet for this product.

CAUTION:

Improper use and handling of this product can be hazardous to health.

Do not use this product without first taking all appropriate safety measures to prevent property damage and injuries. These measures may include, without limitation: implementation of proper ventilation, use of proper lamps, wearing of proper protective clothing and masks, tenting and proper separation of application areas. Consult your supervisor. Proper ventilation and protective measures must be provided during application and drying to keep spray mists and vapour concentrations within safe limits and to protect against toxic hazards. Necessary safety equipment must be used and ventilation requirements carefully observed, especially in confined or enclosed spaces, such as tank interiors and buildings.

This product is to be used by those knowledgeable about proper application methods. PPG Industries makes no recommendation about the types of safety measure that may need to be adopted because these depend on application environment and space, of which PPG Industries is unaware and over which it has no control.

If you do not fully understand these warnings and instructions or if you cannot strictly comply with them, do not use the product.

This product is for professional use only. Not for residential use.



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Substrate Systems

Preparation

Wood / MDF – Sand and dust down

Steel – Remove rust, clean and degrease

Aluminium – Scour with Scotchbrite and degrease

Galv – Clean and degrease

Substrate / Recommended System	WFT / DFT (Microns)	Overcoat Time @ 20 Degrees C	Overcoat Preparation
MILD STEEL (Interior Use Only) 1 st coat 100 Primer Surfacer 2 nd coat 605	55-85 / 25-40 90-135 / 40-60	1-8 hours Overnight	N/A Sand 360
MILD STEEL (Interior / Exterior Use) 1 st coat 238 Primacote OR 1850 Zinchro Primer 2 nd coat 605	70-110 / 25-40 65-125 / 25-50 90-135 / 40-60	1-8 hours Overnight 1-8 hours Overnight	N/A Sand 360 N/A Sand 360
ALUMINIUM / GALV (Interior / Exterior Use) 1 st coat 719 Polyetch 2 nd coat 238 Primacote OR 1850 Zinchro Primer 3 rd coat 605	70-100 / 7-10 70-110 / 25-40 65-125 / 25-40 90-135 / 40-60	15-20' 1-8 hours Overnight 1-8 hours Overnight	N/A N/A Sand 360 N/A Sand 360
WOOD (Interior / Exterior Use) 1 st coat 100 Primer Surfacer 2 nd coat 605	55-85 / 25-40 90-135 / 40-60	1-8 hours Overnight	N/A Sand 360
MDF (Interior Use Only) 1 st coat 708 Primaboard 2 nd coat 100 Primer Surfacer 3 rd coat 605	100-250 / 30-75 55-85 / 25-40 90-135 / 40-60	Overnight 1-8 hours Overnight	Sand 360 N/A Sand 360

WFT = Wet Film Thickness

DFT = Dry Film Thickness

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