



AMERBUILD 690

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Product Data

- A 2k High Build sprayable surfacing primer.
- Forms a hard matt film that is free sanding.
- Can be applied by brush, roller or conventional spray techniques.
- Build coat for durable systems, with wide range of topcoats, including epoxy and polyurethane primer surfacers.
- Suitable for immersion service. Can be used above or below water line.
- Practical 3:1 mixing ratio.
- Contains no lead or chromate pigments.
- Compatible with a wide variety of substrates and surface preparations.

Uses

Shipping and pleasure marine applications. Industrial structural steel and machinery. 690 Amerbuild is specifically designed as an intermediate sprayable surfacing compound for maintenance and fabrication applications where high builds and excellent sanding properties are demanded. Use between coats of Amerlock 2 for immersion service and under 178 HS Primer Surfacer for high quality finishes above water. Apply wet film thickness of 200-800 microns (125-500 microns DFT).

Colour Availability

White, Grey (based on hardener used)

Packaging

Amerbuild Base: 3L

Amerbuild Hardener: 1L

Mixing Ratio

Mix 3L 690A with 1L 690B

Pot Life

Once catalysed, pot life is 2 hours @ 20 deg C

Total Solids Content

70.4% (wt), 63% (vol) ready for use.

Thinning and Clean Up

Once catalysed, product is at spray viscosity. Thin with up to 5% 470T for workability, if required.

Clean gun and equipment with 470T.

Drying

150 microns DFT @ 20 deg C:

Recoat minimum – 4 hours

Hard dry – overnight

Sand – overnight

Full cure for immersion – 7 days

Theoretical Coverage

4.2 sq.m/L @ 150µm DFT, 2.1 sq.m/L @ 300µm DFT.

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

Substrates

Amerlock 2 – immersion

Blasted steel – non immersion

Fibreglass / Epoxy – well sanded

Concrete

Suitably epoxy primed surfaces – typically Amerlock 2 or similar.

Application Instructions

Surface Preparation

Steel – Remove all loose rust, dirt, grease or other contaminants by one of the following, depending on the degree of cleanliness required:

AS1627.7 Hand Tool Cleaning

AS1627.2 Power Tool Cleaning

AS1627.4 Abrasive Blasting to Class 2 or 2 ½. For more severe service or immersion, clean to Class 2 ½, profile of 50-75 microns and apply a suitable immersion primer, such as Amerlock 2. The choice of surface preparation will depend on the system selected, and end use service conditions.

Fibreglass / Epoxy – Sand and dust down. Degrease.

Suitable Epoxy Primer – Apply unsanded if aged for <1 week. Sand and degrease after this time.

Aluminium – Degrease, scour with Scotchbrite, degrease again, apply 719 Polyetch.

Application

1. Stir each component thoroughly, then combine base and hardener and mix until uniform.
2. Allow 10 minutes induction time before application.
3. Do not mix more material than can be used within potlife. Potlife is shortened at elevated temperatures.
4. For conventional spray, use adequate air pressure and volume to ensure proper atomisation.
5. Apply a wet coat in even, parallel passes; overlap each pass 50%. If required, cross spray at right angles to avoid holidays, bare areas and pinholes. Several wet coats can be applied without sags or runs occurring.
6. Normal recommended dry film thickness per coat is 150-300 microns. Airless spray application may be used, however, should not be applied at above 800 microns wet film thickness.
7. When using brush or roller application methods, multiple coats may be required to achieve proper film thickness.
8. Clean all equipment with recommended thinner immediately after use.
9. Seal surface with 178 HS Primer Surfacer or Amerprime CC22/1 before topcoating above water.

Airless spray – Wagner 7000H with G10 or G20 gun (480mm) tip, 6mm line and 15MPa fluid pressure. Equivalent equipment or pumps may be used.

Conventional spray – Use pressure pot and De Villbis JGA502 gun with E fluid tip (1.8mm) / 704 air cap. Set atomising pressure to 400-480 kPa and pot pressure according to length of line. Equivalent equipment may be used.

Rolling – Use medium nap (10mm) roller.

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. When catalysed this product contains isocyanates, which are harmful by inhalation. Refer to Code of Practice for the Safe Handling of Isocyanates 1989 (or updates) for details on handling isocyanate material.

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. Persons with a history of respiratory problems are advised not to use this product or any other two pack polyurethane.

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.

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