



american coating technologies

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Product Technical Data

AM 8400 Dry-Fall Phenolic Modified Alkyd Primer

Product Description

AM 8400 is a dry fall primer that is surface tolerant and contains a complex proprietary rust inhibitor. This primer is a phenolic modified alkyd primer that can be applied over HIGH PRESSURE water JETTING steel surface with surface rust (no sand blasting required) or over tightly adhered existing coating. AM 8400 features maximum adhesion and corrosion protection even in limited surface preparation areas. Its overspray is designed to dry to a powder within 10-20 feet from point of application allowing coating to continue without the worry of paint overspray damaging nearby vehicles and equipment.

Vehicle Type:

Phenolic Modified Alkyd

Pigmentation:

Zinc Phosphate
(Lead & Chromate Free)

Reducers:

Summer (above 80°F):
AM3000 Exempt Warm
Weather Reducer

Winter (below 80°F):
AM3200 Exempt Cold
Weather Reducer

Mix Ratio:

Single Package

Pot Life:

Not Applicable

Volume Solids:

61%

Theoretical Coverage:

976 ft² /gallon @ 1 mil DFT

VOC:

<335 g/L)

Flash Point:

24° (Lowest Flashing
Component)

Recommended DFT:

2-3 mils

Dry-time:

Normal:

To Touch:

20-30 Mins.

Tack Free:

1 Hour

To Topcoat:

Minimum
1 Hour/
Maximum
– No Limit

To Handle:

4-6 Hours

For Service:

12 Hours

Shelf Life:

1-Year Minimum

Finish:

Gloss, Semi-Gloss, Satin

Color:

Off-White

Typical Systems:

Primer:
AM 8400 (2-3 mils)

Topcoat:
AM 6800 Dry-Fall Aliphatic
Urethane (2-3 mils)

Primer:

AM 8400 (2-3mils)

Topcoat:

AM 72000 Dry-Fall Modified
Silicone Alkyd (2-3 mils)

Primer:

AM 8400 (2-3 mils)

Topcoat:

AM 6500 Dry-Fall Modified
Acrylic (2-3 mils)

Surface Preparation:

- 1) Commercial Blast SSPC-SP6 is recommended for steel when practical. Where blast cleaning is not practical, SSPC-SP3 Power Tool or SSPC-SP2 Wire Brushing is acceptable and provides excellent results. Also, Water Jetting in accordance with SSPC-SP12 is acceptable.
- 2) All surfaces to be painted should be dry and free of all foreign contaminants.

Mixing Instructions and Reduction:

AM 8400- must be reduced 20% with one of the following:

IS 3000-E AMERICAN VOC
Exempt Warm Weather Dry-Fall
Reducer for temperatures 80°F
and above?

OR—IS 3200-E AMERICAN VOC
Exempt Cold Weather Dry-Fall
Reducer for temperatures
below 80°F?

AM 3600-E AMERICAN VOC
Exempt Blending Reducer
may also be used in extreme
temperatures above 90°F to
help overspray blend in (Do not
exceed 5% reduction)

If "Fingering" occurs during the
spray application, increase the
amount of thinner, which will
decrease the viscosity of the
coating. Do not increase the
pump pressure. Maintain 1800
psi allowing +/- 25 psi for surges.

Application Requirements:

To assure Dry-Fall effect, do not
apply in temperatures below
45°F, on surfaces below 40°F, or
humidity above 85% Rh. When
humidity is above 50%, take
caution to observe the dry-fall
range as it may extend slightly
past the 20-foot mark, up to 50
feet depending on other weather
variables. **Make sure the
equipment being used will
give accurate psi readings so
the pressure from the pump
can be maintained at 1800 psi
allowing a maximum +/- 25-
psi for surges.**

The product will continue
curing to temperatures of 30°F.
Do not apply in temperatures
that are 5°F or less from the
dew point. Contact a American
representative to further review
your specific spray conditions.

Method of Application:

Airless Gun:

Graco 205-591

Pump:

30:1/45:1/60:1,
Gas Pump Acceptable

Tip Range:

3.011 – 4.013

Pump Pressure:

1800 psi allowing +/- 25 psi
for surges

Hose:

3/8 inch ID (Do not use
whip lines)

Brush or Roller:

Both are acceptable

Clean Up:

1:1 Blend MEK & Xylene

Note: Electric pumps are NOT recommended

Safety Precautions:

- 1) Use normal precautions such as gloves, facemasks and barrier creams.
- 2) Adequate ventilation must be maintained. In confined areas, workmen must wear constant flow airline respirators.
- 3) If product comes into contact with skin, wash thoroughly with lukewarm water or diluted Boric Acid, and obtain immediate medical attention.
- 4) This product contains **FLAMMABLE** materials. Keep away from sparks and open flames. Observe **NO SMOKING** regulations.
- 5) All electrical equipment and installations should conform to NEC regulations. In areas where explosion hazards exist, workmen should be required to use non-ferrous tools, and to wear conductive, non-sparking shoes.
- 6) Observe low flash regulations.
- 7) Refer to Material Safety Data Sheet (MSDS) for complete safety instructions.

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