



american coating technologies
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Product Technical Data

AM 47500 Dry-Fall Epoxy Primer

Product Description

AM 47500 IS A DRY FALL SURFACE TOLERANT modified polyamine high build epoxy primer. Its overspray is designed to dry to a powder 10 feet from the point of application when reduced and within 20 feet without reduction. This allows painting to continue without worry of paint overspray damaging nearby equipment and vehicles. AM 47500 may be applied over tightly bonded rust, mill scale or tightly bonded coatings and offers outstanding chemical, water, weathering, and corrosion protection.

Vehicle Type:

Polyamine Epoxy

Pigmentation:

Varies with Color
(Zinc Phosphate)

Reducers:

Dry-Fall outside 20 ft:
No Reduction Necessary

Dry-Fall within 10-20 ft:
10% with AM 3200 Reducer up to 80°F

10% with AM 3000 Reducer above 80°F

Mix Ratio:

9:2 Base to Activator

Pot Life:

3 Hours @77°F
(Decreases in higher temp)

Volume Solids:

45%

VOC:

<335 g/L

Theoretical Coverage:

720 ft² /gal. @ 1 mil DFT

Flash Point:

24°F (Lowest Flashing Component)

Recommended DFT:

Moderate Conditions:
2-3 mils DFT = 4.5 - 7 mils wet
mils 1-1.5 mil jagged profile is recommended

Severe Chemical & Atmospheric Conditions:

4-6 DFT applied in 1-2 Coats over a 2-3 Mil jagged profile

Shelf Life:

1-Year Minimum

Dry-time:

Recoat/Topcoat:

Min: 1-2 hrs

Max: 60 Days

Tack Free: 45 Minutes

Dry Hard: 4-6 Hours

Complete Cure:

5-7 Days @ 77°F

For Service: 24 Hours

Finish:

Flat

Color:

Off-White

Surface Preparation:

1) For immersion or under insulation (CUI), an SSPC-SP5 White Metal Blast is recommended. Commercial Blast SSPC-SP6 is recommended for steel when practical. Where blast cleaning is not practical, SSPC-SP3 Power Tool or SSPC-SP2 Hand Tool Cleaning 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:

Mix 2 Parts "A" Activator with 9 Parts "B" Base. Allow a minimum 15-minute induction period before reduction. No reduction is necessary to achieve Dry-Fall properties at 20 feet. For Dry-Fall effect within 10-20 feet, you must reduce activated material 10%. Reduce with one of the following Highland Exempt Reducers:

AM 3000 American VOC Exempt Warm Weather Dry-Fall Reducer for temperatures 80°F and above.

AM 3200 American VOC Exempt Cold Weather Reducer for temperatures below 80°F.

In extremely hot weather (+90°F), **AM 3600** Blending Reducer may be used 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.

Apply up to 6 mils per coat to achieve recommended TDFT.

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 - 4.015

Pump Pressure:

1800 psi allowing +/- 25 psi for surges

Hose:

3/8 inch ID

Brush or Roller:

Reduce 10% min with #105 B&R

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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