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Product Technical Data

AM 6800 Dry-Fall Aliphatic Urethane Topcoat

Product Description

AM 6800 Dry Fall Aliphatic Urethane Top Coat designed to be powder dry within 10-20 feet from the point of application, allowing painting to continue without the worry of overspray damage to nearby vehicles or equipment. AM 6800 offers the perfect combination of color purity, flexibility, and UV & corrosion protection in the petroleum industry even when exposed to a variety of harsh climatic and chemical environments. This product meets SSPC-Paint 36 specifications for 2-K weather-able aliphatic urethanes. This proprietary product eliminates the unsightly chalking that epoxy coating exhibit.

Vehicle Type:

Aliphatic Urethane

Pigmentation:

Varies with Color (Lead Free)

Reducers:

No Reduction necessary, if desired:

Below 80°F:

American AM 3200 Reducer

Above 80°F:

American AM 3000 Reducer

Above 80°F:

American AM 3000 Reducer

To Maintain Wet Edge:

American AM 3600 Blending Reducer (Maximum 5%)

Mix Ratio:

4:1 Base to Activator

Pot Life:

3 Hours @77°F

Volume Solids:

45% +/- 1%

Theoretical Coverage:

720 ft² /gal. @ 1 mil DFT

VOC:

<400 g/L

Flash Point:

-4°F (Lowest Flashing Component)

Recommended DFT:

2-3 mils DFT =
5 - 7.5 mils WFT

Shelf Life:

1 Year from DOM

Finish:

Gloss, Semi-Gloss, Satin

Dry-time:

To Touch: 10-15 Mins.

Tack Free: 1 Hour

To Recoat: 1 Hour

Dry Hard: 6-8 Hours

Complete Cure: 5-7 Days

For Service: 12 Hours

Color:

Selected Range

Typical Systems:

Primer:

AM 47500 Dry-Fall Epoxy (2-3 mils DFT)

Topcoat:

AM 6500 (2-3 mils DFT)

Primer:

AM 8400 Dry-Fall Phenolic Modified Alkyd 2-3 mils

Topcoat:

AM 6500 2-3 mils DFT

Primer:

AM 32500 Dry-Fall Zinc Rich Epoxy

Topcoat:

AM 6800 (2-3 mils DFT) (3-4 mils DFT)

Surface Preparation:

- 1) All surfaces to be painted should be dry and free of all foreign contaminants.
- 2) Apply over desired primer (See Typical Systems)

Mixing Instructions and Reduction:

Mix 1 Part "A" Activator with 4 Parts "B" Base. Allow a 5 minute induction period before reduction. Reduction of this product is not normally required. If desired, reduce with one of American Exempt Reducers.

Reducers:

AM 3000 American VOC

Exempt Warm Weather Dry-Fall Reducer for temperatures 80°F and above.

OR: AM 3200 American VOC Exempt Cold Weather Dry-Fall Reducer for temperatures below 80°F.

AM 3600 American Blending Reducer may also be used for extremely hot temperatures (+90°F), to help overspray blend in. (Do not exceed 5% reduction)

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 – 5.011

Pump Pressure:

1800 psi allowing
+/- 25 psi for surges

Hose:

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

Brush or Roller:

Acceptable when reduced with American AM 10500 Brush & Roll Reducer

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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