



american coating technologies
www.amcoating.com

AM 321 High Performance Urethane

Product Description

AM 321 is a two component polyester/aliphatic polyurethane floor sealer that exhibits excellent characteristics for abrasion resistance, chemical resistance, flexibility, weathering and UV stability.

Solids By Weight:

Mixed= 60% (colors); 56% (clear) (+,-2%)

Solids By Volume:

Mixed= 53% (colors); 53% (clear) (+,-2%)

Volatile Organic Content:

Less than 3.8 pounds per gallon

Standard Colors:

White, off white, light gray, medium gray, tile red, beige, and clear.

Recommended Film Thickness:

3-5 mils per coat wet thickness (yields 2-3 mils dry)

Coverage Per Gallon:

320 to 500 square feet @ 3-5 mils wet thickness.

Packaging Information:

3 gallon and 15 gallon kits 3 gal kit= 2 gallons part A (10.5#/gal-colors) or (8.75#/gal-clear) and 1 gallon part B (8.5#/gal.) (weights and volumes approximate)

Mix Ratio:

2 parts A to 1 part B by volume.

Shelf Life:

1 year

Finish Characteristics:

High gloss (>80 at 60 degrees @ glossmeter)

Abrasion Resistance:

Taber abrasor CS-17 calibrase wheel with 1000 gram total load and 500 cycles = 20.0 mg loss

Impact Resistance:

Gardner Impact, direct & reverse = 160 in. lb. (passed)

Flexibility:

No cracks on a 1/8" mandrel

Adhesion:

360 psi @ elcometer (concrete failure, no delamination)

Viscosity:

Mixed = 200-400 cps (typical, most colors)

Dot Classifications:

Part A "FLAMMABLE LIQUID N.O.S., 3, UN1993, PGIII"
Part B "FLAMMABLE LIQUID N.O.S., 3, UN1993, PGIII"

Hardness:

Shore D= 72

Cure Schedule: (70°)

Pot life – 1 1/2 gallon volume	2-5 hours
Tack free (dry to touch)	2-4 hours
Recoat or topcoat	4-8 hours
Light foot traffic	14-24 hours
Full cure (heavy traffic)	3-5 days

Application Temperature:

45-90 degrees F with relative humidity below 90%

Chemical Resistance:

Reagent	Rating
Acetic acid 5%	C
Xylene	E
MEK	B
Methyl alcohol	B
Gasoline	D
10% sodium hydroxide	E
50% sodium hydroxide	D
10% sulfuric	D
10% hydrochloric acid	D
20% nitric acid	C
Ethylene glycol	D

Rating key: A - not recommended, B - 2 hour term splash spill, C - 8 hour term splash spill, D - 72 hour immersion, E -

Recommended For

Recommended for auto service centers, warehouses, computer rooms, laboratories, aircraft hangers, cafeterias, exterior tanks, indoor or outdoor service and chemical exposure areas.

long term immersion. NOTE: extensive chemical resistance information is available through your sales representative.

Primer:

Recommend NP143/144, NP154 or NP015

Topcoat:

None recommended

Limitations:

Colors or gloss may be affected by high humidity, low temperatures, chemical exposure, or exposure to lighting such as sodium vapor lights.

For best results use a high quality 3/8" nap roller.

Slab on grade requires moisture barrier.

Substrate temperature must be 5°F above dew point.

All new concrete must be cured for at least 30 days.

Physical properties are typical values and not specifications.

Light or bright colors (white, safety yellow, etc.) may require multiple coats or a suitable color coordinated primer to achieve a satisfactory hide.

Tire contact may cause staining and discoloration.

Colors may vary from batch to batch, therefore, use only product from the same batch for an entire job.

See reverse side for application instructions.

See reverse side for limitations of our liability and warranty.

AM 321 Instructions:

1) PRODUCT STORAGE: Store product in an area so as to bring the material to normal room temperature before using. Continuous storage should be between 60 and 90 degree F.

2) SURFACE PREPARATION: Surface preparation will vary according to the type of complete system to be applied. For a one or two coat thin build system (3-10 mils dry) we recommend either mechanical scarification or acid etching until a suitable profile is achieved. For a complete system build higher than 10 mils dry, we recommend a fine brush blast (shot blast). All dirt, oil, dust, foreign contaminants and laitance must be removed to assure a trouble free bond to the substrate. A test should be made to determine that the concrete is dry; this can be done by placing a 4' X 4' plastic sheet on the substrate and taping down the edges. If after 24 hours, the substrate is still dry below the plastic sheet, then the substrate is dry enough to start coating. The plastic sheet testing is also a good method to determine if any hydrostatic pressure problems exist that may later cause disbonding.

3) PRODUCT MIXING: This product has a two to one mix ratio by volume- merely mix two gallons of part A with 1 gallon of part B. After the two parts are combined, mix well with slow speed mixing equipment such as a jiffy mixer until the material is thoroughly mixed and streak free. Avoid whipping air into the coating. Improper mixing may result in product failure.

4) PRODUCT APPLICATION: The mixed material can be applied by brush or roller. Maintain temperatures within the recommended ranges during the application and curing process. Properly prime the substrate. It is best to maintain a wet edge to avoid roller marks. Direct sunlight or high temperatures may cause visible roller marking during application. Too thick of an application may result in solvent entrapment and product failure.

5) RECOAT OR TOPCOATING: Multiple coats of this product are acceptable. If you opt to recoat this product, you must first be sure that all of the solvents have evaporated from the coating during the curing process. The information on the front side are reliable guidelines to follow. However, it is best to test the coating before recoating or topcoating. This can be done by pressing on the coating with your thumb to verify that no fingerprint impression is left. If no impression is created, then the recoat can be started. Always remember that colder temperatures will require more cure time for the product before recoating can commence. Before recoating or topcoating, check the coating to insure no contaminants exist. If a blush or contaminants are present on a previous coat, remove with a standard detergent cleaner. When recoating this product with subsequent coats of the urethane, it is advisable to apply the recoat before 24 hour passes. Also, it is advisable to degloss the previous coat to insure a trouble free bond.

6) CLEANUP: Use ketone solvents.

7) FLOOR CLEANING: Caution! Some cleaners may affect the color of the floor installed. Test each cleaner in a small area, utilizing your cleaning technique. If no ill effects are noted, you can continue to clean with the product and process tested.

8) RESTRICTIONS: Restrict the use of the floor to light traffic and non-harsh chemicals until the coating is fully cured (see technical data under full cure). It is best to let the floor remain dry for the full cure cycle.

NOTICE TO BUYER: DISCLAIMER OF WARRANTIES AND LIMITATIONS ON OUR LIABILITY

We warrant that our products are manufactured to strict quality assurance specifications and that the information supplied by us is accurate to the best of our knowledge. Such information supplied about our products is not a representation or a warranty. It is supplied on the condition that you shall make your own tests to determine the suitability of our product for your particular purpose. Any use or application other than recommended herein is the sole responsibility of the user. Listed physical properties are typical and should not be construed as specifications.

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