



american coating technologies
www.amcoating.com

AM 32500 Dry-Fall Zinc Rich Epoxy Primer

Product Description

AM 32500 is a DRY FALL SURFACE TOLERANT high performance 2-component **zinc rich epoxy primer** with 84% zinc dust in dry film. Its overspray is designed to dry to a powder 10-20 feet from point of application, allowing painting to continue without the worry of paint overspray damaging nearby vehicles and equipment. AM 32500 offers outstanding abrasion resistance and maximum protection against undercutting and corrosion by cathodic protection?

Vehicle Type:

Zinc Rich Epoxy

Pigmentation:

Zinc Dust

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 temps)

Volume Solids:

50% (+/- 1%)

VOC:

2.84 lbs/gal. (340 g/L)

Theoretical Coverage:

800 ft² /gal. @ 1 mil DFT

Flash Point:

70° (Lowest Flashing Component)

Recommended DFT:

3-4 mils DFT = 6-8 mils WFTO

Dry-time:

Recoat/Topcoat:

Min: 2-3 hrs.

Max: 28 Days

To Touch: 30 Minutes

To Handle: 3 Hours

Complete Cure:

5-7 Days @ 77°F

For Service: 24 Hours

Topcoats:

Epoxies & Urethanes only

Shelf Life:

1-Year Minimum

Finish:

Flat

Color:

Gray-Green

Surface Preparation:

1) For immersion an SSPC-SP10 Near 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 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:

Mix 2 Parts "A" Activator with 9 Parts "B" Base. Allow a minimum 15-minute induction period before application.

No reduction is necessary to achieve Dry-Fall properties over 20 ft. For Dry-Fall effect within 20 ft. 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 2100 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.

Make sure the equipment being used will give accurate psi readings so the pressure from the pump can be maintained at 2100 psi allowing a maximum +/- 25-psi for surges.

Do not apply in temperatures that are 5°F or less from the dew point. Do not use whip lines.

It is necessary to keep the material under mild agitation during application. If spraying stops for more than 30-45 minutes, re-circulate the material remaining in the spray lines.

The technical data listed herein has been compiled for your convenience and guidelines are based upon our experience and knowledge. However, since we have no control over the use of this information or this product, no warranty expressed or implied is intended or given. Highland assumes no responsibility whatsoever for coverage, performance or any other damage, including injuries from use of this information or products recommended herein.

Method of Application:

Conventional Gun:

DeVilbiss MBC-510

Fluid Tip: E

Air Cap: 704

Atomizing Pressure: 60 psi

Pot Pressure: 15-20 psi

Hose: 1/2 inch ID

Airless Gun:

Graco 205-591

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

Tip Range: 3.011 – 4.015

Pump Pressure: 2100 psi allowing +/- 25 psi for surges

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

Brush or Roller:

Reduce 10% minimum with #105 B&R Reducer

Clean Up:

1:1 Blend MEK & Xylene

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.