

AMERLOCK® 400

APPLICATION GUIDE

Amerlock® 400 is a two-component, high solids, epoxy coating, that cures to a hard semi-gloss appearance. Displaying high abrasion and chemical resistance combined with excellent adhesion to most surfaces (when prepared correctly) it excels in the protection of tanks, trucks, and floors in Grape, Wine, and Food Prep industries.

It is supplied as 1 part hardener and 1 part base, and it is **critical** that this mixing ratio is adhered to. (**1:1 ratio** no matter what amount is mixed)

Amerlock® 400 has a theoretical coverage rate of **6–8 m²/Lt** and can be applied by brush, roller, or spray application. This coverage rate creates a final film thickness of 100-125µ thick which is required to achieve the performances listed above.

PREPARATION:

Prepare all surfaces by the removal of all loose paint, mill scale, and rust. The surface to be painted must be dimensionally stable, dry, clean, and free of oil, grease, and other foreign materials. Stir each component **separately** for 5 minutes before combining, then **mix again** for a further 5 minutes.

ROLLER APPLICATION:

Dilute with 40% **Thinner 21-06** for the 1st coat, and only 15% for the 2nd coat.

SPRAY APPLICATION:

Dilute with 15-20% **Thinner 21-06** dependant on tip size/air pressure/temperature.

DRY TIME: (are extremely variable... see chart below)

Temperature	10°C	20°C	30°C	40°C
Pot Life	3 hours	2 hours	1 hour	30 mins
Touch Dry	24 hours	6 hours	3 hours	1 hour
Handle Dry	48 hours	20 hours	12 hours	8 hours
Recoat Time	36 hours	16 hours	6 hours	4 hours
Final Cure	21 days	7 days	4 days	3 days

It is important to note that the substrate temperature during application and curing should also fall between 5°C and 40°C. (Ideally 15-25°C).

***** Thinner 737 has been superseded by Thinner 21-06 to dilute/clean-up Amerlock® 400 *****