

# Amercoat® 229T

229 Series

Gloss epoxy acrylic topcoat

## Product Data/ Application Instructions

- Gloss topcoat with unlimited recoatability
- Combines the durability and toughness of epoxy with the color and gloss retention of the acrylic polymer
- Low VOC
- Resistant to a broad range of corrosive atmospheres
- Resists soil pickup – cleans easily
- Hard, flexible and abrasion resistant

### Typical Uses

Amercoat 229T can be used as a finish coat where attractive appearance and a wide range of corrosion resistance is required.

- All above-water areas on ships
- Dock side structures and equipment
- Off shore platforms
- Petroleum refineries and containers
- Chemical plants
- General industrial and marine applications

### Typical Systems

1st Coat	2nd Coat	3rd Coat
Amercoat 235, Amercoat 240, Amercoat 370 or Amercoat 385	Amercoat 229T	—
Amerlock Series	Amercoat 229T	—
Amercoat 68HS or Amercoat 302H	Amercoat 385	Amercoat 229T

### Physical Data

Finish	Gloss	
Color*	See color card	
Components	2	
Mixing ratio (by volume)	4 parts resin to 1 part cure	
Curing mechanism	Solvent release and chemical reaction between components	
Volume Solids	56% ± 3%	
VOC (EPA Method 24)	lb/gal	g/L
unthinned	3.2	384
thinned (½ - pint/gal)	3.5	420
Dry film thickness (per coat)	2-4 mils (50-100 microns)	
Coats	1 or 2	
Theoretical coverage	ft <sup>2</sup> /gal	m <sup>2</sup> /L
2 mil	449	11.0
4 mils	224	5.5
Temperature resistance, dry	°F	°C
continuous	200	93
intermittent	250	121
Flash Point	°F	°C
cure	80	27
resin	108	42
Amercoat 65	78	25
Amercoat 101	145	63
Amercoat 12	2	-17
Thinners	Amercoat 65, 101	
Cleaner	Amercoat 12	

*\*Certain colors (especially yellow, red and orange) may require additional coats to achieve adequate hiding, particularly when applied over dark or contrasting primer color. Color variance with rapid response tinted colors may be greater than with standard production batches. If color is critical, change batches at natural breaks in structure or intermix batches for consistency.*

*Yellow, red and orange colors will fade faster than other colors due to the replacement of lead-based pigments with lead-free pigments in these colors.*

## Chemical Resistance Guide

When applied over suitable primer or intermediate coat:

Environment	Splash and Spillage	Fumes and Weather
Acidic	VG	E
Alkaline	VG	E
Solvents	G	E
Salt solutions		
Acidic	E	E
Neutral	E	E
Alkaline	E	E
Water	E	E
G-Good	VG-Very Good	E-Excellent

*This table is only a guide. For specific recommendations, contact your PPG representative for your particular corrosion protection needs. Amercoat 229T is not recommended for immersion service.*

## Surface Preparation

Coating performance, in general, is proportional to the degree of surface preparation. Refer to application instructions for specific primers and intermediate coats being used for application and curing procedures. All previous coats must be clean and dry. Adhere to all minimum and maximum topcoat times for specific primers and intermediate coats. Aged epoxy coatings must be roughened before applying Amercoat 229T.

**Aged coating** – All surfaces must be clean, dry, tightly bonded and free of all loose paint, corrosion products or chalky residue. Clean by pressure water cleaning (1000 psi or greater), then abrade the surface per SSPC-SP2, 3, or 7. Amercoat 229T is compatible over most types of properly applied and tightly adhering coatings. However, a test patch is recommended to confirm compatibility.

## Application Data

Substrates	Prepared and primed steel, concrete, aluminum, galvanizing, or aged coatings.		
Surface preparation:	Refer to Product Data Sheet/ Application Instructions of specific primer or intermediate coat being used.		
Method	Airless or conventional spray, roller, brush (touch-up only)		
Mixing ratio (by volume)	4 parts resin to 1 part cure		
Environmental conditions	°F	°C	
air and surface temp	40 to 120	5 to 49	
material temp	50 to 90	10 to 32	
Surface temperatures must be at least 5°F (3°C) above dew point to prevent condensation.			
Induction time (minutes)			
relative humidity < 70%	none		
relative humidity > 70%	30		
Pot life (hours)	F°/C°		
	90/32	70/21	50/10
	3	6	8
Dry times	F°/C°		
	90/32	70/21	50/10
touch (hours)	1	2	4
through (hours)	6	8	16
Recoat times	F°/C°		
	90/32	70/21	50/10
minimum (hours)	4	6	10
maximum	Unlimited*		
*Surface must be dry and free of all contaminants.			
Thinner	Amercoat 65, 101		
Equipment cleaner	Amercoat 12		

## Application Equipment

The following is a guide; suitable equipment from other manufacturers may be used. Changes in pressure and tip size may be needed for proper spray characteristics.

**Airless spray**—Standard equipment such as Graco, DeVilbiss, Binks, Speeflo, or others having a 30:1 or higher pump ratio and a fluid tip with 0.017- to 0.021-inch orifice.

**Conventional spray**—Industrial equipment such as DeVilbiss or Binks spray gun. Separate air and fluid pressure regulators, and a moisture and oil trap in main air supply line are recommended.

**Brush or roller** - Natural bristle brush or solvent-resistant roller with ¼-inch to ⅜-inch nap. For best appearance when rolling, level any air bubbles with bristle brush.

## Application Procedure

Amercoat 229T is packaged in two components in the proper proportions which must be mixed together before use:

1. Flush equipment with thinner or Amercoat 12 before use.
2. Stir each component thoroughly, then add cure to resin and mix until uniformly blended to a workable consistency. Do not mix more material than will be used within 6 hours at 65-80°F (18-27°C). Pot life is shortened by higher temperatures. See pot life data.
3. If relative humidity is less than 70%, no induction time is required. If relative humidity is 70% or greater, allow the mixed material to sit for 30 minutes prior to the start of the application. After the induction periods has elapsed, stir the mixed material again to ensure that it is uniformly blended, then proceed with the application.
4. Thin only if necessary for workability.
5. When applying by conventional spray, use adequate air pressure and volume to ensure proper atomization.
6. Apply a wet coat in even parallel passes, overlap 50 percent to avoid holidays, bare areas and pinholes. If required, cross spray at right angles.
7. Application of 5.4 mils (135 microns) wet film thickness will normally provide 3 mils (75 microns) dry film.
8. Clean all equipment with thinner or Amercoat 12 immediately after use.

## Shipping Data

Packaging units	1 gal	5-gal
cure	0.2 gal in 1-qt can	1 gal in 1-gal can
resin	0.8 gal in 1-gal can	4 gal in 5-gal can
Shipping weight (approx)	lb	kg
1-gal unit		
cure	3	1.4
resin	11	5.0
5-gal unit		
cure	9	4.1
resin	55	25

Shelf life when stored indoors at 40 to 100°F (4 to 38°C)  
resin and cure 1 year from shipment date

## Safety Precautions

Read each component's material safety data sheet before use. Mixed material has hazards of each component. Safety precautions must be strictly followed during storage, handling and use.

**CAUTION – Improper use and handling of this product can be hazardous to health and cause fire or explosion.**

**Do not use this product without first taking all appropriate safety measures to prevent property damage and injuries. These measures may include, without limitation: implementation of proper ventilation, use of proper lamps, wearing of proper protective clothing and masks, tenting and proper separation of application areas. Consult your supervisor. Proper ventilation and protective measures must be provided during application and drying to keep spray mists and vapor concentrations within safe limits and to protect against toxic hazards. Necessary safety equipment must be used and ventilation requirements carefully observed, especially in confined or enclosed spaces, such as tank interiors and buildings.**

**This product is to be used by those knowledgeable about proper application methods. PPG makes no recommendation about the types of safety measures that may need to be adopted because these depend on application environment and space, of which PPG is unaware and over which it has no control.**

**If you do not fully understand these warnings and instructions or if you cannot strictly comply with them, do not use the product.**

**Note:** Consult Code of Federal Regulations Title 29, Labor, parts 1910 and 1915 concerning occupational safety and health standards and regulations, as well as any other applicable federal, state and local regulations on safe practices in coating operations.

***This product is for industrial use only. Not for residential use.***



**PPG Protective & Marine Coatings**  
www.ppgmc.com

One PPG Place, Pittsburgh, PA 15272 • Tel: (800) 441-9695