

**HPC/Industrial Maintenance****AQUAPON® High Build Semi-Gloss Polyamide-Epoxy Coatings****Generic Type**

Polyamide-Epoxy Two Component

Tinting and Base Information

These products are designed to be tinted with PerformaColor colorants. Use formulas from the Aquapon High Build section of the formula book or from the PerformaColor® Software. Do not tint with 96 line custom colorants.

97-1200	Neutral Base
97-1212	White Base
97-130	Porcelain White
97-131	Light Gray
97-137	Tint Base Comp. B Catalyst
97-139	RM Color Comp. B Catalyst

General Description

Aquapon High Build Semi-Gloss Polyamide-Epoxy Coatings are high build, corrosion resistant finishes that have excellent hardness, abrasion and mar resistance and outstanding adhesion qualities. They are recommended for heavy duty service in corrosive industrial atmospheres. The 97-130/97-139 are recommended for some immersion service when applied over properly prepared and primed steel. Also can be applied over hot dipped galvanized steel, aluminum, masonry, well-cured plaster, cement fiberglass composite, wood or concrete.

Recommended Uses

Aluminum
Bare Wood
Masonry
Steel

Features / Benefits

Fully 3.5 VOC compliant
Virtually infinite color capability with PerformaColor system
Perfect for hard use areas in corrosive industrial environments.
Resistant to spills, splashes, dust or fumes from a variety of acidic and caustic chemicals
Simple 1:1 blend ratio

Limitations of Use

Apply only when air, surface and product temperatures are above 50°F (10°C) and at least 5°F (3°C) above the dew point. The solvents contained in Aquapon High Build Semi-Gloss Coatings will lift alkyd and oil based films, as well as other coatings not resistant to these solvents. Testing of a small area is recommended. These coatings are NOT recommended for use in swimming pools, or for horizontal surface immediately adjacent to pools. Only the 97-130, Porcelain White, or the 97-131, Light Gray should be used as linings. Not recommended for below grade application to masonry. These coatings lose gloss and will chalk on prolonged exterior exposure. However, coating performance is not affected. Not recommended for use where the following material create a severe exposure: Acetic Acid, Amines, Ammonium Hydroxide at concentrations over 10%, Calcium Hypochlorite Chlorinated Solvents, Chromis Acid, Formaldehyde, Hydrogen Peroxide, Hydraulic Fluids containing Phosphate Esters, PVA Latex, Silage Acids, and Sodium Hypochlorite. Not intended for residential use.

Product Data

Gloss:	Semi-Gloss: 20 to 40 (60°Gloss Meter)
VOC*:	3.10 lbs/gal 372.00 g/L
Coverage:	153 to 229 sq ft/gal (14 to 21 sq. m/3.78L)
<i>Note: Does not include loss due to varying application method, surface porosity, or mixing.</i>	
DFT:	4.0 minimum to 6.0 maximum
Weight/Gallon*:	11.4 lbs. (5.5 kg) +/- 0.2 lbs. (91 g)
Volume Solids*:	57% +/- 2%
Weight Solids*:	73% +/- 2%
Mix Ratio:	1 part Comp. A to 1 part Comp. B
Clean-up:	PPG 97-725 Epoxy Thinner

Results will vary by color, thinning and other additives.

*Product data calculated on mixed 97-130

Drying Time:

To Touch:	2 hours
To Handle:	10 hours
To Recoat:	24 hours

Dry Time @77°F (25°C); 50% relative humidity

Pot Life: 4 hours

In Service Temperature:

Dry Heat (F): 250° Dry Heat (C): 121°

Flash Point:	97-130 40°F, (4.4°C)
	97-139 78°F, (25.6°C)
	97-131 50°F, (10°C)

Remove all loose paint, mill scale, and rust. The surface to be coated must be dimensionally stable, dry, clean, and free of oil, grease, release agents, curing compounds, and other foreign materials. Where appropriate bare areas should be primed with a suitable primer.

PREVIOUSLY PAINTED SURFACES: Old coatings should be tested for adhesion of the existing system and lifting by the proposed topcoat.

FERROUS METAL: Non-Immersion Service -- minimum surface preparation for ferrous metal substrates is SSPC-SP6, commercial blast. Immersion Service -- Near white blast, SSPC-SP10, and the use of the proper primer is mandatory for ferrous metals.

ALUMINUM: SSPC-SP1, brush blast to remove contaminants and provide an anchor pattern prior to coating. If the blasting is not done, the aluminum must be pretreated with Polyclutch® Wash Primer, 97-687/688. Note, the Polyclutch Wash Primer must dry overnight before applying the 97-130 Aquapon® High Build Semi-Gloss Polyamide-Epoxy Coatings.

HOT DIPPED GALVANIZED STEEL: Stabilizers on the surface of the galvanized steel must be removed by either brushing or chemical treatment prior to coating to promote adhesion.

NEW CONCRETE: These surfaces should be either acid etched or brush blasted prior to coating.

NEW WOOD: These products are self-priming. All previous coatings must be removed if repainting of wood is required.

HPC Systems in Detail Brochure-COATING SYSTEMS: 198-HD, 217-HD, 218-HD, 294-HD, 295-HD, 296-HD, 331-HD, 350-HD, 435-HD.

Recommended Primers

Galvanized Steel	95-245
Non-Ferrous Metal	95-245
Ferrous Metal	97-680, 95-245
Wood and Hardboard	Self Priming
Concrete, Stucco, Plaster, Masonry other than CM Uni	Self Priming
Concrete Block	16-90, 97-685/97-686

Directions for Use

Mix both components thoroughly before blending. Add the correct Component "B" to Component "A" and blend well using a mechanical mixer. A 30 minute digestion time is required once the two components are combined and mixed thoroughly. Addition of 97-723 Accelerator is not recommended for these products. Air or airless spray is recommended. Read all label and Material Safety Data Sheet (MSDS) information prior to use. MSDS are available through our website or by calling 1-800-441-9695.

Permissible temperatures during application:

Material:	50 to 90°F	10 to 32°C
Ambient:	50 to 100°F	10 to 38°C
Substrate:	50 to 130°F	10 to 54°C

PPG AF believes the technical data presented in this bulletin is currently accurate; however, no guarantee of accuracy, comprehensiveness, or performance is given or implied. Improvements in coatings technology may cause future technical data to vary from what is in this bulletin. For complete, up-to-date information visit our web site or call 1-800-441-9695

Application Information

Recommended Spread Rates:

Wet Mills :	7.0 minimum to	10.5 maximum
Wet Microns:	178.0 minimum to	267.0 maximum
Dry Mills :	4.0 minimum to	6.0 maximum
Dry Microns:	102.0 minimum to	152.0 maximum

Application Equipment: Changes in application equipment, pressures and/or tip sizes may be required depending on ambient temperatures and application conditions.

Conventional Spray: Fluid Nozzle: DeVilbiss gun, with 704 or 777 air cap with E tip and needle, or comparable equipment.

Atomization Pressure: 55 - 70 Fluid Pressure: Can not specify, dependent on numerous factors.

Airless Spray: Pressure 1500 psi, tip 0.015" - 0.021"

Brush: Not Recommended

Roller: Not Recommended.

Thinning:

Ready-Mixed colors can be reduced 12 oz. per gallon with the 97-725 Epoxy Thinner for either conventional air spray or airless spray applications. Do not thin beyond regulations in VOC regulated areas.

Packaging: 1-Gallon (3.78L) 5-Gallon (18.9L)

Not all products are available in all sizes.



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One PPG Place
Pittsburgh, PA 15272

www.pittsburghpaints.com

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International Sales:
(412) 434-2049

PPG Coatings, Inc.
Coatings and Resins Group
5546 Timberlea Blvd.
Mississauga, Ontario L4W2T7
(905) 238-6441

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Additional copies of this bulletin can be obtained from our web site or by calling 1-800-428-7806.

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