



AMERGLOSS 595F

MARCH 2005

Polyurethane

Product Data

595F is a two pack acrylic polyurethane spraying enamel, with the following features:

- Fast drying
- Hard, high gloss finish
- Excellent exterior durability, highly resistance to yellowing and chalking
- Good UV resistance – contains UV absorbers
- Resistant to a wide range of chemicals and cleaning agents:
 - 5% Aqueous Sodium Hydroxide – no effect
 - 5% Aqueous Hydrochloric Acid – slight gloss loss, no softening
- Excellent abrasion resistance
- Excellent heat resistance: 110C continuous, 130C intermittent

The hardener is based on aliphatic polyisocyanate.

Uses

595F is suitable for a wide variety of end uses where a durable, tough, chemical resistant finish is required – trucks, buses, machinery, excavators, marine etc.

Colour Availability

A full range of colours and clear available at Point of Sale.

Packaging

Base: 5L in 10L can

Hardener: 1L

Mixing Ratio

Mix 5L Base with 1L Hardener

Pot Life

Once catalysed, pot life is 2 hours.

Total Solids Content

63% (wt), 53% (vol) – catalysed.

Theoretical Coverage

Approximately 14 sq. m/litre @ 40µm DFT (catalysed).

Practical coverage rates will be lower than theoretical and this must be taken into consideration when calculating costs.

Thinning and Clean Up

Thin up to 25% with 475.

Clean equipment with 254 or 475.

Application

Spray – conventional, pressure pot, airless.

Do NOT apply by hot spray.

Brush – small areas only.

Not recommended for Dip or Flowcoat, because of limited pot life.

Drying

Dust Free: 30 mins

Touch Dry: 60 mins

Dry to Tape: 8 hours

Recoat Time: Wet on wet – under 2 hours OR over 12hours with sanding.

Original Finish – Sand and dust down. Degrease

Application Instructions

Substrates

Steel and Ferrous Alloys, suitable primed.

Aluminium / Galvanised Steel – MUST be preprimed with 719 Polyetch.

Wood / MDF, suitably primed.

Sanded original baked enamel or 2K enamel in good condition.

Surface Preparation

Steel – Remove rust by blasting to SA2.5, or by using power tools or sanding. Degrease.

Aluminium – Degrease. Scour with Scotchbrite. Degrease again.

Galvanised Steel – Clean and degrease. Use a proprietary acid wash if the surface has been chromate treated.

Wood – Sand and dust down.

MDF – Sand faces with 150 grit, edges with 120 grit followed by 180 grit in the opposite direction.

Substrate Systems

Preparation

Steel – Remove rust, clean and degrease

Aluminium – Scour with Scotchbrite and degrease

Galv – Clean and degrease

Wood – Sand and dust down

MDF – Sand and dust down

Substrate / Recommended System	WFT / DFT (Microns)	Overcoat Time @ 20 Degrees C	Overcoat Preparation
STEEL 1 st coat 178HS Primer OR 1894 Etch Primer 2 nd coat 595F	90-135 / 50-75 155-200 / 20-25 70-95 / 37-50	16 hrs 1-6 hrs 16 hrs plus	Sand 360 N/A Sand 320
STEEL (Aggressive Conditions) 1 st coat 719 Polyetch 2 nd coat 178HS Primer 3 rd coat 595F	70-100 / 7-10 90-135 / 50-75 70-95 / 37-50	20' – 8 hours 16 hours	N/A Sand 360
ALUMINIUM / GALV (2 coat system) 1 st coat 719 Polyetch 2 nd coat 595F	70-100 / 7-10 70-95 / 37-50	20' – 8 hours	N/A
ALUMINIUM / GALV (3 coat system) 1 st coat 719 Polyetch 2 nd coat 178HS Primer 3 rd coat 595F	70-100 / 7-10 90-135 / 50-75 70-95 / 37-50	20' – 8 hours 16 hours	N/A Sand 360
MDF/WOOD-Interior (Pigmented Finish) 1 st coat 708 Primaboard 2 nd coat 595F	70-170 / 30-75 70-95 / 37-50	16-24 hours	Sand 360
WOOD – Interior (Clear Finish) 1 st coat 700 Urethane Sealer 2 nd coat 595F Clear	95-140 / 20-30 70-95 / 37-50	16-24 hours	Sand 360



AMERCOAT 595F

MARINE SYSTEMS

FIBREGLASS / EPOXY (Hull Above Waterline) 1 st coat Amercoat CC22 2 nd coat 178HS Primer 3 rd coat 595F	120-180 / 50-75 90-135 / 50-75 70-95 / 37-50	3 hours – 1 month 16 hours	N/A Sand 360
FIBREGLASS / EPOXY (Topsides / Decks) 1 st coat Amerlock 2 2 nd coat 178HS Primer 3 rd coat 595F	150-180 / 125-150 90-135 / 50-75 70-95 / 37-50	3 hours – 1 week 16 hours	N/A Sand 360
STEEL (Hull Above Waterline) 1 st coat Amerlock 2 2 nd coat 178HS Primer 3 rd coat 595F	150-180 / 125-150 90-135 / 50-75 70-95 / 37-50	3 hours – 1 week 16 hours	N/A Sand 360
STEEL (Topsides / Decks) 1 st coat Amerlock 2 2 nd coat 178HS Primer 3 rd coat 595F	150-180 / 125-150 90-135 / 50-75 70-95 / 37-50	3 hours – 1 week 16 hours	N/A Sand 360
FERRO CEMENT (Hull Above Waterline) 1 st coat Amerlock Sealer 2 nd coat Amerlock 2 3 rd coat 178HS Primer 4 th coat 595F	38 / 38 150-180 / 125-150 90-135 / 50-75 70-95 / 37-50	24 hours – 1 month 3 hours – 1 week 16 hours	N/A N/A Sand 360
FERRO CEMENT (Topsides / Decks) 1 st coat Amerlock Sealer 2 nd coat Amerlock 2 3 rd coat 178HS Primer 4 th coat 595F	38 / 38 150-180 / 125-150 90-135 / 50-75 70-95 / 37-50	24 hours – 1 month 3 hours – 1 week 16 hours	N/A N/A Sand 360
TIMBER (Hull Above Waterline) 1 st coat CC22 2 nd coat 178HS Primer 3 rd coat 595F	120-180 / 50-75 90-135 / 50-75 70-95 / 37-50	3 hours – 1 month 16 hours	N/A Sand 360

TIMBER (Topsides / Decks) 1 st coat Amerlock 2 2 nd coat 178HS Primer 3 rd coat 595F	150-180 / 125-150 90-135 / 50-75 70-95 / 37-50	3 hours – 1 week 16 hours	N/A Sand 360
ALUMINIUM (Hull Above Waterline) 1 st coat 719 Polyetch 2 nd coat Amerlock 2 3 rd coat 178HS Primer 4 th coat 595F	70-100 / 7-10 150-180 / 125-150 90-135 / 50-75 70-95 / 37-50	20' – 8 hours 3 hours – 1 week 16 hours	N/A N/A Sand 360
ALUMINIUM (Topsides / Decks) 1 st coat 719 Polyetch 2 nd coat Amerlock 2 3 rd coat 178HS Primer 4 th coat 595F	70-100 / 7-10 150-180 / 125-150 90-135 / 50-75 70-95 / 37-50	20' – 8 hours 3 hours – 1 week 16 hours	N/A N/A Sand 360

WFT = Wet Film Thickness

DFT = Dry Film Thickness

CAUTION:

Improper use and handling of this product can be hazardous to health.

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 vapour 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 Industries makes no recommendation about the types of safety measure that may need to be adopted because these depend on application environment and space, of which PPG Industries 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.

This product is for professional use only. Not for residential use..

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