NAVSEA REVIEWED ASTM F-718

PPG Protective and Marine Coatings

Amercoat 3258

NAVSEA Standard Item 009-32

If this product is to be applied as part of a coating system, all components of the system must be as listed on the QPL.

This NAVSEA-REVIEWED ASTM F-718 data sheet is the only data sheet approved for use when utilizing this coating for U.S. Navy preservation projects. NAVSEA's review covers only the application process for the material. The review does not denote the material as a qualified product, nor does it constitute an approval for purchase/procurement of the material. For products on the Qualified Products List (QPL) for this MILSPEC, please refer to https://assist.daps.dla.mil/quicksearch/

Questions regarding modifications or updates of this ASTM F-718 shall be directed toward:

NSWCCD
(215) 897-7411
nswccd_astm_f718@navy.mil

ASTM F 718

SHIPBUILDERS AND MARINE PAINTS AND COATINGS PRODUCT/PROCEDURE DATA SHEET

CONTINUATION SHEET USED: ☐ YES ☒ NO

Date: 5/2009 Rev.2

I. GENERIC TYPE AND DESCRIPTION: Epoxy Polyamide Anti-corrosive Coating System
Specification Number, Type, Class and/or Grade (If Applicable): NAVSEA Standard Item 009-32

II. MANUFACTURERS DATA:

(a) MANUFACTURER: PPG Protective and Marine Coatings
11065 Vimy Ridge Road
Alexander, AR 70022

(b) PRODUCT DESIGNATION: Amercoat 3258

(c) COLOR(S): Green Primer, Haze Gray Midcoat, Dark Gray Topcoat

(d) USES: Anti-corrosive epoxy system for NAVSEA, underwater hull appendages on minesweepers

(e) TECHNICAL SERVICE REPRESENTATIVE
(Include Telephone Nos.): Paul Whitehead 800-661-4774

(f) NOT RECOMMENDED FOR: potable water tanks

III. PROPERTIES:

(a) % VOLUME SOLIDS (ASTM D 2697): 59% +/- 2%

(b) % WEIGHT SOLIDS (ASTM D 1475): 74% +/-3%

(c): FLASH POINT (ASTM TEST METHOD D 93 OR D 56 OR D 3278): 100 °F minimum

(d): WEIGHT PER VOLUME: (FTMS 141a4184.1): 10.1-11.0 lbs/gallon

(e) % EDGE RETENTION (IF REQUIRED BY APPLICABLE SPECIFICATION): NA

(f): SHELF LIFE: 3 years from date of manufacture (both components)

(g) VISCOSITY (STATE TEST METHOD TO BE USED: ASTM D 562): COMPONENT A: 85 +/- 10 KU

COMPONENT B: 64-89 KU

MIXED: 80 +/- 10 KU

(h) PACKAGING: 2 gallon kits or 10 gallon kits

(i): NUMBER OF COMPONENTS: 2

(j) GLOSS (ASTM D 523): 15-40 units (@ 60 degrees)

(k) STORAGE REQUIREMENTS: TEMP. MIN. 40 °F MAX. 100 °F

ADDITIONAL PAINT STORAGE REQUIREMENTS: NA

(l) VOLATILE ORGANIC COMPOUND (EPA TEST METHOD 24): 335 g/L (2.79 lb/gal)

(m) WEIGHT OF DRY FILM (WEIGHT/FT^2 AT 1 MIL THICKNESS): 0.008 lbs +/ 3%

(n): SPECIAL PROPERTIES (e.g., STAIN RESISTANCE, LOW SOLAR ABSORBANCE, MOISTURE TOLERANCE): NA

IV. SURFACE PREPARATION MINIMUM REQUIREMENTS (USE SPECIFIC STANDARD NUMBERS):

(a) INITIAL - SSPC SP-10 using aluminum oxide or garnet or SSPC SP-12 WJ-2 (L)

(b) TOUCH-UP – Power tool clean to bare metal in accordance with SSPC SP-11

(c) PROFILE (INCLUDE METHOD USED) - MIN. 2.0 mils MAX. 4.0 mils (Testex Tape)

(d) SPECIAL INSTRUCTIONS - NA

(e) PRIMER REQUIREMENTS (IF APPLICABLE): Amercoat 3258 Green

(f) MAXIMUM ALLOWABLE CONDUCTIVITY (BRESLE PATCH METHOD): 30 mg/m^2 for immersed areas, 50 mg/m^2 for non-immersed areas IAW NSI 009-32

(g) MAXIMUM DEGREE OF FLASH RUSTING ALLOWABLE (LIST COMMERCIAL STANDARD): SSPC-SP 12/WJ 2 (L)

SPECIAL SAFETY PRECAUTIONS:
Refer to Material Safety Data Sheet

V. MIXING PROCEDURES:

(a) MIXING RATIOS BY WEIGHT - NA
BY VOLUME – 1 part component A : 1 part component B

(b) INDUCTION TIME – 1 hour at 70-90°F, 2 hours at 50°F

(c) RECOMMENDED SOLVENT – THINNING – NO THINNING ALLLOWED
CONFINED AREAS - NO THINNING ALLOWED
NON-CONFINED AREAS - NO THINNING ALLOWED
CLEAN UP - Amercoat 12 or T-10 Thinner

(d) THINNING REQUIREMENTS (RATIO) – NO THINNING ALLOWED

(e) POT LIFE - 8 Hr(s) @ 50°F (10ºC)

5 Hr(s) @ 70°F (21ºC)

2 Hr(s) @ 90°F (32ºC)

(f) SPECIAL INSTRUCTIONS – Mix each component with a power agitator using a "jiffy" type impeller. Ensure the sides and bottom are scraped to incorporate settled solids. Mix part B Into Part A. Mix the combined material with a power agitator.

VI. APPLICATION:

(a) ENVIRONMENTAL LIMITATIONS -

SUBSTRATE TEMPERATURE: MIN. 50°F MAX. 120°F

MINIMUM SUBSTRATE TEMPERATURE DIFFERENCE ABOVE THE DEW POINT 5°F

RELATIVE HUMIDITY: Refer to NAVSEA Standard Item 009-32

AMBIENT TEMPERATURE: MIN. 35°F MAX. 100°F

(b) FILM THICKNESS (SSPC-PA 2):

PER COAT:
WET MIN. 5 mils WET MAX. 8.3 mils

DRY MIN. 3 mils DRY MAX. 5 mils

TOTAL SYSTEM:

DRY MIN. 9 mils DRY MAX. 15 mils

(c) DRY TIMES (ASTM D 1640) –

	90°F (32°C)	70°F (21°C)	50°F (10°C)	40°F (5°C)
Dry to Recoat (min)*	2 hours	3 hours	8 hours	24 hours
Maximum recoat *	5 days	7 days	14 days	30 days
Dry to Handle	4 hours	6 hours	18 hours	48 hours
Full Service	4 days	7 days	14 days	21 days

* Epoxy must be tack free, but soft to finger pressure prior to overcoating with antifouling paint

(d) EQUIPMENT REQUIREMENTS (INCLUDE PREFERRED, SUITABLE, NOT SUITABLE REQUIREMENTS) – Airless spray (minimum 30::1 pump ratio, 0.017-0.021 tip), conventional spray, brush (natural bristle), roller (phenolic core)

IF PLURAL COMPONENT EQUIPMENT IS REQUIRED, STATE SO - NA

IF HEATED LINES ARE REQUIRED, STATE SO - NA

(e) SPECIAL INSTRUCTIONS - NA

REPAIR PROCEDURES IF THE OVERCOAT WINDOW HAS BEEN EXCEEDED: Refer to NAVSEA Standard Item 009-32, surface must be uniformly abraded and solvent wiped.