



## AP-LOCK

(RX Series, American Coatings)

### RECOATABLE EPOXY PRIMER

66% volume solids, epoxy primer for use over hand cleaned, water blasted, or sandblasted surfaces.

#### GENERAL FEATURES

- EXCELLENT CORROSION PROTECTION
- INDEFINITE RECOATABILITY
- FAST CURE
- CURES AT LOW TEMPERATURE
- CAN BE USED WITH A VARIETY OF TOPCOATS

#### DESCRIPTION

Although optimum performance is achieved over sandblasted surfaces this coating is surface tolerant. It may be applied over marginally prepared steel surfaces where it is not possible to abrasive blast. It may be applied over old and aged coating systems that have been hand-prepared, and are free of oil, contaminants and loose paint flakes. This coating is infinitely recoatable and can be topcoated with alkyds, epoxies or polyurethanes. It offers excellent corrosion protection in moderate to severe conditions

#### USES

AP-LOCK Epoxy can be AP-LOCK can be used on structural steel, tank exteriors, hulls, decks, bulkheads and offshore structures. AP-LOCK can be applied over slightly rusty or damp surfaces. It is an excellent choice as a primer for drilling rigs.

**NOTE:** AP-LOCK has indefinite recoatability; however, follow good paint practices by removing dirt, chalk, and other foreign matter before topcoating.

#### PRODUCT COLORS

AP-LOCK Buff 22  
AP-LOCK White 23  
AP-LOCK Gray 24  
AP-LOCK Black 25  
AP-LOCK Aluminum 26

#### PHYSICAL DATA

Finish \_\_\_\_\_ Eggshell  
Color \_\_\_\_\_ White, Buff, Gray, Aluminum, Black  
Applied Over \_\_\_\_\_ Steel, Aluminum  
Components \_\_\_\_\_ Two  
Cure \_\_\_\_\_ Catalytic  
Mixing Ratio (by Volume): \_\_\_\_\_ 4:1  
VOC \_\_\_\_\_ 2.51 lbs./gal  
Volume Solids ± 2% \_\_\_\_\_ 66 %

#### Recommended Film Thickness

Wet \_\_\_\_\_ 225 – 300µ  
Dry \_\_\_\_\_ 150 – 200µ  
Application Method \_\_\_\_\_ Airless or Conventional Spray, Brush or Roller  
Thinning Required \_\_\_\_\_ 0 – 10%, AP-THINNER 770  
Induction Time \_\_\_\_\_ None

#### <sup>1</sup>Theoretical Coverage at:

Recommended Thickness \_\_\_\_\_ 16 – 12 m<sup>2</sup>/gal

Dry Times @ 50% RH	25°C	4°C
TOUCH	1 HR	2 HR
TACK FREE	4 HR	10 HR
TOP COAT	10 HR	48 HR

#### Temperature Limit

Immersed \_\_\_\_\_ not recommendable  
Atmospheric \_\_\_\_\_ 93°C

#### Miscellaneous Properties

Shelf Life \_\_\_\_\_ 1 year  
Pot Life – Mixed @ 25°C \_\_\_\_\_ 2-3 hours  
Mixed @ 32°C \_\_\_\_\_ 1 hours

**CAUTION:** ELEVATED TEMPERATURES DRAMATICALLY REDUCE POT LIFE

#### SURFACE PREPARATION

Commercial Blast (SSPC - SP6/NACE 3) preferred. When blasting unavailable power tool or hand clean. Surfaces should be free of dust, dirt, oils, moisture and other contaminants.

#### PERFORMANCE DATA

TESTS	RESULTS
<b>HARDNESS</b> ASTM D-3363	HB
<b>WEIGHT</b> ASTM D-1200	AVG 4.7 Kg/gallon
<b>IMPACT</b> (ASTM G-14)	20 inch pounds direct 10 inch pounds reverse
<b>SOLVENT RESISTANCE</b> (ASTM D-5402)	200 + after 7 days
<b>TAPE ADHESION</b> (ASTM D-33359 A / B)	5A and 5B
<b>PULL OFF ADHESION</b> (ASTM D – 4541)	1000+ psi (Elcometer)
<b>SPECULAR GLOSS</b> (ASTM D-523)	25 units at 60 degrees
<b>SAG RESISTANCE</b> (ASTM D-4400)	400µ
<b>OIL IMMERSION D</b> (ASTM D-1308)	Passes 1000 Hours
<b>SALT FOG RESISTANCE</b> (ASTM B-117)	Passes 1000 Hours

<sup>1</sup>Coverages are theoretical and do not make provision for spray losses.



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### APPLICATION METHOD

Airless spray preferred, but can be brushed, rolled, or sprayed with conventional equipment.

### MIXING

Thoroughly mix Part A before adding Part B, then mix Part A and Part B thoroughly together at a 4:1 ratio taking care to get good color consistency. Induction time is not required. Product should be used immediately.

### CLEAN-UP AND THINNING

Clean all equipment immediately with AP-THINNER 315. If thinning is necessary thin with AP-THINNER 760 or AP-THINNER 770.

### SPRAY EQUIPMENT FOR AIRLESS SPRAY

Pump Ratio \_\_\_\_\_ 33:1  
Air Supply (in) \_\_\_\_\_ 75 – 80 psi  
Hose Diameter (ID) \_\_\_\_\_ 3/8"  
Hose Length \_\_\_\_\_ 100'  
Hose Length ( in elevated temperature ) \_\_\_\_\_ 50'  
Tip Size \_\_\_\_\_ .017 - .025  
Atomization Pressure \_\_\_\_\_ 2,475

### FOR CONVENTIONAL SPRAY

Spray Pot with Dual Regulated Air Gauges for Pot Pressure and Atomization Air

Air Supply (in) \_\_\_\_\_ 100 psi  
Material Hose (ID) \_\_\_\_\_ 1/2"  
Material Hose Length \_\_\_\_\_ 50'  
Air Hose (ID) \_\_\_\_\_ 5/16"  
Air Atomization \_\_\_\_\_ 40 – 60 psi  
Fluid Pressure (psi) \_\_\_\_\_ 10 –25 psi  
Fluid Tip Orifice Size (in) \_\_\_\_\_ 0.070" – 0.080"

### SAFETY INFORMATION

#### FOR PROFESSIONAL USE ONLY! WARNING! FLAMMABLE!

Keep away from sparks or flame. Vapors may cause flash fire. Use with adequate ventilation. Do not breathe vapors or spray mist. Wear an appropriate, properly fitted respirator during and after applications unless air monitoring demonstrates vapor/mist levels are below applicable limits. Avoid contact with eyes, skin, and clothing, Wash thoroughly after handling.

### SHIPPING DATA

Proper Shipping Name \_\_\_\_\_ Paint Liquid  
Hazard Class \_\_\_\_\_ Part A: Flammable Liquid  
\_\_\_\_\_ Part B: Flammable Liquid  
Flash Pt. °C SETA \_\_\_\_\_ 16°C Part A  
\_\_\_\_\_ 27°C Part B  
UN 1263 \_\_\_\_\_ 1263

### PACKAGING

Shipping Wt. (Kg)  
AP-LOCK PART A (Paint) \_\_\_\_\_ AP-LOCK PART B (Hardener)  
Ones = 4.9 \_\_\_\_\_ Quart = 0.76  
Fives = 24.3 \_\_\_\_\_ Ones = 3.6

### MATERIAL SAFETY

Safety Data Sheet of the product is available on request.

### For more information please contact;

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