



AMERON
INTERNATIONAL

Performance Coatings & Finishes

Amerlock® 400BF

Epoxy masonry block filler

Product Data/ Application Instructions

- Block filler for use on prepared interior or exterior masonry block

Application Data

Adhere to all application instructions, precautions, conditions and limitations to obtain maximum performance. For conditions outside the requirements or limitations described, contact your Ameron representative.

Surface Preparation

Surface must be clean and free of all contaminants. Refer to ASTM D4258 for cleaning.

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 Bulldog Hydra-Spray or larger, with a 0.021 to 0.029-inch fluid tip.

Brush or roller – For touchup or texturing coating.

Power mixer – Jiffy Mixer with an explosion-proof motor.

Application Procedures

1. Flush all equipment with thinner or Amercoat 12 before use.
2. Stir resin using an explosion-proof power mixer to disperse pigments.
3. Add cure to resin. Mix thoroughly until uniformly blended to a workable consistency.
4. Do not mix more material than can be used within the expected pot life.
5. For optimum application material should be from 50 to 90°F (10 to 32°C). Above 110°F (43°C) sagging may occur.
6. Thin only for workability; thin no more than 1/2 pint of Amercoat 65 per gallon of Amerlock 400BF. A small amount of thinner greatly reduces viscosity; running or sagging may occur.
7. Apply in even, parallel passes; overlap 50 percent to avoid holidays, bare areas and pinholes. If required, cross spray at right angles.
8. Ventilate confined spaces with clean air between curing application coats and while curing final coat.
9. Repair any damaged areas by brushout or spray.
10. Clean equipment with thinner of Amercoat 12 immediately after use.

Physical Data

Color	Off-white	
Components	2	
Curing mechanism	Solvent release and chemical reaction between components	
Volume solids (calculated)	75% ± 3%	
Dry film thickness per coat	10-20 mils (250-500 microns)	
Coats	1	
Theoretical coverage	ft ² /gal	m ² /L
1 mil (25 microns)	1203	29.5
10 mils (250 microns)	120.3	2.9
VOC	lb/gal	g/L
mixed	1.8	216
mixed/thinned ½ pt	2.1	252
Temperature resistance, Dry	°F	°C
continuous	200	93
intermittent	350	177
Flash point (SETA)	°F	°C
cure and resin	80	27
Amercoat 65	78	25
Amercoat 12	2	-17

Application Data

Applied over	Concrete; concrete cinder, or masonry block		
Surface preparation	Dry, clean, well prepared surface		
Method	Airless spray, brush (touch-up), roller (back-up)		
Mixing ratio (by volume)	1 part resin to 1 part cure		
Pot life (hours)	°F/°C		
	90/32	70/21	50/10
Amerlock 400BF	1 1/2	2 1/2	4
Environmental conditions			
Temperature	°F		°C
air and surface	20 to 122		-7 to 50
material	50 to 90		10 to 32
Surface temperatures must be at least 5°F (3°C) above dew point to prevent condensation. At freezing temperatures, surface must be free of ice.			
Drying time (ASTM D1640) (hours)	°F/°C		
	90/32	70/21	50/10
touch 10 mils	1	3	—
20 mils	1 1/2	4	—
through 10 mils	5	9	—
20 mils	6	11	—
Thinner	Amercoat 65		
Equipment cleaner	Amercoat 12		

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. Ameron 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 Ameron 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.

Shipping Data

Packaging units	2 and 5 gal	
cure	1 gal in 1-gal can	
	2.5 gal in 3 gal can	
resin	1 gal in 1-gal can	
	2.5 gal in 5-gal can	
Shipping weight (approx)	lb	kg
2-gal unit		
cure	14.7	6.7
resin	14.2	6.4
5-gal unit		
cure	37.4	17.0
resin	36.4	16.5

Shelf life when stored indoors at 40 to 100°F (4 to 38°C)

1 year from shipment date

Numerical values are subject to normal manufacturing tolerances, color and testing variances. Allow for application losses and surface irregularities.

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This mixed product is photochemically reactive as defined by the South Coast Air Quality Management District's Rule 102 or equivalent regulations.

Warranty

Ameron warrants its products to be free from defects in material and workmanship. Ameron's sole obligation and Buyer's exclusive remedy in connection with the products shall be limited, at Ameron's option, to either replacement of products not conforming to this Warranty or credit to Buyer's account in the invoiced amount of the nonconforming products. Any claim under this Warranty must be made by Buyer to Ameron in writing within five (5) days of Buyer's discovery of the claimed defect, but in no event later than the expiration of the applicable shelf life, or one year from the delivery date, whichever is earlier. Buyer's failure to notify Ameron of such nonconformance as required herein shall bar Buyer from recovery under this Warranty.

Ameron makes no other warranties concerning the product. No other warranties, whether express, implied, or statutory, such as warranties of merchantability or fitness for a particular purpose, shall apply. In no event shall Ameron be liable for consequential or incidental damages.

Any recommendation or suggestion relating to the use of the products made by Ameron, whether in its technical literature, or in response to specific inquiry, or otherwise, is based on data believed to be reliable; however, the products and information are intended for use by Buyers having requisite skill and know-how in the industry, and therefore it is for Buyer to satisfy itself of the suitability of the products for its own particular use and it shall be deemed that Buyer has done so, at its sole discretion and risk. Variation in environment, changes in procedures of use, or extrapolation of data may cause unsatisfactory results.

Limitation of Liability

Ameron's liability on any claim of any kind, including claims based upon Ameron's negligence or strict liability, for any loss or damage arising out of, connected with, or resulting from the use of the products, shall in no case exceed the purchase price allocable to the products or part thereof which give rise to the claim. **In no event shall Ameron be liable for consequential or incidental damages.**



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