

Amercoat 4310

Silicone modified alkyd

(formerly Steelbond 2310)

Product Data/ Application Instructions

- EPA compliant (1998) as a top coat to PG6/ 23
- Good colour and gloss retention
- Excellent durability
- Approved as a topcoat for Steelguard FM
- Single pack material
- 30% silicone modified alkyd
- Quick and easy to apply either by brush, spray or roller

Typical Uses

Durable finish for general steelwork operating in a wide range of industrial and marine conditions. Amercoat 4310 is also suitable as a topcoat for Steelguard FM intumescent coatings.

Approvals

Amercoat 4310 is approved and registered to Network Rail RT98 specification item 5.13.3.

Surface Preparation

For use in protective coating systems Amercoat 4310 must be applied over suitably primed surfaces. The priming system used will depend on the type and condition of the substrates. Surface preparation must be in accordance with the product data instructions of the primer being used. Consult your Ameron representative for detailed specifications. All surfaces must be dry and free of dust, salts, grease and other contaminants immediately before coating.

Mixing

Stir thoroughly before use until the product is uniform throughout.

Physical Data

Appearance when dry	gloss as standard
Colour	RAL and BS*
Components	1
Volume solids	46 ± 2%
VOC*	
EC SED 1999/13/EC	411 g/kg (441 g/l)
UK PG6/23(92) Appendix 3 ..	420 g/l
Dry film thickness	35-50 µm per coat
Curing mechanism	solvent release and reaction with oxygen from the air

	typical	minimum	maximum
Dry film thickness (µm)	40	35	50
Wet film thickness (µm)	87	76	109
(Wet film thicknesses quoted are theoretical for one brush coat)			
Theoretical coverage	11.5 m ² /l (at typical dft)		
Specific gravity	approx 1.08 kg/l (white)		
Flash point			
(closed cup)	°C	°F	
Amercoat 4310	46	115	
Amercoat 15	38	100	

* VOC figures are quoted according to both the EC directive 1999/13/EC which are theoretically calculated figures and the UK PG6/23(92) Appendix 3 which are practically determined figures.

Amercoat 4310

Application Methods

AIRLESS SPRAY: Use standard airless spray equipment capable of producing a minimum pressure at the tip of 2800 psi (200 kg/cm²). Tip size range 13-17 thou (0.33-0.43mm). Adjustments to pressure and tip size/angle may be necessary to obtain spray characteristics required for specific substrate configurations.

CONVENTIONAL SPRAY: Use standard industrial equipment. Thinning with the recommended thinner may be necessary to facilitate application.

BRUSH/ROLLER: Apply evenly using a clean, well-loaded brush or roller. With this application more than one coat may be necessary to achieve the required dry film thickness.

Overcoating

Can be overcoated with itself to increase the coating thickness. Certain strong colours may require more than one coat for full opacity.

Application Data

Substrate	Primed substrates
Application methods	airless or conventional spray, brush or roller
Potlife (at 20°C/68°F)	N/A

Environmental Conditions

Amercoat 4310 should only be applied within the limits of temperature and humidity set out below.

Relative humidity:	up to 90%
Surface temperature:	minimum: 5°C/41°F
.....	maximum: 40°C/104°F

The surface temperature must also be at least 3°C/5°F above dew point.

Drying Characteristics	°C/°F		
Temperature	10/50	20/68	30/86
Touch dry	8 hours	4 hours	2 hours
Hard dry	16 hours	12 hours	6 hours
Overcoating (minimum)	24 hours	16 hours	8 hours
Overcoating (maximum)	No maximum overcoating time when overcoating with itself		

NOTE: drying and curing times are dependent on air and steel temperature, applied film thickness, ventilation and other environmental conditions. Times are shorter at higher temperatures and longer at lower temperatures

Thinner	Amercoat 15
Cleaner	Amercoat 15

Amercoat 4310

Application procedure

1. Flush equipment with recommended cleaner before use.
2. Stir the contents of the can to an even consistency.
3. Thinning is normally not required for airless spray.
4. Stir during application to maintain uniformity of material. Apply a wet even coat in parallel passes. Overlap each pass 50% to avoid bare areas, pinholes or holidays.
5. Double coat all rough spots, sharp edges and corners, rivets, bolts, etc.
6. Application at 85 µm wet film thickness will normally provide 40 µm dry film.
7. Check thickness of dry coating with a non-destructive dry film thickness gauge, such as Mikrotest or Elcometer. If less than specified thickness, apply additional material as needed.
8. Small damaged or bare areas and random pinholes or holidays can be touched up by brush. Repair larger areas by spray.
9. In confined areas ventilate with clean air during application and drying until all solvents are removed. Temperature and humidity of ventilating air must be such that moisture condensation will not form on surface.
10. Clean all equipment with recommended cleaner immediately after use or at least at the end of each working day or shift

Before using the product, read the label on the can and consult the material safety data sheet.

Shipping Data

Pack size	5 litres
Shipping weight.....	approx. 6 kg
Shelf life	1 year from shipment date or as indicated on label when stored indoors in unopened, original containers at 5 to 40°C (41 to 104°F).

Amercoat 4310

Safety

Since improper use and handling can be hazardous to health and cause of fire or explosion, safety precautions included with Product Data/Application Instruction and Material Safety Data Sheet must be observed during all storage, handling, use and drying periods.

Warranty

Ameron warrants its products to be free from defects in material and workmanship. Ameron's sole obligations and Buyer's exclusive remedy in connection with the products shall be limited, at Ameron's option, to either replacement of products not conforming this warranty or credit to Buyer's account in the invoiced amount of the non-conforming 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 non-conformance as required herein shall bar Buyer from recovery under this warranty.

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In no event shall Ameron be liable for consequential or incidental damages.

Due to Ameron's policy of continuous product improvement, the information contained in this Product Data/Application Instructions sheet is subject to change without notice. It is the Buyer's responsibility to check that this issue is current prior to using the product. For the most up-to-date Product Data/Application Instructions always refer to the Ameron Performance Coatings & Finishes website at www.ameroncoatings.com

To avoid any confusion that may arise through translation into other languages, the English version of the Product Data/Application Instructions will be the governing literature and must be referred to in case of deviations with product literature in other languages.

Condition of Sale

All our transactions are subject to our Terms and Conditions of Sale.

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