

## Product Data / Application Instructions

- Direct adhesion to galvanised steel
- Chemical resistant
- Compatible with most aged coatings
- Extensive track record
- Single pack material
- Free from overcoating stress

### Typical Uses

Durable finish for:

- Street furniture and lighting columns
- Tank roofs and shell externals
- General plant and steelwork

### Surface Preparation

STEEL - Applied over Steelbond 2136 or other suitable Ameron Coatings build coat or primer.

GALVANISED STEEL - Degrease the surface with Amercoat 88 or similar degreasing material.

Test the surface with T-wash 1410: immediate blackening of the surface indicates that application can take place.

Blackening will not occur if the surface has been contaminated or affected by corrosion products.

In this situation, abrade and degrease the surface before application. The surface 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.

### Application Methods

BRUSH - Apply evenly using a clean, well loaded brush. Do not attempt to "brush out" or "lay off" the wet coating.

AIRLESS SPRAY - May be thinned as necessary with up to 10% by volume of the recommended thinner.

Tip size 15-18 thou' (0.38-0.46mm). Pressure at tip: 2800 psi (200kg/square centimetre).

### Environmental Conditions

Relative humidity: up to 90%

Surface temperature: minimum 5°C  
maximum 30°C

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

### Physical Data

Appearance when dry.....	semi gloss
Colour .....	RAL and BS
Substrate.....	galvanised or primed steel
Components.....	1
Curing mechanism .....	solvent release
Volume solids .....	42±2%
VOC .....	520 g/l
	<b>typical    minimum    maximum</b>
Dry film thickness (µm)	75    50    100
Wet film thickness (µm)	179    119    238
(wet film thicknesses quoted are theoretical for one brush coat)	
Theoretical coverage .....	5.6 m <sup>2</sup> /l (at typical dft)
Specific Gravity .....	approx. 1.3 kg/l (depending on colour)
Application methods.....	brush, airless spray
Potlife (at 20°C) .....	not applicable
Thinner .....	Amercoat 65
Cleaner .....	Amercoat 65
Flash points (closed cup)	
Steelbond 2143.....	40°C
Amercoat 65 .....	24°C
Pack size.....	5 litres
Shipping weight .....	approx. 7 kg
Shelf life (months) .....	2 years when stored indoors in unopened, original containers at 5-35°C

\*Reference is made to the basic colour collections of RAL and BS-4800.

## Drying Characteristics

Temperature	10°C	20°C	30°C
Touch dry	2 hours	1 hour	30 minutes
Hard dry	8 hours	4 hours	2 hours
Full cure	10 days	7 days	4 days
Overcoating (minimum)	24 hours	16 hours	8 hours
Overcoating (maximum)	-	-	-

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

## Overcoating

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

## Application procedure

1. Flush equipment with recommended cleaner before use.
2. Stir the contents of the can to an even consistency with a power mixer.
3. Thin if necessary with up to 10% by volume of the recommended thinner.
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 welds, rough spots, sharp edges and corners, rivets, bolts, etc.
6. Application at 179 µm wet film thickness will normally provide 75 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.

### Safety

Since improper use and handling can be hazardous to health and cause fire or explosion, safety precautions included with application instructions must be observed during all storage, handling, use and drying periods. 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.

### 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 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 response to specific enquiry, or otherwise, is based on data believed to be reliable; however, the products and information are intended for use by Buyer's having requisite skill and know-how in the industry, and therefore it is 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, as 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.

### Conditions of Sale

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

8. Small damaged or bare areas and random pinholes or holidays can be touched up by brush. Repair larger areas either by spray or brush.
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.**