



# Amercoat 124AS

## Zinc-Rich Epoxy Preconstruction Primer

### Product Data/ Application Instructions

- Used as a weldable preconstruction primer or field or shop applied primer
- Permits almost immediate handling, welding, cutting and fabricating
- Can be used with epoxy topcoats
- Easily applied by airless or conventional spray
- Tough and adherent primer providing excellent resistance to corrosion

#### Outstanding Characteristics

Amercoat 124AS is a fast drying zinc rich epoxy primer, providing excellent protection against corrosion. Amercoat 124AS is a tough and adherent primer, used on abrasive blast cleaned steel. Amercoat 124AS primer can be applied by airless or conventional spray with automatic or manual spray equipment. For small areas Amercoat 124AS can be applied by brush.

#### Typical Uses

As a weldable primer: protects against weathering and abrasion on flat steel plates and structural steel shapes. A single coat applied at 15 to 25 µm protects against weathering, water and abrasion during transportation, handling and fabricating. Readily cut and welded automatic and manual methods. Note: like all primers, Amercoat 124AS alone is not suitable for immersion in or spillage of acid or alkaline solutions.

INDUSTRIAL - Structural steel, machinery, pipes and tank exteriors in paper mills, oil refineries, power plants, chemical process and waste treatment plants and paper mills.

MARINE - Decks and superstructures of ships, barges and workboats. Piers, offshore platforms and related structures.

#### Approvals and Certificates

Amercoat 124AS conforms to British Standard 4652 type III. Approved as weldable primer for application on blast cleaned steel plates and sections by *Det Norske Veritas*. Approved as prefabrication primer by Lloyds Register for use in ships.

Meets the requirements of DVS-0501 as tested by the German *Schweißtechnische Lehr- und Versuchsanstalt* in Duisburg. Approved by ACQPA, France.

#### Physical Data

Finish .....	flat
Colour .....	grey
Components .....	2
Mixing ratio (by volume)	
resin .....	2 parts
cure .....	1 part
Curing mechanism .....	solvent release and chemical reaction between components
Volume solids .....	51% (ASTM D2697 modified)*
VOC .....	19% by weight/487 g/l
Dry film thickness .....	15 - 25 µm
Number of coats .....	1
Calculated coverage .....	34 m <sup>2</sup> /l at 15 µm 20 m <sup>2</sup> /l at 25 µm
Allow for application losses, surface irregularities, etc.	
Specific gravity .....	2.58 kg/l (mixed product)
Flash points (Closed Cup).....	°C    °F
resin .....	25    77
cure .....	16    61
Amercoat 18 .....	27    81

#### Typical Properties

Viscosity .....

14 sec. DIN cup 4
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\* Volume solids is measured in accordance with ASTM D2697 modified. Slight variations ± 3% may occur due to colour and testing variances.

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## Surface Preparation

STEEL - Blast in accordance with Swedish Standard Sa 2½ SIS 05 5900 - 1967, ISO 8501-1 or Steel Structures Painting Council SP-10. NOTE: blast to achieve a 25 to 50 µm profile as determined with *Testex* Tape or similar instrument. Remove abrasive residues and dust from surface.

IMPORTANT - Apply Amercoat 124AS as soon as possible after surface preparation to prevent any contamination. Do not leave blasted steel uncoated overnight. In case of contamination, remove contaminants. Spot blast steel if needed.

## Application Equipment

The following equipment is listed as a guide and suitable equipment from other manufacturers may be used. Adjustments of pressure and change of tip size may be needed to obtain the proper spray characteristics.

AIRLESS SPRAY - Standard airless spray equipment, such as Graco, DeVilbiss, Nordson-Bede, Spee-Flo or others having a 28:1 or higher pump ratio and a fluid tip with a 0.38 to 0.53 mm (0.015 to 0.021 inch) orifice.

CONVENTIONAL SPRAY - Industrial equipment such as DeVilbiss MBC or JGA gun with 78 or 765 air cap and "E" fluid tip and heavy mastic spring or Binks No. 18 or 62 with a 66 x 63 PB nozzle setup. Separate air and fluid pressure regulators, mechanical pot agitator and a moisture and oil trap in the main air supply line are recommended.

MIXER - Use power mixer powered by an air motor or an explosion proof electric motor.

## Application Data Summary

Like all high performance coatings, this product must be applied as recommended to obtain the maximum performance. To obtain the maximum performance for which Amercoat 124AS is formulated, strict adherence to all application instructions, precautions, conditions and limitations is necessary. If conditions exist that are not within the requirements or limitations described, consult your Ameron representative.

## Repair

Amercoat 124AS may be used to repair itself. Spot blast or power tool clean bare substrate to the requirements shown under surface preparation. Feather edges of intact coating. Remove dust, dirt and contamination before recoating.

## Topcoating

Suitable topcoats are epoxies. For specific recommendations, contact your Ameron representative.

## Application Data

Substrate ..... abrasive blasted steel  
Application methods ..... airless or conventional, manual or automatic spray

### Environmental Conditions

(during application)  
Air temperature: ..... 5 to 50°C      41 to 122°F  
Surface temperature: ..... 5 to 60°C      41 to 140°F

To prevent moisture condensation during application, surface temperature must be at least 3°C/5°F above dew point. Never apply coatings under reverse environmental conditions. Ensure good ventilation when applied in confined areas to assist evaporation and elimination of solvents.

Drying Times (at 15 µm, °C/°F)	20/68	30/86	40/104
dry to touch (seconds) .....	60	30	15
dry to handle (minutes) .....	2	1	½
dry hard (minutes).....	30	15	3

NOTE: drying times are dependent on air and steel temperature, applied film thickness, ventilation and other environmental conditions. Times are proportionally shorter at higher temperature and longer at lower temperatures. Prior to recoating ensure the surface is clean. Maximum recoating time depends on coating system to be used. Consult your Ameron representative for specific recommendations.

Recoating Times (in hours, °C/°F)	10/50	20/68	30/86
minimum .....	4	1	½
maximum .....	unlimited		

Potlife (at 21°C/70°F) ..... 12 hours  
Potlife is dependent on temperature and quantities mixed.

Thinner/cleaner ..... Amercoat 18

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## Application Procedure

Amercoat 124AS is packaged in the proper mixing proportions of resin and cure.

Resin 8 l in 20 l can

Cure 4 l in 5 l can

1. Flush equipment with recommended cleaner.
2. Stir pigmented resin (in the larger container) to an even consistency with a power mixer.
3. Add cure to resin and continue stirring for 5 minutes. Strain material through a 250 µm (60 mesh) screen to prevent possible clogging of equipment. Induction time before use is 10 minutes. NOTE: since the potlife is limited and shortened by high temperatures, do not mix more material than will be used in 12 hours at 21°C.
4. For conventional spray, thin only as needed for workability with up to 20% to achieve 25 µm, and between 20 to 40% to achieve 15 µm dry film thickness. Required amount of thinner will vary with temperature of the mixed material. Depending on drying properties thinning is normally not needed for manual airless spray, to achieve 20 to 25 µm. To achieve a low film thickness with fast drying properties recommended thinner.
5. Stir during application to maintain uniformity of material. Apply a wet coat even, parallel passes. Overlap each pass 50% to avoid bare areas, pinholes or holidays.
6. Double coat all welds, rough spots, sharp edges and corners, rivets, bolts, etc.
7. Application at 40 µm wet film thickness will normally provide 20 µm dry film.
8. 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.
9. Small damaged or bare areas and random pinholes or holidays can be touched up by brush. Repair larger areas by spray.
10. 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.
11. Clean all equipment with recommended cleaner immediately after use or at least at the end of each working day. When left in spray equipment Amercoat 124AS will cure and cause clogging.

## Shipping Data

### Packaging

resin ..... 8 l in 20 l can

cure ..... 4 l in 5 l can

### Shipping weight

resin ..... approx. 28 kg

cure ..... approx. 4.5 kg

Shelf life ..... 1 year from shipment date when stored indoors in unopened, original containers at 5 to 40°C (41 to 104°F).

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## Caution

Amercoat 124AS is highly flammable. Keep away from heat and open flame. Keep container closed. Use with adequate ventilation. Avoid prolonged and repeated contact with skin. If used in confined areas, observe the following precautions to prevent hazards of fire or explosion or damage to health:

1. circulate adequate fresh air continuously during application and drying;
2. use fresh air masks and explosion proof equipment;
3. prohibit all flames, sparks, welding and smoking.

Do not empty into drains. Take precautionary measures against static discharges. For specific information on hazardous ingredients, required ventilation, possible consequences of contact, exposure and safety measures see Safety Data Sheet.

## 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.amerondirect.co.uk](http://www.amerondirect.co.uk)

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.