



Amercoat 132E

Zinc Epoxy Primer

Product Data/ Application Instructions

- An experience-proven metallic zinc epoxy primer
- Complies with SSPC Paint 29
- EPA compliant in the United Kingdom as a single coat protective finish
- Provides cathodic protection
- Forms durable coating systems with a wide range of topcoats
- No maximum overcoating time restrictions
- Easily applied by airless or conventional spray

Typical Uses

In combination with suitable topcoat systems Amercoat 132E can be used for the following applications.

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

MARINE - Decks, topsides and superstructures of ships, barges and workboats. Piers, offshore platforms and related structures. Interiors of dry cargo holds.

Outstanding Characteristics

Amercoat 132E is a polyamide cured zinc epoxy primer. The zinc content provides a cathodic protection if the film is damaged. Applied as part of a coating system Amercoat 132E provides excellent performance in a wide range of aggressive environments. With the suitable topcoats, withstands splash or spillage of water, solvents, chemicals and petroleum products.

Qualifications

Complies with the compositional requirements for SSPC Paint 29

Typical systems:

First coat	Intermediate coating options	Finish coat options
Amercoat 132E	Amercoat 370 Amercoat 385	Amercoat 450 series Amercoat 229
Amercoat 132E	Amerlock series Amercoat 383H	Amercoat 450 series

Physical Data

Finish	matt	
Colour	grey	
Components	2	
Mixing ratio (by volume)		
resin	5 parts	
cure	1 part	
Curing mechanism	solvent release and reaction between components	
Volume solids	60% (ISO 3233)*	
VOC	18.4% by weight/350 g/l	
Dry film thickness	50-75 µm per coat (2-3 mils)	
Number of coats	1	
Calculated coverage	12 m ² /l (at 50 µm) 489 ft ² /gal (at 2 mils)	
Allow for application losses, surface irregularities, etc.		
Specific gravity	1.9 kg/l (mixed product)	
Flash points (Closed Cup).....	°C	°F
resin	25	77
cure	25	77
Amercoat 18	25	77
Thinner/cleaner	Amercoat 18	

* Volume solids is measured in accordance with ISO 3233. Slight variations ± 3% may occur due to colour and testing variances.

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Repair

Amercoat 132E may be used to repair itself.

Surface Preparation

New steel without pits or depressions should be abrasive blast cleaned in accordance with Sa 2½ SIS 05 5900-1967 or ISO 8501-1. Previously painted or pitted steel, blast in accordance with Sa 2½. Note: Blast to achieve a 35 to 65 µm profile as determined with Testex Press-O-Film tape or similar instrument. Remove abrasive residues and dust from surface. **IMPORTANT** - Apply Amercoat 132E 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 0.43 to 0.58 mm (0.017 to 0.023 inch) orifice.

CONVENTIONAL SPRAY - Industrial equipment such as DeVilbiss MBC or JGA gun with 765 air cap or Binks No. 18 or 62 spray gun. 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.

Overcoating

For final use the Amercoat 132E is normally overcoated with Ameron epoxy coatings or other suitable topcoats.

Before overcoating, ensure surface is clean and free from zinc salts and other contamination.

Application Data

Substrate	abrasive blasted steel
Surface preparation.....	abrasive blast to ISO 8501-1 to SA 2½
Application method.....	airless or conventional spray, brush or roller**
Mixing ratio (by volume)	
resin	5 parts
cure	1 part
Environmental conditions	
surface temperature:.....	5-50°C (41-122°F)

Surface temperature must be at least 3°C (5°F) above dew point to prevent moisture condensation on the surface. For optimum performance curing temperature should not be less than 10°C.

Potlife (at 20°C/68°F) 8 hours

Potlife is dependent on temperature.

Drying times (°C/°F)	10	20	30	40
Touch dry (minutes).....	60	40	30	20
dry through (hours)	4	2	1½	1
Topcoat times (°C/°F).....	10	20	30	40
Minimum (hours).....	4	2	1½	1
Maximum	-	-	-	-

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

Thinner/cleaner Amercoat 18

** Brush and roller application are only suitable for small areas.

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Application Procedure

Amercoat 132E is packaged in the proper mixing proportions of resin and cure.

Resin: 8.33 l (2,2 gal) in 10 l can
Cure: 1.67 l (0,44 gal) in 2½ l can

1. Flush equipment with Amercoat 18 before use.
2. Stir resin (in the larger container) to an even consistency with a power mixer.
3. Add cure to resin and continue stirring for 5 minutes. Note: Since the potlife is limited and shortened by high temperatures, do not mix more material than will be used in 8 hours at 20°C (68°F).
4. Thinning is normally not required for airless spray. For conventional spray, thin only as needed for workability, with up to 10 vol.% of Amercoat 18.
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 85 µm (3,4 mils) wet film thickness will normally provide 50 µm (2 mils) dry film, or 125 µm (5 mils) wet film for 75 µm (3 mils) 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 Amercoat 9HF immediately after use or at least at the end of each working day or shift. When left in spray equipment, Amercoat 132E will cure and cause clogging.

Before using the product, read the label on the can and consult the Material Safety Datasheet.

Shipping Data

Packaging
resin 8.33 l (2,2 gal) in 10 l can
cure 1.67 l (0,44 gal) in 2½ l can

Shipping weight
resin approx. 20 kg
cure approx. 2.2 kg

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

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Caution

This product is 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 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 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 this warranty or credit to Buyer's account in the invoiced amount of the non-confirming 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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All our transactions are subject to our Terms and Conditions of Sale.