



# Amercoat 139

## Epoxy Preconstruction Primer

### Product Data/ Application Instructions

- Use as a weldable preconstruction primer or field or shop applied primer
- Permits almost immediate handling, welding, cutting and fabricating
- Can be used with a wide range of topcoats
- Easily applied by automatic spray equipment
- Simple 1:1 mixing ratio
- Chromate and lead free
- EPA compliant in the UK as a blast primer

#### Typical Properties

Amercoat 139 is a fast drying, two pack epoxy preconstruction primer, providing protection against corrosion during construction.

- Anti-corrosive, fast drying, weldable preconstruction primer.
- Two pack epoxy based, pigmented with zinc phosphate and iron oxides.
- Tough and adherent on abrasive blast cleaned steel.
- Provides at a dry film thickness of 20-25 µm up to 6 months protection in mild industrial environments.
- Suitable for application by airless or conventional spray, using automatic or manual spray equipment.

Permits automatic or manual welding and cutting of steel plates and profiles.

#### Typical Uses

As a weldable preconstruction primer in shoppriming plants over abrasive blast cleaned steel for flat steel plates and structural steel shapes. A single coat applied at 15 to 25 µm protects against weathering during handling and fabricating. Can be readily cut and welded by automatic and manual methods. After fabrication, overcoat with suitable topcoat systems.

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

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

#### Approvals and Certificates

Tested and approved as prefabrication primer by Lloyds Register for use in ships

Testing at the Newcastle occupational Health Agency has shown that no toxic gases are formed in concentrations above the threshold limit values during cutting and welding.

Approved by the Russian Maritime Register of Shipping. Welding test reports are available on request.

#### Physical Data

Finish .....	matt	
Colour .....	oxide red and grey	
Components .....	2	
Mixing ratio (by volume)		
resin .....	1 part	
cure .....	1 part	
Curing mechanism .....	solvent release and reaction between components	
Dry film thickness .....	15 - 25 µm	
Number of coats .....	1	
Volume solids .....	25% (ASTM D2697, modified)*	
VOC .....	58% by weight / 646 g/l	
Calculated coverage .....	12.5 m <sup>2</sup> /l at 20 µm	
Allow for application losses, surface irregularities, etc.		
Specific gravity .....	1.13 kg/l (mixed product)	
Flash points (Closed Cup) .....	°C	°F
Amercoat 139 .....	4	39
Amercoat 18 .....	25	77
Amercoat 12 .....	24	75

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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## Recommended Systems

TOPCOATING - Suitable topcoats are Ameron epoxies, alkyds, coaltar epoxies, and polyurethanes. Prior to topcoating, the primed surface must be clean and free of contamination, dust and foreign matter; special attention must be given to damaged areas. Damaged areas can be repaired with Amercoat 139 after cleaning by spot blasting or mechanical cleaning methods such as wire brushing, depending on the service conditions. Refer also to the specific requirements and recommendations shown in the product data of the intermediate and topcoats to be applied. For specific recommendations contact your Ameron representative.

## 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 139 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 Bulldog Hydra or larger, DeVilbiss, Nordson-Bede, Spee-Flo or others having a 28:1 or higher pump ratio and a fluid nozzle with a 0.38 to 0.62 mm (0.015 to 0.025 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 set-up. Separate air and fluid pressure regulators and a mechanical pot agitator and a moisture and oil trap in the main air supply line is essential.

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 protection for which this coating is formulated.

To obtain the maximum performance for which Amercoat 139 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.

## Application Data

Substrate ..... abrasive blasted steel

Application methods ..... airless or conventional spray

### Environmental Conditions

(during application and drying)

Air temperature: ..... 5 to 50°C      41 to 122°F

Surface temperature: ..... 5 to 60°C      41 to 140°F

Effective cure down to 10°C/50°F

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

Drying Times (in minutes at 25 µm dft, °C/°F)

	20/68	30/86	40/104
dry to touch .....	2	1	30 seconds
dry to handle .....	10	6	2
before full service.....	60	30	15

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

Recoat Times (in hours, °C/°F) 10/50 20/68 30/86

minimum ..... 2      1      ½

Potlife (approx.) ..... 24      16      10  
(in hours)

Potlife is dependent on temperature and quantities mixed.

Induction time ..... 10 minutes

Thinner ..... Amercoat 18

Cleaner ..... Amercoat 12

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## Application Procedure

Amercoat 139 is packaged in the proper mixing proportions of resin and cure.

resin            10 l in 10 l can  
cure             10 l in 10 l can

1. Flush equipment with recommended cleaner.
2. Stir each of the components prior to mixing to an even consistency with a power mixer.
3. Mix cure with resin, and continue stirring for 5 minutes. **NOTE:** Since the potlife is shortened by high temperatures, do not mix more material than will be used within the potlife period.
4. For conventional spray, thin only as needed for workability with no more than 10% of the recommended thinner.
5. Stir during application to maintain uniformity of material. Apply a wet coat by even, parallel passes. Overlap each pass 50% to avoid bare areas, pinholes or holidays.
6. Give special attention to welds, rough spots, sharp edges and corners, rivets, bolts, etc.
7. Application at 80 µm wet film thickness will usually provide a 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.  
When spraying automatically, use glass plates and a surface micrometer to check dry film thickness and to adjust the equipment to the required dft.
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 sol vents 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 or shift. When left in spray equipment, product will cure and cause clogging.

## Shipping Data

### Packaging

resin ..... 10 l in 20 l can  
cure ..... 10 l in 10 l can

### Shipping weight

resin ..... approx. 15 kg  
cure ..... approx. 10 kg

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

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## Caution

This product 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.