



Amercoat 148

Waterborne Acrylic Primer

Product Data/ Application Instructions

- Waterborne one component acrylic primer
- Good physical and mechanical properties
- Excellent build characteristics
- Fast drying, minimum downtime
- Suitable for temperatures down to 5°C/41°F
- Low odour, low VOC emission
- Brush, roller or spray application
- Accepts a wide range of topcoats
- Compatible with most existing coatings

Typical Uses

As a primer for abrasive blasted or mechanically cleaned steel, Amercoat 148 provides corrosion protection to structural steel, tanks, pipes and equipment, marine vessels topsides and interiors and offshore platform interiors. It can be used to replace traditional inhibited alkyd or chlorinated rubber primers in non-immersion service.

Recommended Systems

Amercoat 148 is a waterborne acrylic primer with inhibitive features. Ideal for priming steel and other substrates, it also provides a bond between most existing painted or primed surfaces and suitable Ameron high performance topcoats such as Amercoat 220 waterborne acrylic, Amercoat waterborne epoxies, Amershield high build polyurethane and Amercoat alkyds.

Repair

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.
or holidays. If required, cross spray at right angles to first pass.

Physical Data

Finish	low sheen
Colour	red oxide, white
Components	1
Curing mechanism	physical drying
Dry film thickness	50 to 75 µm per coat
Number of coats	1
VOC	5.7% by weight / 77 g/l
Volume solids	46% (ASTM D2697 modified)*
Calculated coverage	9.2 m ² /l at 50 µm
Allow for application losses, surface irregularities, etc.	
Specific gravity	1.35 kg/l (mixed product)
Flash point (closed Cup)	>100°C/212°F

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

Amercoat 148

Surface Preparation

All surfaces must be dry and free of dust, salts, grease and other contaminants before coating. Coating performance is proportional to the degree of surface preparation. Abrasive blasting is the most effective and economical method to remove rust and mill scale.

STEEL - Blast in accordance with ISO 8501-1 to Sa 2½ or Steel Structures Painting Council SP-10. Where blasting is not possible Amercoat 148 can be applied on phosphatized steel or clean cold rolled steel.

NOTE: blast to achieve a 25 to 65 µm anchor profile as determined with *Testex* Tape or similar instrument. Remove abrasive residues and dust from surface.

NEWLY GALVANISED SURFACES – Thoroughly clean with Amercoat 57 and rinse with clean, fresh water. For optimum adhesion lightly blast with fine abrasive.

WEATHERED GALVANISED SURFACES – Thoroughly clean with Amercoat 57 and rinse with clean fresh water. Ensure surface is free of zinc salts before coating by scrubbing/scouring the effected areas and rinsing with clean, fresh water. Allow to dry completely before coating.

DIMETCOTE - Surface must be clean and dry. Remove any contamination. Refer to application instructions for the particular Dimetecote types for any other special topcoating requirements. Remove oil or grease with a neutral detergent or emulsion cleaner (like Amercoat 57 oil cleaner).

IMPORTANT - Apply Amercoat 148 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, or others having a 28:1 or higher pump ratio and a fluid tip with a 0.38 to 0.48 mm (0.015 to 0.019 inch) orifice.

CONVENTIONAL SPRAY - Industrial equipment such as DeVilbiss MBC or JGA gun with 75 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 and a mechanical pot agitator are recommended. A moisture and oil trap in the main air supply line is essential.

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

BRUSH - Natural bristle. Maintain a wet edge.

ROLLER - Industrial roller. Level any air bubbles with bristle brush. Do not brush or roller out wet coating too far, otherwise the correct thickness will not be obtained.

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 this product 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

Surface steel, galvanizing and Dimetecote
Application conventional or airless spray, brush or roller

Environmental Conditions

(during application and drying)

Air temperature	5 to 40°C	41 to 104°F
Surface temperature	5 to 40°C	41 to 104°F
Material temperature.....	10 to 30°C	50 to 86°F
Relative humidity	5 to 10°C	41 to 50°F
.....		max. 60%
.....	10 to 35°C	50 to 95°F
.....		max. 85%
.....	> 35°C/95°F	max. 95%

To prevent moisture condensation during application, surfacetemperature 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 and Curing Times (ASTM D1640)

(at 50 µm and RH as under Environmental Conditions)

	°C/°F . 10/50 20/68 30/86		
dry to touch	3 hours	2 hours	1 hour
dry to handle	6 hours	4 hours	2 hours
dry to topcoat (hours)			
waterborne.....	6	4	2
PU/alkyd	48	24	16

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

Potlife (at 20°C/68°F) not applicable

Thinner

Fresh water

Cleaner

water, water with detergent

Amercoat 148

Application Procedure

Amercoat 148 is packaged as 20 l or 5 l

1. Flush equipment with fresh water before use.
2. Stir material thoroughly to a workable consistency to ensure suspension of pigments.
3. For conventional spray, thin only as needed for workability with no more than 10% fresh water. Thinning is normally not needed for airless spray.
4. 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
5. Double coat all welds, rough spots, sharp edges and corners, rivets, bolts, etc.
6. Application at 120 µm wet film thickness will normally provide 50 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 clean water or water with detergent immediately after use or at least at the end of each working day or shift. When left in spray equipment, Amercoat 148 may cure and cause clogging.

Shipping Data

Packaging	20 l can or 5 l can
Shipping weight	24.8 kg or 6.8 kg
Shelf life	1 year from manufacturing date or as indicated on the label when stored indoors in unopened, original containers at 10 to 40°C (50 to 104°F) *.

* Product contains water; protect from freezing.

Amercoat 148

Caution

This product contains organic solvents and presents dangers normally related to the use of solvents. 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 the 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.

Ameron makes no other warranties concerning the product. No other warranties, whether express, implied or statutory, such as warranties of merchantability or fitness particular purpose, shall apply. In no event shall Ameron be liable for consequential or incidental damages.

Any recommendations 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.

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

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.