



Amercoat 149

Water Based Epoxy Primer

Product Data/ Application Instructions

- **Water based epoxy primer for steel substrates**
- **Excellent rust inhibitive primer**
- **Adheres to a great variety of different coatings**
- **Can be topcoated with water based and solvent based coatings**

Typical Uses

As a primer for abrasive blasted steel Amercoat 149 provides excellent corrosion protection in chemical plants, oil refineries, nuclear industry and food and pharmaceutical industry.

Outstanding Characteristics

When applied to abrasive blasted steel, Amercoat 149 provides excellent corrosion protection. Amercoat 149 does not contain any organic solvents and adheres to a great variety of different coatings, making it an ideal product for maintenance of coating systems. It can be topcoated with water based and solvent based coatings. Amercoat 149 can be used in nuclear, food and pharmaceutical industry and in other areas where the use of solvents is restricted.

Physical Data

Finish	semi-gloss
Colour	ivory
Components	2
Mixing ratio (by volume)	
resin	1.85 parts
cure	3.15 parts
Curing mechanism	evaporation of water and chemical reaction between components
Dry film thickness	50 µm per coat
Number of coats	1 or 2
VOC	0
Volume solids	49% (ISO 3233)*
Calculated coverage	9.9 m ² /l at 50 µm

Allow for application losses, surface irregularities, etc.

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

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Surface Preparation

STEEL - Blast in accordance with Sa 2½ Swedish Standard SIS 05 5900 1967, ISO 8501-1. Blast to achieve a 25 to 50µm profile as determined with *Testex* Tape or a similar device. Remove abrasive residue or dust from surface.

EXISTING COATINGS - Sound existing coatings should be dry, and free of contaminants like oil, grease and loose coating.

Application Equipment

Use of the following equipment is suggested, but suitable equipment from other manufacturers may be used.

Adjustments of pressures and change of tip size may be needed to obtain the proper spray characteristics.

AIRLESS - Standard airless spray equipment such as Graco, De Vilbiss, Wagner or other with a 0.40 to 0.53 mm (0.016-0.021 inch)

CONVENTIONAL - Industrial Equipment such as De Vilbiss MBC or JGA gun with 78 or 765 air cap and 'E' fluid tip, or Binks no. 18 or 62 gun 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.

Cleaning Equipment

1. In areas where the use of solvents is prohibited, the equipment can be cleaned by extensive flushing with warm fresh water. It is recommended to do the final cleaning outside this area with solvents like Amercoat 12 Cleaner.
2. In non restricted areas equipment can be cleaned with Amercoat 12 Cleaner.

Application Data

Surface Sa 2½ blast cleaned steel; sound existing coating systems

Application conventional or airless spray, brush

Environmental Conditions

Air temperature	10 to 50°C	50 to 122°F
Surface temperature	10 to 50°C	50 to 122°F
Storage	10 to 35°C	50 to 95°F

Amercoat 149 contains water; protect from freezing. The surface temperature must be at least 3°C/5°F above the dew point at all times to prevent moisture condensation, until the coating has dried.

Drying Times

(at 50 µm dft, 21°C/70°F and 50-80% RH)
dry to touch 4 - 6 hours
dry to recoat or topcoat 8 hours

Potlife (at 21°C/70°F) 1½ hours

Potlife and drying curing times are dependent on temperature, ventilation, relative humidity and coating thickness. High temperatures will shorten drying times, high relative humidity will lengthen drying times.

Thinner Fresh water

Cleaner Warm fresh water or Amercoat 12.
See under Cleaning Equipment.

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Application Procedure

Amercoat 149 is packaged in two components in the proper proportions which must be mixed together before use. 5 l unit:

Resin: 1.85 l in 5 l can.

Cure: 3.15 l in 5 l can.

1. Flush equipment with fresh water before use.
2. Stir resin solution thoroughly to homogeneous liquid.
3. Add cure to the resin and mix until uniform.
4. The end of the potlife will not be shown by viscosity increase. Material must be used prior to the expiration of the potlife. Potlife of Ameron 149 is
1½ hours at 21°C/70°F
2 hours at 15°C/59°F
2½ hours at 10°C/50°F
5. Mixing shall be done with a power mixer to obtain the required degree of emulsion. Insufficient mixing (too low speed of mixer, manual mixing, etc.) will cause poor emulsification and consequently be detrimental to the performance of the coating.
6. When applying by conventional spray, use adequate air pressure and volume to ensure proper atomization. To optimise spraying, Amercoat 149 can be thinned with 3 - 6% fresh water. For airless spray application, normally no thinning is required.
7. Only fresh, clean water should be used for thinning.
8. Apply a wet coat in even parallel passes, overlapping each pass 50%.
9. Normal recommended dry film thickness is 50 µm. However, if a greater thickness is applied in local areas because of overlapping, no runs or sags will normally occur at a dry film thickness up to approx. 75 µm.
10. Application of a wet film thickness of 103 µm normally provides 50 µm of dry film.

Shipping Data

Packaging

resin 1.85 l in 5 l can
cure 3.15 l in 5 l can

Shipping weight

resin 4.6 kg
cure 3.7 kg

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

* Product contains water; protect from freezing.

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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.

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Limitation of Liability

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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

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.