



# Amercoat 160HF

## Modified Inorganic Zinc-Rich Primer

### Product Data/ Application Instructions

- **Single package, modified inorganic zinc primer, with excellent corrosion protection**
- **Adheres to a variety of surfaces**
- **Outstanding for repairing inorganic zinc/organic topcoat systems**
- **Excellent performance on tank exteriors, marine hulls, decks and super structures**
- **Easily applied by airless or conventional spray**

#### Typical Uses

Amercoat 160HF may be topcoated with epoxies, vinyls, chlorinated rubbers or modified acrylics.  
**INDUSTRIAL** - Structural steel, machinery pipes and tank exteriors in paper mills, oil refineries, power plants, chemical process and waste treatment plants.  
**MARINE** - In non immersion service; decks, hulls and super structures of ships, barges and workboats; piers, offshore platforms and related structures.

#### Outstanding Characteristics

Amercoat 160HF is a single package, modified inorganic zinc primer with excellent corrosion protection. It adheres to a wide variety of steel surfaces and is outstanding for repair of inorganic zinc / organic topcoat systems. With the proper topcoats, it withstands splash or spillage of water, solvents, chemicals and petroleum products.

Amercoat 160HF is also suitable for touch up of galvanised steel.

Contact your Ameron representative for your specific requirements.

#### Repair

Amercoat 160HF may be used to repair itself or inorganic zinc coatings. 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.

#### Physical Data

Finish .....	flat
Colour .....	zinc grey
Components .....	1
uring mechanism .....	solvent release
Volume solids .....	37% (ASTM D2697, modified)*
VOC .....	34% by weight / 668 g/l
Dry film thickness .....	75 µm per coat
Number of coats .....	1
Calculated coverage .....	5.0 m <sup>2</sup> /l at 75 µm
Allow for application losses, surface irregularities, etc.	
Specific gravity .....	1.96 kg/l
Flash points (Closed Cup).....	°C      °F
Amercoat 160HF .....	33      91
Amercoat 9HF .....	26      79
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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## Surface Preparation

STEEL - Blast in accordance with Swedish Standard Sa 2½ SIS 05 5900 - 1967 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 160HF 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 0.53 mm (0.017 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 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 motor or an explosion proof electric motor.

## Application Data Summary

Like all high performance coatings, Amercoat 160HF must be applied as recommended to obtain the maximum protection for which this coating is formulated. To obtain the maximum performance for which Amercoat 160HF 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 ..... suitably prepared steel

Application methods ..... airless or conventional spray, brush for small areas

### Environmental Conditions

(during application and drying)

Air temperature ..... 0 to 50°C (32 to 122°F)

Surface temperature ..... 0 to 55°C (32 to 131°F)

Material temperature ..... 10 to 30°C (50 to 86°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

	°C/°F	10/50	20/68	30/86
dry to handle and topcoat .....		2 hr	1 hr	30 min

NOTE: 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 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.

Potlife (at 20°C/68°F) ..... not applicable

Induction time (at 20°C/68°F) ..... not applicable

Temperature resistance ..... 150°C/302°F dry

Thinner ..... Amercoat 9HF

Cleaner ..... Amercoat 12

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## Application Procedure

Amercoat 160HF is a one component product and packaged in 10 litre units.

1. Flush equipment with Amercoat 12 before use.
2. Stir Amercoat 160HF to an even consistency with a power mixer. NOTE: Amercoat 160HF may show a soft settlement of zinc on the bottom of the can. This settlement should be completely redispersed in the liquid.
3. Strain material through 250 µm (60 mesh) screen to prevent possible clogging of equipment.
4. For conventional spray, thin only as needed for workability with no more than 10% of Amercoat 9HF thinner. Thinning is normally not needed for airless spray.
5. Adjust spray equipment to apply to an even wet coat with minimum overspray. 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. Double coat all welds, rough spots, sharp edges and corners, rivets, bolts, etc.
7. Application at 200 µm wet film thickness will normally provide 75 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. Prevent contact with water until the freshly applied coating is at least dry to touch.
11. 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.
12. Clean all equipment with Amercoat 12 immediately after use or at least at the end of each working day or shift. When left in spray equipment, Amercoat 160HF will cure and cause clogging.

## Shipping Data

Packaging .....	10 l in 10 l can
Shipping weight.....	approx. 20.2 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

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 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.**

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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.