



# Amercoat 217

## Water borne MIO protective coating

(formerly Steelbond 2704)

### Product Data/ Application Instructions

- **Single pack MIO pigmented water borne acrylic coating**
- **EPA compliant (1998)**
- **Low volatile organic compounds**
- **Low odour**
- **Compatible with most aged coatings**
- **Direct adhesion to galvanised steel**
- **Quick and easy to apply**
- **Non flammable**

#### Typical Uses

- Water borne maintenance coating for:-
- Tank roofs and shell externals
  - General plant and steelwork
  - Street furniture and lighting columns

#### Physical Data

Appearance when dry .....	low sheen, metallic sparkle or lustre		
Colour.....	medium grey, silver grey		
Components .....	1		
Volume solids .....	50 ± 2%		
VOC .....	95 g/l		
Curing mechanism .....	Physical drying		
	<b>typical</b>	<b>minimum</b>	<b>maximum</b>
Dry film thickness (µm).....	50	40	75
Wet film thickness (µm) .....	100	80	150
(Wet film thicknesses quoted are theoretical for one brush coat)			
Theoretical coverage .....	10.0 m <sup>2</sup> /l (at typical dft)		
Specific gravity .....	1.5 kg/l		
Flash points (Closed Cup).....	Not applicable		

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## Surface Preparation

All surfaces must be dry and free of dust, salts, grease and other contaminants immediately before coating. Reference should be made to the relevant product data sheets of the recommended primers and cleaning materials as detailed below.

**STEEL** - applied over Amercoat 148 or other suitable Ameron Coatings anti-corrosive primer.

**GALVANISED STEEL** – Thoroughly clean with Amercoat 57 or similar degreasing material and rinse with clean fresh water. Ensure surface is free of white zinc salts before coating by scrubbing/scouring the effected areas and rinsing with clean fresh water.

Allow to dry completely before coating.

**EXISTING SOUND COATINGS** - Feather edges of sound paint back using abrasive means. Roughen surface mechanically to provide a “key” for the new coating.

## Mixing

Stir thoroughly before use until the product is uniform throughout.

## Application Methods

**BRUSH** - Apply evenly using a clean, well loaded brush. Do not attempt to “brush out” or “lay off” the wet coating.

**ROLLER** - Apply evenly making sure the coating is not rolled out too far.

**AIRLESS SPRAY** - Tip size 17-19 thou (0.43-0.48mm). Use a pump of minimum ratio 30:1 (Graco “Bulldog” or equivalent) capable of producing a minimum pressure at the tip of 2800 psi (200kg/square centimetre).

## Application Data

Substrate ..... primed or galvanised steel

Application methods ..... airless spray, brush, roller

### Environmental Conditions

Amercoat 217 should only be applied within the limits of temperature and humidity set out below.

Relative humidity: up to 85%.  
(Good air movement promotes drying)

### Surface temperature:

..... minimum 5°C/41°F  
..... maximum 40°C/104°F

The surface temperature must also be at least 3°C/5°F above dew point.

### Drying Characteristics

Temperature °C/°F	10/50	20/68	30/86
Touch dry	3 hours	2 hours	1 hour
Hard dry	8 hours	4 hours	3 hours
Overcoating (minimum)	3 hours	2 hours	1 hour
Overcoating (maximum)	-	-	-

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

### Overcoating

Can be overcoated with itself to increase the coating thickness or Amercoat 220 water borne finish.

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

Thinner ..... fresh water

Cleaner ..... water, water with detergent

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## Application procedure

1. Clean the equipment with a suitable solvent, then thoroughly flush with water before use.
2. Stir the contents of the can to an even consistency with a power mixer.
3. Thinning is normally not required for airless spray.
4. Stir during use to maintain uniformity of material. When spraying apply a wet even coat in parallel passes. Overlap each pass 50% to avoid bare areas, pinholes or holidays.
5. Double coat all welds, rough spots, sharp edges and corners, rivets, bolts, etc.
6. Application at 100 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 water immediately after use or at least at the end of each working day or shift

**Before using the product, read the label on the can and consult the material safety data sheet.**

## Shipping Data

Pack size .....	5 litres
Shipping weight .....	approx. 9 kg
Shelf life .....	1 year from shipment date or as indicated on the label when stored indoors in unopened, original containers at 5 to 35°C (41 to 95°F). Do not allow to freeze

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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.

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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.