



# Amercoat 2143

## Durable Vinyl Finish Coat on Galvanizing

formerly Steelbond 2143

### Product Data/ Application Instructions

- Direct adhesion to galvanized steel
- One-coat, decorative finish
- Compatible with most aged coatings
- Extensive track record
- Single pack material
- Free from overcoating stress

#### Typical Uses

Amercoat 2143 is a high build decorative protective coating designed to protect both steel and galvanized steel structures including tank roofs/shell externals, fences, galvanized ducts/cladding, street furniture and lighting columns.

#### Overcoating

Can be overcoated with itself to increase the coating thickness. Certain strong colours may require more than one coat for full opacity.

#### Mixing

Stir thoroughly before use until the product is uniform throughout.

### Physical Data

Appearance when dry .....	semi gloss		
Colour .....	RAL and BS colours*		
Components .....	1		
Curing mechanism .....	solvent release		
Volume solids .....	42±2%		
VOC .....	520 g/l		
Film thickness	<b>typical</b>	<b>minimum</b>	<b>maximum</b>
Dry film thickness (µm/mils)	75/3	50/2	100/4
Wet film thickness (µm/mils)	179/7.2	119/4.8	238/9.5
(wet film thicknesses quoted are theoretical for one brush coat)			
Theoretical coverage .....	5.6 m <sup>2</sup> /l (228 f <sup>2</sup> /gal (at typical dft)		
Specific Gravity .....	approx. 1.3 kg/l (depending on colour)		
Flash points (closed cup) .....	°C	°F	
Amercoat 2143 .....	40	104	
Amercoat 65 .....	24	75	
Thinner .....	Amercoat 65		
Cleaner .....	Amercoat 65		

\*Reference is made to the basic colour collections of RAL and BS-4800.

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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 recommended primers and cleaning materials as detailed below.

**NEWLY GALVANIZED STEEL** – Thoroughly clean with Amercoat 57 or similar degreasing material and rinse with clean fresh water. Ensure surface is free of pre-treatments and white zinc salts before coating by scrubbing/scouring the effected areas and rinsing with clean fresh water. Allow to dry completely before coating.

**WEATHERED GALVANIZED 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. Rusted steel should be patch primed using Amercoat 385P, Amercoat 182ZP HB, Amercoat 4180 or other suitable Ameron anti corrosive primer.

**PREVIOUSLY COATED STEEL/GALVANIZED STEEL** – Feather edges of sound paint back using abrasive means. Roughen surface mechanically to provide a 'key' for the new coating. Rusted/exposed steel should be patch primed using Amercoat 385P, Amercoat 182ZP HB, Amercoat 4180 or suitable Ameron anti corrosive primer. A test area is advised to ensure no reaction with the existing coating.

**STEEL NON GALVANIZED**- Applied over Amercoat 385P, Amercoat 182ZP HB, Amercoat 4180 or other suitable Ameron anti corrosive primer.

## Application Equipment

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

**AIRLESS SPRAY** - May be thinned as necessary with up to 10% by volume of the recommended thinner.

Tip size 15-18 thou' (0.38-0.46mm). Pressure at tip: 2800 psi (200kg/cm<sup>2</sup>).

## Application Data

Substrate ..... galvanized or primed steel

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

Environmental conditions

relative humidity: ..... up to 90%

surface temperature: ..... 5-30°C (41-86°F)

*Surface temperature must be at least 3°C (5°F) above dew point to prevent moisture condensation on the surface.*

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

Drying times (°C/°F) .....	10/50	20/68	30/86
Touch dry (hours) .....	2	1	½
Hard dry (hours).....	8	4	2
Full cure (days).....	10	7	4

Recoat or topcoat times (°C/°F)	10/50	20/68	30/86
minimum/hours .....	24	16	8
maximum .....	-	-	-

*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 temperatures and longer at lower temperatures.*

Thinner ..... Amercoat 65

Cleaner ..... Amercoat 65

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## Application procedure

1. Flush equipment with recommended cleaner before use.
2. Stir the contents of the can to an even consistency with a power mixer.
3. Thin if necessary with up to 10% by volume of the recommended thinner.
4. Stir during application to maintain uniformity of material. 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 179  $\mu\text{m}$  (7.2 mils) wet film thickness will normally provide 75  $\mu\text{m}$  (3 mils) 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 either by spray or brush.
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 recommended cleaner immediately after use or at least at the end of each working day or shift

## Shipping Data

Pack size .....	5 litres (1.32 gal)
Shipping weight.....	approx. 7 kg
Shelf life .....	1 year from shipment date when stored indoors in unopened, original containers at 5°C to 40°C (41-104°F).

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

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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 application instructions must be observed during all storage, handling, use and drying periods.

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.

## **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-confirming 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.

## **Condition of Sale**

All our transactions are subject to our Terms and Conditions of Sale.