



Amercoat 220 G

Water borne acrylic finish

(Formerly Steelbond 2706)

Product Data/ Application Instructions

- **Single pack water borne acrylic finish**
- **EPA compliant (1998)**
- **Low volatile organic compounds content**
- **Low odour**
- **Non-flammable**
- **Good colour and gloss retention**
- **Compatible with most aged coatings**
- **Quick and easy to apply by brush, roller and spray**

Typical Uses

Durable water borne finish for tank roofs and shell externals, general plant and steelwork, street furniture and lighting columns. Suitable for application in storage areas, schools, hospitals, laboratories and other internal areas where the use of solvent based coatings is restricted for health, safety and/or environmental reasons.

Physical Data

Appearance when dry	glossy		
Colour	RAL and BS*		
Components	1		
Volume solids	40 ± 2%		
VOC	140 g/l		
Curing mechanism	physical drying		
	typical	minimum	maximum
Dry film thickness (µm)	40	30	55
Wet film thickness (µm)	100	75	138
(Wet film thicknesses quoted are theoretical for one airless spray coat)			
Theoretical coverage	10.0 m ² /l (at typical dft)		
Specific gravity	approx 1.05 – 1.25 kg/l (depending on colour)		
Flashpoint (closed cup)	not applicable		

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

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Surface Preparation

Applied over surfaces primed typically with Amercoat 148 water borne primer. The priming system and preparation will depend on the type and condition of the substrates. Consult your Ameron representative for detailed specifications.

All surfaces must be dry and free of dust, salts, grease and other contaminants immediately before coating.

Mixing

Stir thoroughly before use until the product is uniform throughout.

Application Methods

AIRLESS SPRAY - Tip size 15-19 thou' (0.38-0.48mm). Pressure at tip 2800 psi (200 kg/cm²).
BRUSH - Apply evenly using a clean, well loaded brush. Ensure the coating is not brushed out too far.
ROLLER - Apply evenly using a clean well loaded roller. Ensure the coating is not rolled out too far. Level any air bubbles with a bristle brush.

Overcoating

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

Application Data

Substrate primed substrates
Application methods airless spray, brush, roller
Potlife (at 20°C/68°F) not applicable

Environmental Conditions

Amercoat 220 should only be applied within the limits of temperature and humidity set out below.

Relative humidity: up to 90%
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	90 minutes	45 minutes	20 minutes
Hard dry	4 hours	2 hours	1 hour
Overcoating (minimum)	4 hours	2 hours	1 hour
Overcoating (maximum)	No maximum overcoating time when overcoating with itself		

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

Thinner fresh water

Cleaner water or water with detergent

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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.
3. Thinning is normally not required for airless spray.
4. Stir during application 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 rough spots, sharp edges and corners, rivets, bolts, etc.
6. Application at 100 µm wet film thickness will normally provide 40 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 recommended cleaner 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. 7 kg
Shelf life	1 year from shipment date or as indicated on label when stored indoors in unopened, original containers at 5 to 40°C (41 to 104°F).

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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.

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

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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.