Amercoat 240

Universal Epoxy Coating

Product Data/ Application Instructions

- **Formulated for direct-to-metal application with excellent substrate wetting while retaining excellent edge coverage**
- **Exceptional corrosion protection in salt and fresh water immersion and corrosive chemical environments**
- **Surface tolerant, lowers the cost of surface preparation**
- **Excellent adhesion to tight rust**
- **Compatible with water jetted or hand power tool cleaned surfaces**
- **Low temperature cure down to –18°C (0°F) without additives or alternate curing agents**
- **Fast dry-to-recoat**
- **High-build (up to 300 microns) in one coat**
- **Also available with MIO pigmentation**

Very low solvent content meets VOC requirements, reduces the chances for film pinholing and solvent entrapment at the substrate-coating interface, often a major cause of coating failure with conventional epoxies and lower solids systems.

Typical Uses

Tank Linings and Pipe Coatings

- Ballast and fuel tanks
- Bilges, wet voids and other damp areas

Ships, Offshore and Marine Structures

- Exterior hull above and below waterline
- Decks and superstructures, piping and equipment
- Interior surfaces

Fabrication and New Construction

- Speeds up production, even at low temperatures
- A single coat multi-purpose, surface-tolerant coating

Typical systems

1st coat	2nd coat	3rd coat
Amercoat 240	X	X
Amercoat 240	229 Series, 450 Series, Amershield, PSX 700	X
Amercoat 240	Amercoat 240	X
Amercoat 240	Amercoat 240	ABC3, ABC4
Dimetcote 9 Series or Dim. 302H	Amercoat 240	X
Dimetcote 9 Series or Dim 302H	Amercoat 240	450 Series, 229 Series, Amershield, PSX 700

Physical Data

Finish	Semi-gloss	
Colour	Buff, Haze Grey, Pastel Green, Oxide Red	
Components	2	
Curing mechanism	Solvent release and chemical reaction between components	
Volume solids	87% (ISO 3233)	
Dry film thickness (per coat)	100 – 300 microns (4 –12 mils)	
Number of coats	1 or 2	
Theoretical coverage	m^2/l	ft^2/gal
150 microns (6 mils)	5.8	236
VOC (EPA 24)	g/l	lb/gal
mixed	145	1.2
Temperature resistance	dry	
	°C	°F
continuous	121	250
Flash point (SETA)	°C	°F
Amercoat 240 resin	50	122
Amercoat 240 cure	59	138
Amercoat 65	27	81
Amercoat 12	24	73
Thinner	Amercoat 65	
Cleaner	Amercoat 12	

Tank Coating system – Two coats of Amercoat 240 at 125 to 200 microns (5 to 8 mils) per coat, plus two stripe coats over sharp edges, cutouts and welds. Use contrasting colours for each coat and stripe coat.

Surface Preparation

Coating performance is, in general, proportional to the degree of surface preparation. Abrasive blasting is usually the most effective and economical method. When this is impossible or impractical, Amercoat 240 can be applied over mechanically cleaned surfaces. All surfaces must be clean, dry and free of all contaminants, including salt deposits.

STEEL – Remove all loose rust, dirt, grease or other contaminants by one of the following depending on the degree of cleanliness required: SSPC-SP2, 3, 6 or 7. These minimum surface preparation standards apply to steel that has been previously abrasive blasted. The choice of surface preparation will depend on the system selected and end-use service conditions.
For more severe service and immersion, clean to SSPC-SP10. Blast to achieve an anchor profile of 50-75 microns (2-3 mils) as indicated by a Keane-Tator Surface profile Comparator or Testex Tape. Previously blasted steel may be ultra-high pressure water jetted to NACE NO.5/SSPC-SP12 WJ-2L/SC-1. The wet surface can be dried by blowing with dry compressed air giving special attention to horizontal surfaces and recesses.

ALUMINIUM – Remove oil, grease or soap film with neutral detergent or emulsion cleaner, treat with Alodine® 1200, Alumiprep® or equivalent, or blast lightly with fine abrasive.

GALVANIZING – Remove oil or soap film with detergent or emulsion cleaner, then use zinc treatment such as Galvaprep® or equivalent, or blast lightly with fine abrasive.

CONCRETE- Light abrasive per ASTM D4259 blast to remove all previous coatings, chalk, and surface glaze or laitance. If blasting is not possible, acid etch uncoated concrete per ASTM D4260 to obtain glaze-free surface with a slightly granular texture. Rinse with clean water and allow to dry thoroughly. After blasting or acid etching, fill all small holes or voids with material such as Nu-Klad® 114A filler compound.

AGED COATINGS – All surfaces must be clean, dry, tightly bonded and free of all loose paint, corrosion products or chalky residue. Abrade surface, then clean with Amercoat 88. Amercoat 240 is compatible over most types of properly applied and tightly adhering coatings, however, a test patch is recommended to confirm compatibility.

REPAIR – Prepare damaged areas to original surface preparation specifications, feathering edges of intact coating. Thoroughly remove dust or abrasive residue before touch-up.

Application Data

Applied over	Steel, concrete, aluminium, galvanizing
Surface preparation	
Steel	SSPC-SP2, 3, 6, 7, 10 or 12
Concrete	ASTM D4259 or 4260
Aluminium	Alodine®, Alumiprep® or light abrasive blast
Galvanizing	Galvaprep® or light abrasive blast
Method	Airless or conventional spray. Brush or roller (may require additional coats)
Mixing ratio (by volume)	4 parts resin 1 part cure
Induction time	15 minutes at 21°C (70°F)
Environmental conditions air and surface temperature.	-7° to 50°C (20° to 122 °F)

Surface temperatures must be at least 3°C (5°F) above dew point to prevent condensation. At freezing temperatures, surface must be free of ice.

Thinner	Amercoat 65
Equipment cleaner	Thinner of Amercoat 12
Potlife (@ 21°C)	3 hours

Drying time @ 150 microns (hours)	°C/°F			
	32/90	21/70	10/50	0/32
dry to touch	3	5	10	24
dry hard	6	8	13	30

Cure to immersion (days)	°C/°F				
49/120	32/90	21/70	10/50	0/32	-7/20
2	5	7	10	42	90

Recoat/Topcoat time (@ 125 microns dft)	°C/°F				
minimum (hours)	32/90	21/70	10/50	0/32	-7/20
Amercoat 240	2	5	8	14	28
Amercoat 229 Series or 450 Series	3	5	7	12	40

	°C/°F				
maximum (days)	32/90	21/70	10/50	0/32	-7/20
Amercoat 240	90	90	90	90	90
Amercoat 229 Series 450 Series	3	5	5	7	7

Application Equipment

The following is a guide; suitable equipment from other manufacturers may be used. Changes in pressure, hose and tip size may be needed for proper spray characteristics.

AIRLESS SPRAY – Standard equipment with pump ratio of 45:1 or larger, with a 0.021- to 0.025-inch fluid tip, $^{3}/_{8}$ ID hose with 15 meters maximum length. Long hose runs or location of work at heights 6 – 9 meters higher than the pump location may require higher pump ratios.

CONVENTIONAL SPRAY – Industrial equipment, such as DeVilbiss MBC or JGA or Binks 18 or 62 spray gun. A moisture and oil trap in the main air supply line, a pressure material pot, and separate regulators for air and fluid pressure are recommended.

POWER MIXER – Jiffy Mixer powered by an air or explosion proof electric motor.

BRUSH OR ROLLER – Additional coats may be required to attain proper thickness.

To obtain maximum performance, adhere to all application instructions, precautions, conditions and limitations. For conditions outside the requirements or limitations described, contact your Ameron representative.

Application procedure

1. Flush all equipment with thinner or Amercoat 12 before use.
2. Stir resin using an explosion-proof power mixer to disperse pigments.
3. Add cure to resin. Mix thoroughly until uniformly blended to a workable consistency.
   Induction time (minutes @ 21°C/70°F): 15
4. Do not mix more material than can be used within the expected potlife, 3 hours at 21°C. Higher material temperatures will shorten the potlife considerably.
5. For optimum application, material should be between 10 to 32°C (50-90°F).
6. Use only Amercoat 65 thinner at no more than 10% per volume.
7. To minimize orange peel appearance, adjust conventional spray equipment to obtain adequate atomization at lowest air pressure.
8. Apply a wet coat in even, parallel passes with 50 percent overlap to avoid holidays, bare areas and pinholes. If required, cross spray at right angles.
9. When applying directly over inorganic zincs or zinc-rich primers, a mist coat/full coat technique may be required to minimize bubbling. This will depend on the age of the Dimetcote, surface roughness and conditions during curing.
10. Ventilate confined areas with clean air during application, between coats, and while curing the final coat. Prevent moisture condensation on the surface between coats.
11. Repair damaged areas by brush or spray.
12. Clean equipment with thinner or Amercoat 12 immediately after use.

Note: Consult Code of Federal Regulations Title 29, Labor, parts 1910 and 1915 concerning occupational safety and health standards and regulations, as well as any other applicable federal, state and local regulations on safe practices in coating operations.

Shipping Data

Packaging	
Resin	16l (4,22 gal) in 20l can
Cure	4l (1,06 gal) in 5l can
Shipping weight (approx)	
resin	28.2 kg
cure	7.2 kg
Shelf life	1 year from shipment date when stored indoors in unopened, original containers at 5-40°C (41-104°F).

Numerical values are subject to normal manufacturing tolerances, colour and testing variances. Allow for application losses and surface irregularities.
This mixed product is photochemically reactive as defined by the South Coast Air Quality Management District's Rule 102 or equivalent regulations.

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.

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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.

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