



Amercoat 340

Two pack epoxy low friction coating

(Formerly Utimax BS airless spray)

Product Data/ Application Instructions

- **High Solids, low VOC**
- **Outstanding abrasion resistance**
- **High build**
- **Chemical resistant**
- **Low friction alleviates flow problems**

Typical Uses

Low friction coating for coal hoppers and bunkers, bulk solids storage and handling equipment.

Overcoating

Can be overcoated with itself if necessary. Surface must be abraded if overcoating after maximum overcoating time has elapsed.

Physical Data

Appearance when dry	glossy		
Colour	red, grey		
Components	2		
Mixing ratio by volume			
Resin.....	2.5	parts	
Cure	1	part	
Components	2		
Volume solids	89±3%		
VOC	97 g/l		
Curing mechanism	solvent release and reaction between components		
	typical	minimum	maximum
Dry film thickness (µm)	500	350	500
Theoretical coverage	1.8 m ² /l (at 500 µm)		
Specific gravity	1.63 kg/l (mixed product)		
Flashpoint			
(closed cup)	°C	°F	
Resin.....	4	39	
Cure	15	59	
Amercoat 12	24	75	

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Surface Preparation

STEEL - Dry abrasive blast to ISO 8501-1 SA 2.5 or SSPC SP 10. Surface must be free of moisture, grease and other contaminants. Apply Amercoat 340 as soon as possible to keep the steel from rusting. Obtain an anchor profile of 75-100 microns with an angular shape.

CONCRETE - Light abrasive blasting is best to remove all previous coatings, chalk and surface glaze or laitance. After blasting small holes or voids in cast concrete or overhead surfaces should be filled with a suitable material such as Nu-Klad 114A epoxy filler compound before applying

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IMPORTANT - Apply Amercoat 340 as soon as possible after surface preparation to prevent recontamination. Do not leave blasted steel uncoated overnight. In case of contamination remove contaminants. Spot blast if needed.

Application Methods

AIRLESS SPRAY - Tip size 0,026 - 0,030 inch (0.66-0.76mm). Use a pump minimum ratio 45:1 (Graco "King" or equivalent) capable of producing a minimum pressure at the tip of 3600 psi (250kg/square centimetre). Allow for tip wear due to the nature of the product.

The use of 1/2" diameter spray lines is recommended with 3/8" diameter whip end. Spray lines should be kept as short as possible. In line filters should be removed although a large mesh sieve is recommended at the pump intake.

BRUSH - small areas only.

Application Data

Substrate steel, concrete

Application methods airless spray

Potlife (at 20°C/68°F) 1 hour

Environmental Conditions

Relative humidity: up to 90%

Surface temperature: minimum 5°C/41°F

..... maximum 30°C/86°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	10 hours	6 hours	4 hours
Hard dry	24 hours	16 hours	12 hours
Full cure	7 days	5 days	4 days
Overcoating (minimum)	12 hours	8 hours	6 hours
Overcoating (maximum)	3 days	2 days	36 hours

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 temperatures and longer at lower temperatures

Thinner normally not necessary.

Cleaner Amercoat 12

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Application Procedure:

1. Flush equipment with recommended cleaner before use.
2. Stir resin (in the larger container) to an even consistency with a power mixer.
3. Add cure to resin and continue stirring for 5 minutes. NOTE: Since the potlife is limited and shortened by high temperatures, do not mix more material than will be used within the potlife period.
4. Thinning is normally not required.
5. 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.
6. Double coat all welds, rough spots, sharp edges and corners, rivets, bolts, etc.
7. Application at 560 µm wet film thickness will normally provide 500 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. 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.
11. Clean all equipment with recommended cleaner immediately after use or at least at the end of each working day or shift. When left in spray equipment, the product will cure and cause clogging.

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

Shipping Data

Pack size	20 litres in two part units
Resin	14.3 litres in 20 l. can
Cure	5.7 litres in 10 l. can
Shipping weight	
Resin	approx. 29 kg
Cure	approx. 9 kg
Shelf life	1 year 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.

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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.