



Amercoat 3650

Aluminium epoxy sealer primer

formerly Steelguard 3650

Product Data/ Application Instructions

- **Two pack aluminium pigmented epoxy sealer/primer**
- **EPA compliant as a sealer coat**
- **Complies with BS 5493:1977 - Table 4C Type CP5B**
- **BBA HAPAS and Network Rail approved**
- **Excellent sealing properties**

Typical Uses

Aluminium pigmented epoxy coating for the effective sealing of aluminium and zinc metal-sprayed surfaces.

Approvals

Amercoat 3650 is approved and registered to BBA HAPAS Roads and Bridges Certificate Reference 05/H116 (Highways Agency specification item 159) and Network Rail RT98 specification RT 7.1.1.

Outstanding Characteristics

Amercoat 3650 exhibits excellent sealing properties when applied to aluminium and zinc metal-sprayed surfaces, thus providing a sound basecoat for subsequent application of Amercoat epoxy coatings.

Physical Data

Finish	metallic
Colour	red tinged aluminium
Components	2
Curing mechanism	solvent release and reaction between components.
Volume solids :	40+/-2%
VOC	548 g/l
Dry film thickness	20-40 µm per coat
	typical minimum maximum
Dry film thickness (µm)	25 20 40
Wet film thickness (µm)	63 50 100
(wet film thicknesses quoted are theoretical for a coverage rate of 14-20 square metres per litre)	
Number of coats	1
Calculated coverage	16 m ² /l at 25 µm
Allow for application losses, surface irregularities, etc.	
Induction time (at 20°C/68°F)	not applicable
Mixing ratio (by volume)	
resin	3 parts
cure	1 part
Specific gravity	1.00 kg/l (mixed product)
Flash points (Closed Cup).....	°C °F
resin	36 97
cure	38 100
Amercoat 18	25 77
Amercoat 12 cleaner.....	24 75
Thinner	Amercoat 18
Cleaner	Amercoat 12



Amercoat 3650

Surface preparation

Amercoat 3650 should be applied to the metal spray surface within 4 hours of the metal spray application. The surface must be dry and free of dust, salts, grease and other contaminants immediately before coating.

Mixing

Stir the resin component thoroughly, then add the cure and continue mixing until the product is uniform throughout. A powerful mixer should be used.

Application

Apply at a coverage rate of approximately 14-20 square metres per litre. Ensure the metal spray is adequately sealed, but do not over apply the coating. AIRLESS SPRAY: Use standard airless spray equipment capable of producing a minimum pressure at the tip of 2800 psi (200 kg/cm²). Tip size range 15-17 thou (0.38-0.43mm). Adjustments to pressure and tip size/angle may be necessary to obtain spray characteristics required for specific substrate configurations.

BRUSH/ROLLER: Application by these methods should be limited to small areas only such as repairs and when stripe coating. Apply evenly using a clean, well-loaded brush or roller. With this application more than one coat may be necessary to achieve the required dry film thickness.

Overcoating

Typically overcoated with epoxy primers and intermediates such as Amercoat 3905, Amercoat 3926 and Amercoat 3373. There are no maximum overcoating restrictions with these products provided the Amercoat 3650 is clean, dry and free from contaminants before overcoating.

Application Data

Substrate aluminium or zinc metal spray
Surface preparation..... refer to the typical systems table for specific recommendations

Application methods airless spray, brush or roller

Environmental conditions
Amercoat 3650 should only be applied within the limits of temperature and humidity set out below.

Relative humidity: up to 90%

Surface temperature:..... 5 - 40°C 41-104°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) 8 hours

Drying time (at 20°C/68°F)
dry to handle 4 hours
dry to recoat..... 8 hours

Potlife and drying time are dependent on prevailing temperatures.

Drying times (hours, °C/°F)....	10/50	20/68
Dry to touch	2	1
Hard dry.....	8	4

Recoat times (hours, °C/°F)....	10/50	20/68
Minimum	16	8
Maximum	-	-

Note: All information relates to the typical dry film thickness.

Amercoat 3650

Application Procedure

1. Clean the equipment with the recommended cleaning solvent before use.
2. Stir the resin component thoroughly, then add the cure and continue mixing until the product is uniform throughout. A powerful mixer should be used. Thinning is not required.
3. For airless spray, apply a wet even coat in parallel passes. Overlap each pass by 50% to avoid bare areas, pinholes or holidays.
4. Give special attention to welds, rough spots, sharp edges and corners, rivets, bolts, etc.
5. Application at 65µm wet film thickness will normally provide 25µm dry film.
6. In confined areas ventilate with clean air during application and drying. The humidity should be maintained below 90% and the temperature such that moisture condensation will not form on the surface.
7. Clean all equipment with fresh, clean solvent immediately after use.

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

Shipping Data

Packaging.....	5 litres in two part units
resin for 5 l unit	3.75 L in 5 L can
cure for 5 l unit	1.25 L in 2.5 L can
Shipping weight (approx).....	5 L unit
resin	5 kg
cure	1.5 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°C).

Amercoat 3650

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.

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 descretion 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.

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