Amercoat 3926

High solids epoxy MIO intermediate coating

(formerly Steelguard 3926)

Product Data/ Application Instructions

- Superior, fast drying two pack epoxy MIO intermediate
- EPA compliant
- High build, high solids and low VOC
- Network Rail approved
- Excellent abrasion and impact resistance
- Excellent barrier properties

Typical Uses
Micaceous iron oxide intermediate coating or functional finish for general structural steel operating in a wide range of environmental conditions such as bridges, marine structures, petroleum processing and storage facilities, chemical and power plants and other heavy industrial facilities.

Approvals
Amercoat 3926 is approved and registered to Network Rail RT98 specification item 7.2.1.

Outstanding Characteristics
Amercoat 3926 exhibits excellent barrier properties thus providing enhanced anti-corrosion performance when used in combination with suitable primers and topcoats.

Physical Data

Finish	matt, metallic sparkle
Colour	natural grey, medium grey
Components	2
Mixing ratio (by volume)	
resin	5 parts
cure	1 part
Curing mechanism	solvent release and reaction between components. Effective cure down to 5°C/41ºF
Volume solids :	73+/-3%
VOC	240 g/l
Dry film thickness	100-200 µm per coat

	typical	minimum	maximum
Dry film thickness (µm)	125	100	200
Wet film thickness (µm)	171	137	274

(wet film thicknesses quoted are typical for one airless spray coat)

Number of coats	1
Calculated coverage	5.8 m²/l at 125 µm

Allow for application losses, surface irregularities, etc.

Specific gravity	1.79 kg/l (mixed product)

Flash points (Closed Cup)	ºC	ºF
resin	28	82
cure	30	86
Amercoat 18	25	77
Amercoat 12 cleaner	24	75

Surface preparation
STEEL: Apply over a suitable anti-corrosive primer such as Amercoat 3905. The substrate should be prepared in accordance with the product data instructions of the primer being used.
THERMAL METAL SPRAY: The surface should be sealed with a suitable material such as Amercoat 3650 epoxy aluminium sealer.
In all cases the surfaces 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
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 17-19 thou (0.43-0.48mm). 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 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 finishes such as Amercoat 450S and Amercoat 440HS. Can also be overcoated with itself to increase the coating thickness. There are no maximum overcoating restrictions with these products provided the Amercoat 3926 is clean, dry and free from contaminants before overcoating. If being used as a stripe coat with itself then Amercoat 3926 can be applied using a wet-on-wet technique.

Application Data

Substrate ..... primed steel

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

Induction time (at 20°C/68ºF) not applicable

Potlife (at 20°C/68ºF) ..... 2 hours

Drying characteristics ºC/ºF

Temperature	5/41	10/50	20/68
Touch dry	6 hours	3 hours	$1^1/_2$ hours
Hard dry	10 hours	6 hours	3 hours
Overcoating (minimum)	8 hours	5 hours	2 hours
Overcoating (maximum)	-	-	-

This product will cure down to 0°C/32ºF, however drying times will be extended.

Note: All information relates to the typical dry film thickness. Potlife and drying time are dependent on prevailing temperatures.

Environmental conditions

Amercoat 3926 should only be applied within the limits of temperature and humidity set out below.
Relative humidity: ..... Up to 90%
Surface temperature: ..... Minimum 2°C/36ºF
..... Maximum 40°C/104ºF

The surface temperature must also be at least 3°C/5ºF above the dew point. As with most coatings early contact with water can result in water spotting damage. Care should be taken to protect the coating during the early stages of cure to prevent water marking.

Thinner ..... Amercoat 18

Cleaner ..... Amercoat 12 cleaner

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 170um wet film thickness will normally provide 125um dry film.
6. 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.
7. Small damaged or bare areas and random pinholes or holidays can be touched up by brush. Repair larger areas either by spray, brush or roller using Amercoat 3926.
8. 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.
9. 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 and 20 litres in two part units
resin for 20 l unit	16.67 l in 20 l can
resin for 5 l unit	4.17 l in 5 l can
cure for 20 l unit	3.33 l in 5 l can
cure for 5 l unit	0.83 l in 1 l can

Shipping weight (approx)

	20 l unit	5 l unit
resin	34 kg	9 kg
cure	4 kg	1 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 104ºF).

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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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.

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