



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/41°F |

| | |
|--------------------------|---------------------|
| 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 m ² /l at 125 µm |

Allow for application losses, surface irregularities, etc.

| | |
|------------------------|---------------------------|
| Specific gravity | 1.79 kg/l (mixed product) |
|------------------------|---------------------------|

| | | |
|--------------------------|----|----|
| Flash points | | |
| (Closed Cup)..... | °C | °F |
| resin | 28 | 82 |
| cure | 30 | 86 |
| Amercoat 18 | 25 | 77 |
| Amercoat 12 cleaner..... | 24 | 75 |

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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/68°F) | not applicable |
| Potlife (at 20°C/68°F) | 2 hours |
| Drying characteristics | °C/°F |

| | Temperature | 5/41 | 10/50 | 20/68 |
|-----------------------|-------------|---------|----------|-------|
| Touch dry | 6 hours | 3 hours | 1½ 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/32°F, 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/36°F

..... Maximum 40°C/104°F

The surface temperature must also be at least 3°C/5°F 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

Amercoat 3926

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 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.

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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.