



Amercoat 4117

Fast drying alkyd zinc phosphate primer/finish

(Formerly Steelbond 4117)
(Replaces Amercoat 4117 R23/03/2000)

Product Data/ Application Instructions

- **EPA compliant (1998) as a single coat protective finish**
- **Rapid dry**
- **High build**
- **Quick and easy to apply**
- **Corrosion inhibiting**
- **Tough and durable**

Typical Uses

Works applied single coat protective finish for general structural steelwork in dry internal environments. Meets the performance criteria of ISO12944.

Overcoating

Can be overcoated with itself to increase the coating thickness.

Mixing

Stir thoroughly before use until the product is uniform throughout.

Physical Data

Appearance when dry	semi gloss		
Colour	RAL and BS*		
Components	1		
Volume solids	63 ±3%		
VOC	320 g/l		
Curing mechanism	solvent release and reaction with oxygen from the air.		
	typical	minimum	maximum
Dry film thickness (µm)	75	75	125
Wet film thickness (µm)	119	119	198
(wet film thicknesses quoted are theoretical for one airless spray coat)			
Theoretical coverage	8.4 m ² /l (at typical dft)		
Specific gravity	1.53 kg/l		
Flashpoint			
(closed cup)	°C	°F	
Amercoat 4117	25	77	
Amercoat 65	24	75	

* Reference is made to the basic colour collections of RAL and BS-4800.

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Surface Preparation

STEEL - Abrasive blast clean to ISO 8501-1, Sa 2½. The blast profile achieved should be within the range 50 to 100 microns but not exceeding 100 microns. Application should occur before degradation of the surface takes place. If oxidation occurs then the steel should be re-prepared.

NOTE - The surface must be dry and free of dust, salts, grease and other contaminants immediately before coating.

Application Methods

AIRLESS SPRAY - Tip size 17-19 thou' (0.43-0.48mm). Pressure at tip: 2800 psi (200 kg/square centimetre).

CONVENTIONAL SPRAY - Thin as necessary with up to 10% of the recommended thinner. Use a compressed air spray gun with 40-60 psi supply.

BRUSH - small areas only.

Application Data

Substrate steel
Application methods airless and conventional spray
Potlife (at 20°C/68°F) not applicable

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	1 hour	30 minutes	15 minutes
Hard dry	8 hours	4 hours	2 hours
Full cure	10 days	7 days	5 days
Overcoating (minimum)	8 hours	4 hours	3 hours
Overcoating (maximum)	No maximum overcoating time when overcoating with itself		

NOTE: drying and curing times are dependent on air and steel temperature, applied film thickness, ventilation and other environmental conditions. Times are shorter at higher temperatures and longer at lower temperatures

Thinner Amercoat 65

Cleaner Amercoat 65

Amercoat 4117

Application procedure

1. Flush equipment with recommended cleaner before use.
2. Stir the contents of the can to an even consistency with a power mixer.
3. Thinning is normally not required for airless spray. For conventional spray, thin only if necessary with no more than 10% of recommended thinner.
4. 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.
5. Double coat all welds, rough spots, sharp edges and corners, rivets, bolts, etc.
6. Application at 119 µm wet film thickness will normally provide 75 µm dry film.
7. 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.
8. Small damaged or bare areas and random pinholes or holidays can be touched up by brush. Repair larger areas by spray.
9. 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.
10. Clean all equipment with recommended cleaner immediately after use or at least at the end of each working day or shift

Shipping Data

Pack size	20 litres
Shipping weight	approx. 33 kg
Shelf life	1 year when stored indoors in unopened, original containers at 5 to 35°C (41 to 95°F).

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

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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.