



Amercoat 4180

Modified Vinyl Primer

Product Data/ Application Instructions

- **Single pack vinyl-alkyd primer**
- **Corrosion inhibiting**
- **Fast drying**
- **Rapid overcoating and job completion**
- **Quick and easy to apply**
- **Brush, roller and spray application.**

Typical Uses

Quick drying anti-corrosive primer for the maintenance painting of general plant and structural steelwork. Used extensively as a primer for new build coach and vehicle frames, bodywork and chassis. Amercoat 4180 is also used as a primer in Amercoat cladding re-paint systems as a primer for PVC plastisol.

Mixing

Stir thoroughly before use until the product is uniform throughout.

Overcoating

Can be overcoated with most single pack finishes.

Physical Data

Appearance when dry	matt
Colour	buff, medium grey, off white, red oxide
Components	1
Volume solids	37± 2%
VOC	578 g/l
Curing mechanism	solvent release and reaction with oxygen from the air

	typical	minimum	maximum
Dry film thickness (µm)	50	35	50
Wet film thickness (µm)	135	95	135
(Wet film thicknesses quoted are theoretical for one airless spray coat)			
Theoretical coverage	7.4 m ² /l (at typical dft)		
Specific gravity	1.28 kg/l.		
Flashpoint			
(Closed Cup).....	°F	°C	
Amercoat 4180	46	115	
Amercoat 920	42	108	
Amercoat 12	24	75	

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Surface Preparation

Coating performance is, in general, proportional to the degree of surface preparation. Surfaces must firstly be thoroughly cleaned of all contaminants such as, dust, dirt, grease and salts. Reference should be made to the relevant product data sheets of recommended cleaning materials as detailed below.

STEEL: - Abrasive blast clean to ISO 8501-1, Sa 2½. Where this is not practical, manual preparation to a minimum standard conforming to ISO 8501-1 St2.

COLD ROLLED STEEL (Vehicle frames and chassis):

- Remove sharp edges, weld spatter and other surface defects. Thoroughly wash down with Amercoat 88 or similar material and rinse with clean, fresh water. Allow to dry completely before coating.

ALUMINIUM - Thoroughly wash down with Amercoat 88 or similar material and rinse with clean, fresh water. Allow to dry completely. The surface should then be abraded either manually with coarse abrasive or by light sweep blasting to provide a key for optimum adhesion.

PVC: - Thoroughly wash down with Amercoat 88 and rinse with clean, fresh water. Allow to dry completely before coating. Do not apply on to any exposed galvanised steel surfaces.

Surfaces must be dry and free of dust, salts, grease and other contaminants immediately before coating.

Application Methods

AIRLESS SPRAY - Use a pump of minimum ratio 30:1 (Graco "Bulldog" or equivalent) capable of producing a minimum pressure at the tip of 2800 psi (200 kg/cm²). Tip size 13-15 thou' (0.33-0.38mm).

CONVENTIONAL SPRAY - Use a compressed air spray gun with 40-60 psi supply.

BRUSH/ROLLER - Apply evenly using a clean, well loaded brush or roller. Do not attempt to "brush out" or "lay off" the wet coating otherwise correct thickness will not be achieved.

Application Data

Substrate steel, aluminium, PVC plastisol

Application methods airless and conventional spray, brush, roller

Potlife (at 20°C/68°F) not applicable

Environmental Conditions

Amercoat 4180 should only be applied within the limits of temperature and humidity set out below.

Relative humidity: up to 90%

Surface temperature: minimum 5°C/41°F
..... maximum 35°C/95°F

The surface temperature must also be at least 3°C/5°F above dew point.

Drying Characteristics

Temperature	20°C/68°F
Touch dry	20 minutes
Hard dry	1 hour
Overcoating (minimum)	2 hours
Overcoating (maximum)	-

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 920

Cleaner Amercoat 12

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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 as needed for workability, with up to 10 vol.% of the recommended thinner
4. Stir during use to maintain uniformity of material. When spraying 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 135 µm wet film thickness will normally provide 50 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 either by spray or brush.
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	5 and 20 litres
Shipping weight	approx. 7 kg (5 l.) approx. 30 kg (20 l.)
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).

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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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.