



# Amercoat 4185

## Bitumen coating

(formerly Bitumen 1309)

## Product Data/ Application Instructions

- **Single pack low build bituminous coating**
- **EPA compliant (1998) as a top coat to PG6/23**
- **Corrosion inhibiting**
- **Excellent water and humidity resistance**
- **Quick and easy to apply**

### Typical Uses

Protective coating for steel in enclosed spaces such as cavity walls and structures subjected to aqueous attack, such as tank internals, pipes and gutters. Not suitable for use in service conditions above 55°C/131°F, exposure to direct sunlight or solvent attack.

### Overcoating

Can be overcoated with itself to increase the coating thickness and also Amercoat 4186. Do not overcoat with other generic types of coating.

### Physical Data

Appearance when dry .....	glossy		
Colour .....	black		
Components .....	1		
Volume solids .....	49 ± 2%		
VOC .....	393 g/l		
Curing mechanism .....	solvent release		
	typical	minimum	maximum
Dry film thickness (µm) .....	35	25	50
Wet film thickness (µm) .....	71	51	102
(Wet film thicknesses quoted are theoretical for one brush coat)			
Theoretical coverage .....	14.0 m <sup>2</sup> /l (at typical dft)		
Specific gravity .....	1.0 kg/l		
Flashpoint			
(Closed cup) .....	°C	°F	
Amercoat 4185 .....	39	102	
Amercoat 15 .....	38	100	

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## Surface Preparation

All surfaces must be dry and free of dust, salts, grease and other contaminants immediately before coating. Performance will be dependent upon the degree of surface preparation. For optimum performance abrasive blast clean to ISO 8501-1 Sa2<sup>1</sup>/<sub>2</sub>. Alternatively manually prepare the surface to a minimum standard conforming to ISO 8501-1 St2. May also be applied over a suitably primed surface.

## Application Methods

**AIRLESS SPRAY** - Tip size 13-17 thou (0.33-0.43mm). Minimum pressure at tip 2800 psi (200kg/cm<sup>2</sup>).

**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.

## Application Data

Substrate ..... steel  
Application methods ..... airless and conventional spray, brush, roller

Potlife (at 20°C/68°F) ..... not applicable

### Environmental Conditions

Amercoat 4185 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 30°C/86°F

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

### Drying Characteristics

Temperature	20°C/68°F
Touch dry	2 hours
Hard dry	4 hours
Overcoating (minimum)	16 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 15

Cleaner ..... Amercoat 15

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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.
4. Stir during application 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 71 µm wet film thickness will normally provide 35 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

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

## Shipping Data

Pack size .....	5 litres
Shipping weight .....	approx. 6 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.

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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.

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