



# Amercoat 4189

## Alkyd primer-undercoat

(formerly Steelbond 2198)

### Product Data/ Application Instructions

- **Single pack high build alkyd primer-undercoat**
- **Non-toxic, ion-exchange anti-corrosive pigments**
- **Suitable for application to manually prepared surfaces**
- **Compatible with most aged coatings**
- **Quick and easy to apply**
- **Extensive track record**

#### Typical Uses

Anticorrosive primer for the maintenance painting of general structural steelwork, tank roofs and shell externals, pipework, bridges, cranes and other general plant.

#### Mixing

Stir thoroughly before use until the product is uniform throughout.

#### Overcoating

Can be overcoated with most single pack coatings. For further information contact your Ameron representative.

#### Physical Data

Appearance when dry .....	matt		
Colour .....	red oxide and grey		
Components .....	1		
Curing mechanism .....	solvent release and reaction with oxygen from the air		
Volume solids .....	42 ± 2%		
VOC .....	490 g/l		
	typical	minimum	maximum
Dry film thickness (µm)	75	60	90
Wet film thickness (µm)	179	143	214
(wet film thicknesses quoted are theoretical for one brush coat)			
Theoretical coverage .....	5.6 m <sup>2</sup> /l (at typical dft)		
Specific gravity .....	1.25 kg/l		
Flash points			
(Closed Cup).....	°C	°F	
Amercoat 4189 .....	33	91	
thinner TN05 .....	46	115	

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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. This can most effectively be carried out by using a biodegradable water based cleaner such as Amercoat 88 or similar, followed by thorough rinsing using clean fresh water.

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.

EXISTING SOUND COATINGS - Roughen surface mechanically to provide a "key" for the new coating. Feather edges of sound paint back using abrasive means.

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

## Application Methods

BRUSH/ROLLER - Apply evenly using a clean, well loaded brush or roller. More than one coat may be required to achieve the specified film thickness.

AIRLESS SPRAY - Tip size 15-18 thou' (0.38-0.46mm). Minimum pressure at the tip 2800 psi (200 kg/cm²).

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

## Application Data

Substrate ..... steel and existing sound coatings

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

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

### Environmental Conditions

Amercoat 4189 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: 40°C/104°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	20 minutes
Hard dry	4 hours	2 hours	90 minutes
Overcoating (minimum)	6 hours	4 hours	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 102E

Cleaner ..... Amercoat 102<sup>E</sup>

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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. Thin only as needed for workability, with up to 10% by volume of the recommended thinner
4. Stir during application to maintain uniformity of material. For spray application 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 179 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

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

## Shipping Data

Pack size .....	5 litre
Shipping weight .....	approx. 7 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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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](http://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.

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