



# Amercoat 4190

## Grease paint penetrating primer

formerly Steelbond 1620

### Product Data/ Application Instructions

- BBA HAPAS approved
- Single pack material
- Tolerant to manually prepared surfaces
- Quick and easy to apply by brush, roller or spray

#### Typical Uses

Amercoat 4190 is a penetrating primer specifically for use in conjunction with Amercoat 4191 for the coating of interiors of bridge box sections, ships tanks, lighting columns, voids and other difficult access areas.

#### Approvals

Amercoat 4190 is approved and registered to BBA HAPAS Roads and Bridges Certificate Reference 05/H116 (Highways Agency specification item 200).

#### Outstanding Characteristics

Amercoat 4190 exhibits excellent penetrating properties, making it ideal for coating difficult areas such as joints, around bolt heads, nuts, washers and plate edges.

#### Physical Data

Finish .....	low sheen, waxy
Colour .....	clear, semi-opaque
Components .....	1
Curing mechanism .....	solvent release
Volume solids : .....	24+/-2%
VOC .....	630 g/l
Dry film thickness .....	15-25 µm per coat

	typical	minimum	maximum
Dry film thickness (µm)	20	15	25
Wet film thickness (µm)	83	60	104

(wet film thicknesses quoted are typical for one brush coat)

Number of coats ..... 1

Calculated coverage ..... 12 m<sup>2</sup>/l at 20 µm  
Allow for application losses, surface irregularities, etc.

Drying time (at 20°C/68°F)

dry to handle ..... N/A

dry to recoat ..... 4 hours with Steelbond 2610

Drying times are dependent on prevailing temperatures.

Induction time (at 20°C/68°F) not applicable

Specific gravity ..... 0.85 kg/l

Flash points (Closed Cup).....	°C	°F
Amercoat 4190 .....	32	90
Amercoat 15 .....	38	100

Thinner ..... Amercoat 15

Cleaner ..... Amercoat 15



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## Surface preparation

Performance will be dependent on surface preparation. Ideally abrasive blast clean to BS 7079:Part A1 Sa 2½. The blast profile achieved should be typically within the range 35-75 microns but not exceeding 100 microns. Alternatively may be applied to manually prepared steel to BS 7079:Part A1 St 2 minimum. All surfaces must be dry and free of dust, salts, grease and other contaminants immediately before coating.

## Mixing

Stir thoroughly before use product is uniform throughout.

## Application

**AIRLESS SPRAY:** Use standard airless spray equipment capable of producing a minimum pressure at the tip of 2800 psi (200 kg/cm<sup>2</sup>). Tip size range 13-17 thou (0.33-0.43mm). Adjustments to pressure and tip size/angle may be necessary to obtain spray characteristics required for specific substrate configurations.

**CONVENTIONAL SPRAY:** Use standard industrial equipment. Thinning with the recommended thinner may be necessary to facilitate application.

**BRUSH/ROLLER:** Apply evenly using a clean, well-loaded brush or roller. Do not over apply the coating and prevent pooling, specifically on horizontal surfaces.

## Application Data

Substrate ..... prepared steel  
Surface preparation..... refer to the typical systems table for specific recommendations  
Application methods ..... airless or conventional spray, brush or roller

Environmental conditions  
Amercoat 4190 should only be applied within the limits of temperature and humidity set out below.

Relative humidity: ..... up to 90%

Surface temperature:..... 2 - 40°C      36 - 104°F

*Surface temperature must be at least 3°C/5°F above dew point to prevent moisture condensation on the surface.*

Potlife (at 20°C/68°F) ..... N/A

Drying times (°C/°F) .....	5/41	10/50	20/68	30/86
Touch dry (hours) .....	16	6	3	1
Hard dry .....	NA	NA	NA	NA

Overcoating times (°C/°F) .....	5/41	10/50	20/68	30/86
Minimum (hours).....	24	16	4	3
Maximum .....	-	-	-	-

# Amercoat 4190 does not harden like other coatings remaining soft and waxy but firm

Note: All information relates to the typical dry film thickness.

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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.
3. Thinning is normally not required for airless spray.
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. Application at 85 µm wet film thickness will normally provide 20 µm 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 by spray.
8. 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.
9. Clean all equipment with recommended cleaner immediately after use or at least at the end of each working day or shift.

## Shipping Data

Packaging.....	5 litres
Shipping weight (approx).....	5 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 (41-104°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 application instructions must be observed during all storage, handling, use and drying periods.

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.

## **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-confirming 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.

## **Condition of Sale**

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