



Amercoat 4191

Grease paint undercoat/finish

formerly Steelbond 2610

Product Data/ Application Instructions

- **BBA HAPAS approved**
- **Tolerant to manually prepared surfaces**
- **Compatible with most aged coatings**
- **Single pack material**
- **Quick and easy to apply**
- **High build**

Typical Uses

Surface tolerant maintenance coating for use in both industrial and marine environments. Provides anti-corrosive protection for the interior of bridge box sections, ships tanks, lighting columns, voids and other difficult access areas where blast cleaning is impractical.

Approvals

Amercoat 4191 is approved and registered to BBA HAPAS Roads and Bridges Certificate Reference 05/H116 (Highways Agency specification item 201).

Outstanding characteristics

Amercoat 4191 exhibits excellent adhesion to manually prepared rusty steel surfaces thus providing a high level of corrosion resistance. Compatibility is excellent with most aged coating systems and therefore eliminates the need for their complete removal.

Physical Data

Finish	low sheen, waxy
Colour	black, white, yellow
Components	1
Curing mechanism	solvent release
Volume solids	55+/-2%
VOC	345 g/l
Dry film thickness	100 - 200 µm per coat

	typical	minimum	maximum
Dry film thickness (µm)	150	100	200
Wet film thickness (µm)	273	182	364

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

Number of coats	1 or 2
Calculated coverage	3.7 m ² /l at 150 µm

Allow for application losses, surface irregularities, etc.

Drying time (at 20°C/68°F)	
dry to handle	N/A (firm at 16 hours)
dry to recoat	16 hours with itself

Drying times are dependent on prevailing temperatures.

Induction time (at 20°C/68°F)	not applicable
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Thinner	Amercoat 15
Cleaner	Amercoat 15

Specific gravity	Approx. 1.2 kg/l
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Flash points (Closed Cup).....	°C	°F
Amercoat 4191	32	90
Amercoat 15	38	100



Amercoat 4191

Surface preparation

Normally applied over Amercoat 4190 (HA item 200, grease paint penetrating primer). May also be applied over manually prepared surfaces that have been hand or power tool cleaned to a minimum standard conforming to ISO 8501-1 St2.

Amercoat 4191 can also be applied to existing aged coating systems. Loose and flaking coatings should be removed and feathered back to a firm edge. Remaining glossy coatings such as epoxy and polyurethane should be abraded and degreased prior to application. A test area is advised to ensure compatibility and no reaction with the existing coating. In all cases the 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/cm²). Tip size range 17-23 thou (0.43-0.58mm). Adjustments to pressure and tip size/angle may be necessary to obtain spray characteristics required for specific substrate configurations.

BRUSH: Apply evenly using a clean, well-loaded brush or roller. Do not attempt to "brush-out" or "lay-off" the wet coating or the required film build may not be achieved.

At low temperatures may be thinned with up to 5% by volume of the recommended thinner to ease application.

Application Data

Substrate steel
Surface preparation..... refer to the typical systems table for specific recommendations

Application methods airless spray or brush

Environmental conditions
Amercoat 4191 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	8	4	2
Hard dry	NA	NA	NA	NA

Overcoating times (°C/°F)	5/41	10/50	20/68	30/86
Minimum (hours)	32	24	16	8
Maximum	-	-	-	-

Amercoat 4191 becomes firm after 16 hours at 20°C/68°F. The coating does not harden to the extent of other protective coatings but remains firm and wax like.

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

Amercoat 4191

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. Double coat all rough spots, sharp edges and corners, rivets, bolts, etc.
6. Application at 275 µm wet film thickness will normally provide 150 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

Packaging.....	5 litres
Shipping weight (approx).....	6.5 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.

Amercoat 4191

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.

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In no event shall Ameron be liable for consequential or incidental damages.

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