



Amercoat 4350

Urethane alkyd based undercoat

(formerly Steelbond 1350)

Product Data/ Application Instructions

- **Tough and durable**
- **Smooth, with high opacity**
- **Single pack material**
- **Network Rail approved**
- **Quick and easy to apply either by brush, roller or spray**

Typical Uses

High opacity undercoat for general structural steel to be overcoated with suitable alkyd based topcoats.

Approvals

Amercoat 4350 is approved and registered to Network Rail RT98 specification item 5.13.2.

Surface preparation

For use in protective coating systems Amercoat 4350 must be applied over suitably primed surfaces. The priming system used will depend on the type and condition of the substrates. Surface preparation must be in accordance with the product data instructions of the primer being used. Consult your Ameron representative for detailed specifications.

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

Physical Data

Finish	low sheen
Colour	Limited range
Components	1
Curing mechanism	solvent release and reaction with oxygen from the air
Volume solids :	50+/-2%
VOC	385 g/l
Dry film thickness	35-50 µm per coat

	typical	minimum	maximum
Dry film thickness (µm)	40	35	50
Wet film thickness (µm)	80	70	100

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

Number of coats	1	
Calculated coverage	12.5 m ² /l at 40 µm	
Allow for application losses, surface irregularities, etc.		
Specific gravity	1.3 kg/l (white)	
Flash points		
(Closed Cup).....	°C	°F
Amercoat 4350	42	108
Amercoat 15	38	100

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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 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. With this application more than one coat may be necessary to achieve the required dry film thickness.

Overcoating

Normally overcoated with Amercoat 4310. There are no maximum overcoating restrictions provided the Amercoat 4350 is clean, dry and free of contamination before overcoating.

Application Data

Substrate	Primed surface
Application methods	airless or conventional spray, brush or roller
Potlife (at 20°C/68°F)	N/A
Induction time (at 20°C/68°F)	not applicable
Drying characteristics	°C/°F

Temperature	10/50	20/68
Touch dry	6 hours	3 hours
Hard dry	16 hours	8 hours
Overcoating (minimum)	24 hours	16 hours
Overcoating (maximum)	-	-

Note: All information relates to the typical dry film thickness. Drying and curing times are dependent on air and substrate temperature, applied film thickness, ventilation and other environmental conditions. Times are shorter at higher temperatures and longer at lower temperatures

Environmental conditions

Amercoat 4350 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 the dew point during application.

Thinner

Amercoat 15

Cleaner

Amercoat 15

Amercoat 4350

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 80 µm wet film thickness will normally provide 40 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

Packaging.....	5 litres
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.

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.

Any recommendations or suggestion relating to the use of the products made by Ameron, whether in its technical literature, or response to specific enquiry, or otherwise, is based on data believed to be reliable; however, the products and information are intended for use by Buyer's having requisite skill and know-how in the industry, and therefore it is Buyer to satisfy itself of the suitability of the products for its own particular use and it shall be deemed that Buyer has done so, as its sole discretion and risk. Variation in environment, changes in procedures of use, or extrapolation of data may cause unsatisfactory results.

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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.