



Amercoat 4380

Two pack epoxy pitch

formerly Steelguard 3380

Product Data/ Application Instructions

- **Excellent abrasion & impact resistance**
- **Excellent resistance to water immersion**
- **EPA compliant**
- **BBA HAPAS approved**

Typical Uses

High build protective coating for immersed/buried structures e.g. lighting column/CCTV mast roots, piling, pier & jetty legs.

Approvals

Amercoat 4380 is approved and registered to BBA HAPAS Roads and Bridges Certificate Reference 05/H116 (Highways Agency specification item 150).

Physical Data

Finish	low sheen
Colour	black, brown
Components	2
Curing mechanism	solvent release and reaction between components. Effective cure down to 5°C/41°F
Volume solids	60+/-3%
VOC	239 g/l
Dry film thickness	typical minimum maximum
Dry film thickness (µm)	125 100 150
Wet film thickness (µm)	208 167 250
(wet film thicknesses quoted are typical for one airless spray coat)	
Number of coats	1
Calculated coverage	4.8 m ² /l at 125 µm
Allow for application losses, surface irregularities, etc.	
Induction time (at 20°C/68°F)	not applicable
Mixing ratio (by volume)	
resin	3 parts
cure	1 part
Thinner	Amercoat 18
Cleaner	Amercoat 12
Specific gravity	1.30 kg/l (mixed product)
Flash points (Closed Cup)	°C °F
resin	26 79
cure	26 79
Amercoat 18	25 77
Amercoat 12	24 75



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Surface preparation

Apply over a suitable anti-corrosive primer such as Amercoat 4371. The substrate should be prepared in accordance with the product data instructions of the primer being used. The surface must be dry and free of dust, salts, grease and other contaminants immediately before coating.

Mixing

Stir the resin component thoroughly, then add the cure and continue mixing until the product is uniform throughout. A powerful mixer should be used.

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 17-21 thou (0.43-0.53mm). Adjustments to pressure and tip size/angle may be necessary to obtain spray characteristics required for specific substrate configurations.

BRUSH/ROLLER: Application by these methods should be limited to small areas only such as repairs and when stripe coating. 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

Maximum overcoating times refer to overcoating with itself. When overcoating with itself then the recoat time should be no longer than maximums shown above. For specific overcoating and topcoat recommendations contact your Ameron representative.

Application Data

Substrate primed steel
Surface Preparation refer to the typical systems table for specific recommendations

Application methods airless spray, brush or roller

Environmental conditions
Amercoat 4380 should only be applied within the limits of temperature and humidity set out below.

Relative humidity up to 90%

Surface temperature 5 - 40°C 41-104°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) 8 hours

Drying time (°C/°F)	5/41	10/50	20/68
touch dry (hours)	8	5	3
hard dry (hours)	24	16	12

Overcoating times (°C/°F)	5/41	10/50	20/68
Minimum (hours)	24	16	12
Maximum (days)	10	7	4

Potlife and drying times are dependent on prevailing temperatures.

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

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Applicaton Procedure

1. Clean the equipment with the recommended cleaning solvent before use.
2. Stir the resin component thoroughly, then add the cure and continue mixing until the product is uniform throughout. A powerful mixer should be used. Thinning is not required.
3. For airless spray, apply a wet even coat in parallel passes. Overlap each pass by 50% to avoid bare areas, pinholes or holidays.
4. Give special attention to welds, rough spots, sharp edges and corners, rivets, bolts, etc.
5. Application at 208µm wet film thickness will normally provide 125µm 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 either by spray, brush or roller using Amercoat 4380.
8. In confined areas ventilate with clean air during application and drying. The humidity should be maintained below 90% and the temperature such that moisture condensation will not form on the surface.
9. Clean all equipment with fresh, clean solvent immediately after use.

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

Shipping Data

Packaging.....	5 and 20 litres in two part units	
resin for 20 l unit	15 l in 20 l can	
resin for 5 l unit	3.75 l in 5 l can	
cure for 20 l unit	5 l in 5 l can	
cure for 5 l unit	1.25 l in 2.5 l can	

Shipping weight (approx).....	20 l unit	5 l unit
resin	21 kg	5 kg
cure	7 kg	2 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°C).	
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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.

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 descretion and risk. Variation in environment, changes in procedures of use, or extrapolation of data may cause unsatisfactory results.

Limitation of Liability

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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.