



# Amercoat 4613

Micaceous iron oxide urethane alkyd undercoat/finish

(formerly Steelbond 1613)

## Product Data/ Application Instructions

- EPA compliant (1998) as a top coat to PG6/ 23
- Tough and durable
- Network Rail approved
- Excellent adhesion
- Quick and easy to apply by brush, roller or spray
- Single pack material
- Brush and airless spray application

### Typical Uses

High build intermediate/finish for general structural steel which can be overcoated with suitable alkyd based topcoats.

### Approvals

Amercoat 4613 is approved and registered to Network Rail RT98 specification item 5.2.1.

### Surface Preparation

For use in protective coating systems Amercoat 4613 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.

### Mixing

Stir thoroughly before use until the product is uniform throughout.

### Physical Data

Appearance when dry .....	Low sheen metallic sparkle or lustre
Colour .....	Approx. BS4800 limited range
Components .....	1
Volume solids .....	52 ± 2%
VOC .....	360-400 g/l (dependent on colour)
Dry film thickness .....	45-80 µm per coat
Curing mechanism .....	solvent release and reaction with oxygen from the air

	typical	minimum	maximum
Dry film thickness (µm) .....	65	45	80
Wet film thickness (µm) .....	125	87	154
(Wet film thicknesses quoted are theoretical for one brush coat)			
Theoretical coverage .....	8.0 m <sup>2</sup> /l (at typical dft)		
Specific gravity .....	approx 1.3 kg/l (depending on colour)		
Flash point (closed cup) .....	°C	°F	
Amercoat 4613 .....	41	106	
Amercoat 15 .....	38	100	

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## Application Methods

**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 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.

**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.

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

## Overcoating

Can be overcoated with itself or other suitable finishes such as Steelbond 2310. There are no maximum overcoating restrictions provided the Amercoat 4613 is clean, dry and free of contamination before overcoating.

## Application Data

Substrate ..... Primed substrates  
Application methods ..... airless or conventional spray, brush or roller  
Potlife (at 20°C/68°F) ..... N/A

### Environmental Conditions

Amercoat 4613 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		
	5/41	20/68	30/86
Touch dry	8 hours	3 hours	2 hours
Hard dry	16 hours	4 hours	3 hours
Overcoating (minimum)	6 hours by airless spray	3 hours by airless spray	2 hours by airless spray
	16 hours by brush	6 hours by brush	3 hours by brush
Overcoating (maximum)	No maximum overcoating time when overcoating with itself		

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 15

Cleaner ..... Amercoat 15

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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. Double coat all rough spots, sharp edges and corners, rivets, bolts, etc.
6. Application at 125 µm wet film thickness will normally provide 65 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 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.**

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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](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.

## **Condition of Sale**

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