



# Amercoat 64

## Amine-Cured Epoxy Primer

### Product Data/ Application Instructions

- Suitable for variety of substrates
- No inhibitive pigments for excellent water and chemical resistance
- Ideal for water immersion, when topcoated with Amercoat 90S
- Formulated for strong adhesion with epoxy topcoats

#### Typical Uses

Suitable primer for epoxy tanklining Amercoat 90S.

#### Resistance Guide

**WATER:** Resists continuous immersion in fresh, salt and demineralised water up to 60°C/147°F, when topcoated with Amercoat 90S

#### Repair

Spot blast or power tool clean bare substrate to the requirements shown under surface preparation. Feather edges of intact coating. Remove dust, dirt and contamination before recoating.

#### Physical Data

Finish .....	flat
Colour .....	pale red
Components .....	2
Mixing ratio (by volume)	
resin .....	24 parts
cure .....	1 part
Curing mechanism .....	solvent release and chemical reaction between components
Volume solids .....	32% (ASTM D2697, modified)*
VOC .....	53% by weight/582 g/l
Dry film thickness .....	35 µm per coat
Number of coats .....	1
Calculated coverage .....	9.1 m <sup>2</sup> /l at 35 µm
Allow for application losses, surface irregularities, etc.	
Specific gravity .....	1.10 kg/l (mixed product)
Flash points	
(Closed Cup).....	°C    °F
resin .....	23    73
cure .....	31    88
Amercoat 9HF .....	26    79
Amercoat 12 .....	24    75

\* Volume solids is measured in accordance with ASTM D2697 modified. Slight variations ± 3% may occur due to colour and testing variances.

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## Surface Preparation

STEEL - Round off all rough welds and sharp edges. Remove weldspatter. Blast in accordance with Swedish Standard Sa 3 SIS 05 5900 - 1967, ISO 8501-1 or Steel Structures Painting Council SP-5. NOTE: Blast to achieve a 25 to 50 µm profile as determined with *Testex* Tape or similar instrument. Remove abrasive residues and dust from surface. IMPORTANT - Apply product as soon as possible to prevent rusting. Keep moisture, oil, grease or other organic matter of surface before coating. Spot reblast to remove any contamination; solvent wiping is not enough.

## Application Equipment

The following equipment is listed as a guide and suitable equipment from other manufacturers may be used. Adjustments of pressure and change of tip size may be needed to obtain the proper spray characteristics.

AIRLESS SPRAY - Standard airless spray equipment, such as Graco, DeVilbiss, Nordson-Bede, Spee-Flo or others having a 28:1 or higher pump ratio and a fluid tip with a 0.015 to 0.021 mm (0.38 to 0.53 inch) orifice.

CONVENTIONAL SPRAY - Industrial equipment such as DeVilbiss MBC or JGA gun with 78 or 765 air cap and "E" nozzle and heavy mastic spring or Binks No. 18 or 62 with a 66 x 63 PB nozzle setup. Separate air and fluid pressure regulators and a mechanical pot agitator are recommended. A moisture and oil trap in the main air supply line is essential.

MIXER - Use power mixer powered by an air motor or an explosion proof electric motor.

BRUSH/ROLLER - Natural bristle. Maintain a wet edge.

## Application Data Summary

Like all high-performance coatings, this product must be applied as recommended to obtain the maximum protection for which this coating is formulated. To obtain the maximum performance for which this product is formulated, strict adherence to all application instructions, precautions, conditions and limitations is necessary. If conditions exist that are not within the requirements or limitations described, consult your Ameron representative.

## Application Data

Substrate ..... steel and aluminium  
Application methods ..... airless or conventional spray, brush or roller

Environmental Conditions  
(during application and drying)  
Air temperature ..... 5 to 50°C      41 to 122°F  
Surface temperature ..... 5 to 60°C      41 to 140°F  
Material temperature ..... 10 to 40°C      50 to 104°F

To prevent moisture condensation during application, surface temperature must be at least 3°C/5°F above dew point. Never apply coatings under reverse environmental conditions. Ensure good ventilation when applied in confined areas to assist evaporation and eliminations of solvents.

Drying Times  
(in hours)                      °C/°F    10/50    20/68    30/86  
dry to touch .....                      2            1            ½  
dry to handle .....                      6            3            1

NOTE: Drying times are dependent on air and steel temperature, applied film thickness, ventilation and other environmental conditions. Times are proportionally shorter at higher temperature and longer at lower temperatures. Prior to recoating ensure the surface is clean. Consult your Ameron representative for specific recommendations.

Potlife (at 20°C/68°F) ..... 8 hours

Potlife and drying times are dependent on temperature and quantities mixed.

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

Topcoating Times  
   °C/°F    10/50    20/68    30/86  
minimum .....                      8            4            2 (hours)  
maximum .....                      14          7            4 (days)

Thinner ..... Amercoat 9 HF

Cleaner ..... Amercoat 12

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## Application Procedure

This product is packaged in the proper mixing proportions of resin and cure.

Resin: 19.2 l in 20 l can

Cure: 0.8 l in 1 l can

1. Flush equipment with recommended cleaner before use.
2. Stir each of the components prior to mixing to an even consistency with a power mixer.
3. Add cure to resin and continue stirring for 5 minutes.

NOTE: Since the potlife is limited and shortened by high temperatures, do not mix more material than will be used within the potlife period.

4. For conventional spray, thin only as needed for workability with no more than 10% of recommended. Thinning is normally not needed for airless spray.
5. Stir during application to maintain uniformity of material. Apply a wet coat by even, parallel passes. Overlap each pass 50% to avoid bare areas, pinholes or holidays.
6. Double coat all welds, rough spots, sharp edges and corners, rivets, bolts, etc.
7. Application at 110 µm wet film thickness will normally provide 35 µm dry film.
8. 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.
9. Small damaged or bare areas and random pinholes or holidays can be touched up by brush. Repair larger areas by spray.

## Shipping Data

### Packaging

resin ..... 19.2 l in a 20 l can  
cure ..... 0.8 l in a 1 l can

### Shipping weight

resin ..... approx. 28 kg  
cure ..... approx. 1.2 kg

### Shelf life

resin and cure ..... 1 year from shipment date when stored indoors in unopened, original containers at 5 to 40°C (41 to 104°F).

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## Caution

This product is flammable.

Keep away from heat and open flame. Keep container closed. Use with adequate ventilation. Avoid prolonged and repeated contact with skin. If used in confined areas, observe the following precautions to prevent hazards of fire or explosion or damage to health:

1. circulate adequate fresh air continuously during application and drying;
2. use fresh air masks and explosion proof equipment;
3. prohibit all flames, sparks, welding and smoking.

Do not empty into drains. Take precautionary measures against static discharges. For specific information on hazardous ingredients, required ventilation, possible consequences of contact, exposure and safety measures see Safety Data Sheet.

## 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.

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

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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.