



Dimetcote 302



Reinforced Inorganic Zinc Primer

(302 Series)

Product Data/ Application Instructions

- Can be topcoated as soon as Dimetcote 302 is solvent free
- Outstanding resistance to water, weather and abrasion
- Superior performance on marine hulls, decks and superstructures
- Resistant to dry spray, mudcracking and topcoat bubbling
- Easily applied by airless or conventional spray and brush

Typical Uses

(with suitable topcoats)

INDUSTRIAL - Structural steel, machinery pipes, and tank exteriors in paper mills, oil refineries, power plants, chemical process and waste treatment plants.

MARINE - Decks, hulls and superstructures of ships, barges and workboats. Piers, offshore platforms and related structures.

Outstanding Characteristics

The zinc contents provides a cathodic protection if film is damaged. Apply a single coat of Dimetcote 302 primer at 75 µm dry film thickness, overcoated with a recommended epoxy topcoat or topcoat system. With the proper topcoats, withstands splash or spillage of water, solvents, chemicals and petroleum products. For specific recommendations contact your Ameron representative.

Repair

Dimetcote 302 may be used to repair itself or other inorganic zinc coatings.

Recommended topcoats

High build epoxies such as Amercoat 235, Amercoat 240, Amercoat 370, Amercoat 385 and Amerlock or PSX 700 Polysiloxane. Dimetcote 302 surface must be clean and dry before topcoating. Water soluble contaminants may be washed off with water. Remove grease and similar contaminants with an emulsion type cleaner or neutral detergent. Rinse with clean water and allow to dry. Solvent wiping is not satisfactory as contamination may only be spread and not removed. In some cases a mist coat/full coat technique may be required to prevent application bubbling.

Physical Data

Finish	flat
Colour	greenish grey
Components	2
Mixing ratio (by volume)	
resin	4 parts
cure	1 part
Curing mechanism	by solvent release and reaction between components
VOC	22.6% by weight 429 g/l 3.5 lbs/gal
Dry film thickness	75 µm (3 mils) per coat
Number of coats	1
Calculated coverage	7.4 m ² /l (at 75 µm)
Allow for application losses, surface irregularities, etc	
Specific gravity	1.95 kg/l (mixed product)
Temperature resistance	205°C/401°F (dry heat)
Flash points (Closed Cup).....	°C °F
resin	26 79
cure	26 79
Amercoat 9HF	26 79
Amercoat 12	24 75
Thinner	Amercoat 9HF
Cleaner	Amercoat 12

Dimetcote 302



Application Data Summary

Like all high performance coatings, Dimetcote 302 primer must be applied as recommended to obtain the maximum performance.

Dimetcote 302 is a reinforced inorganic zinc primer, which also can be used as a maintenance coating for structural steel, marine structures or for repairing itself or other inorganic zinc primers. To obtain the maximum performance for which Dimetcote 302 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.

Surface Preparation

STEEL - Previously painted or pitted steel and new steel without pits or depressions, blast in accordance with Sa 2½ (ISO 8501-1). For mild exposures, power tool cleaning in accordance with St 3 is acceptable.

NOTE: blast to achieve a 25 to 50µm (1 - 2 mils) profile as determined with Testex Press-O-Film tape or similar instrument. Remove abrasive residues and dust from surface.

IMPORTANT - Apply Dimetcote 302 as soon as possible after surface preparation to prevent any contamination. Do not leave blasted steel uncoated overnight. In case of contamination, remove contaminants. Spot blast steel if needed.

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 0.43 to 0.53 mm (0.017 to 0.021 inch) orifice.

CONVENTIONAL SPRAY - Industrial equipment such as DeVilbiss MBC or JGA gun with 765 air cap or Binks No. 18 or 62 spray gun. Separate air and fluid pressure regulators, mechanical pot agitator and a moisture and oil trap in the main air supply line are recommended.

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

Application Data

Substrate abrasive blasted steel

Application airless or conventional spray

Environmental Conditions (during application and drying)
Air temperature 5 to 50°C 41 - 122°F
Surface temperature 5 to 60°C 41 - 140°F

For satisfactory cure, air and surface temperatures must be above 10°C/50°F.

Surface temperature must be at least 3°C/5°F above dew point to prevent moisture condensation on the surface.

Never apply coatings under reverse environmental conditions.

Ensure good ventilation when applied in confined areas to assist evaporation and eliminations of solvents.

Potlife (at 20°C/68°F) 8 hours

Drying times (at 75µm/3 mils 20°/68°F)

dry to handle 6 hours

dry to topcoat 2 hours

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.

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

Thinner Amercoat 9HF

Cleaner Amercoat 12

Dimetcote 302



Application Procedure

Dimetcote 302 is packaged in the proper mixing proportions of resin and cure.

Resin 8 l in 10 l can
Cure 2 l in 2½ l can

1. Flush equipment with Amercoat 12 cleaner before use.
2. Stir resin (in the larger container) to an even consistency with a power mixer.
3. Add cure to resin, and continue stirring for 5 minutes. Strain material through a 250 µm (60 mesh) screen to prevent possible clogging of equipment. NOTE: since the potlife is limited and shortened by high temperatures, do not mix more material than will be used in 8 hours at 20°C/68°F.
4. Thinning is normally not required for airless spray. For conventional spray, thin only as needed for workability, with up to 10% by volume of Amercoat 9HF.
5. Stir during application to maintain uniformity of material. Apply a wet coat in 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 125 - 150 µm (5 - 6 mils) wet film thickness will normally provide 75 µm (3 mils) dry film. Total dry film thickness must not exceed 150µm (6 mils).
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.
10. 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.
11. Clean all equipment with Amercoat 12 cleaner immediately after use or at least at the end of each working day or shift. When left in spray equipment, Dimetcote 302 will cure and cause clogging.

Shipping Data

Packaging
resin 8 1/2.1 gal (17.73 kg) in 10 l can
cure 2 1/0.53 gal (1.75 kg) in 2½ l can

Shipping weight
resin approx. 19 kg
cure approx. 2½ kg

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

Dimetcote 302



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 the 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 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 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.

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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.