



Steelguard 3124

Two pack epoxy zinc phosphate primer

Product Data/ Application Instructions

- **Tough and durable**
- **Excellent abrasion and impact resistance**
- **Excellent adhesion to blast cleaned steel**
- **Suitable as a primer for galvanised steel**
- **Quick and easy to apply**
- **Corrosion inhibiting**
- **EPA compliant (1998) as a blast primer**

Typical Uses

Anti-corrosive primer for:
- general structural steelwork
- civil construction

Physical Data

Appearance when dry	low sheen		
Colour	red oxide, dark grey, buff, off white		
Components	2		
Mixing ratio by volume			
Resin	5.58 parts		
Cure	1 part		
Volume solids	58±2%		
VOC	385 g/l		
Curing mechanism	solvent release and chemical reaction between components Effective down to 10°C/50°F		
	typical	minimum	maximum
Dry film thickness (µm)	75	50	125
Wet film thickness (µm)	129	86	215
(wet film thicknesses quoted are theoretical for one airless spray coat)			
Theoretical coverage	7.7 m ² /l (at typical dft)		
Specific gravity	1.9 kg/l (mixed product)		
Flashpoint			
(closed cup)	°C	°F	
Resin.....	25	77	
Cure	28	82	
Amercoat 12	24	75	

Steelguard 3124

Surface Preparation

STEEL - Abrasive blast clean to ISO 8501-1, Sa 2½. The blast profile achieved should be within the range 50 to 100 microns, but not exceeding 100 microns. Coating should occur before degradation of the surface takes place. If oxidation occurs then the steel should be re-prepared.

GALVANISED STEEL – Thoroughly degrease the surface using Amercoat 88 or similar degreasing material. Treat the surface with Amercoat 59TW or equivalent zinc treatment, or lightly blast with fine abrasive.

NOTE - The surface must be dry and free of dust, salts, grease and other contaminants immediately before coating.

Overcoating

Can be overcoated with suitable Steelguard build coats and finishes or other suitable coatings from the Ameron Coatings range.

Application Data

Substrate steel

Application Methods

AIRLESS SPRAY - Tip size 15-17 thou' (0.38-0.43mm). Pressure at tip: 2800 psi (200 kg/square centimetre).

BRUSH - small areas only.

Environmental Conditions

Relative humidity: up to 90%

Surface temperature: minimum 10°C/50°F

..... maximum 30°C/86°F

The surface temperature must also be at least 3°C/5°F above dew point.

Drying Characteristics °C/°F

Temperature	10/50	20/68	30/86
Touch dry	2 hours	1 hour	30 minutes
Hard dry	8 hours	4 hours	2 hours
Full cure	10 days	5 days	3 days
Overcoating (minimum)	8 hours	4 hours	2 hours
Overcoating (maximum)	No maximum overcoating time with other suitable Steelguard products		

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 normally not necessary

Cleaner Amercoat 12

Steelguard 3124

Application Procedure:

1. Flush equipment with recommended 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. 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. Thinning is normally not required for airless spray.
5. Stir during use to maintain uniformity of material. Apply a wet even coat in 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 129 µm wet film thickness will normally provide 75 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.
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 recommended cleaner immediately after use or at least at the end of each working day or shift. When left in spray equipment, the product will cure and cause clogging.

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

Shipping Data

Pack size	5 and 20 litres in two part units
Shipping weight	
Resin	approx. 36 kg (20 l unit)
Cure	approx. 4 kg (20 l unit)
Resin	approx. 10 kg (5 l unit)
Cure	approx. 1 kg (5 l unit)
Shelf life	1 year when stored indoors in unopened, original containers at 5 to 35°C (41 to 95°F).

Steelguard 3124

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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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.