AMERCOAT®

Protective Coatings

Amercoat 132
Zinc Epoxy Primer

Product Data/ Application Instructions

- **High build anticorrosive zinc epoxy primer**
- **Forms durable coating systems with a wide range of topcoats**
- **Excellent compatibility with old existing coatings**
- **Easily applied by airless or conventional spray and brush**
- **Tough and adherent primer providing excellent resistance to corrosion**

Typical Uses
Amercoat 132 is a fast drying zinc epoxy primer, providing excellent protection against corrosion. Amercoat 132 is a tough and adherent primer, used on abrasive blast cleaned steel. It also provides excellent compatibility with old existing coatings allowing its use as a maintenance primer. Amercoat 132 primer can be applied by airless or conventional spray with automatic or manual spray equipment. For small areas Amercoat 132 can be applied by brush. Amercoat 132 has good compatibility with a variety of topcoats.

Recommended Systems
(With suitable topcoats)
INDUSTRIAL - Structural steel, machinery, pipes and tank exteriors in oil refineries, power plants, chemical process and waste treatment plants and paper mills.
MARINE - Decks of ships, barges and workboats. Piers, offshore platforms and related structures.
TOPCOATING - Suitable topcoats are epoxies and PSX 700. For specific recommendations, contact your PPG representative.

Approvals and Certificates
The Amercoat 132 primer topcoated with PSX 700 is as a two-coat system qualified by **NORSOK** in accordance with *standard M-CR-501, coating system 1*, complies with the requirements of **Shell** *Specification ES/011 Vol 2 Rev 7*, and complies with **ISO** 12944 (class C5M).
Approved primer for fire proofing's (Amercoat 71TC optional as tiecoat).

Physical Data

Finish	flat
Colour	green
Components	2
Mixing ratio (by volume)	
resin	4 parts
cure	1 part
Curing mechanism	solvent release and reaction between components
Volume solids	51% (ASTM D2697, modified)*
VOC (EC SED 1999/13/EC)	224g/kg (479 gr/l)
Dry film thickness	75 µm per coat
Number of coats	1
Calculated coverage	6.7 m^2/l at 75 µm

Allow for application losses, surface irregularities, etc.

Specific gravity	2.13 kg/l (mixed product)

Flash points

(Closed Cup)	°C	°F
resin	27	81
cure	27	81
Amercoat 9HF	26	79
Amercoat 12	24	77

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

Amercoat 132

Application Data Summary
Like all high-performance coatings, Amercoat 132 must be applied as recommended to obtain the maximum protection for which this coating is formulated. To obtain the maximum performance for which Amercoat 132 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 PPG representative.

Surface Preparation
STEEL - New steel without pits or depressions, blast in accordance with Sa 2½ ISO 8501-1. Previously painted or pitted steel, blast in accordance with Sa 2½. For mild exposures, power tool cleaning in accordance with St 3 is acceptable. NOTE: blast to achieve a 25 to 50 µm profile as determined with Testex Press-O-Film tape or similar instrument. Remove abrasive residues and dust from surface. IMPORTANT - Apply Amercoat 132 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 methods	airless or conventional spray
Potlife (at 20°C/68ºF)	8 hours

Potlife is dependent on temperature and quantities mixed.

Induction time (at 20°C/68ºF)	15 minutes

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

For satisfactory cure, air and surface temperatures must be above 10°C/50ºF.
WEATHER CONDITIONS - 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 elimination of solvents.

Drying and Curing Times
(at 75 µm dft and 20°C/68°F)

dry to handle	4 hours
dry to topcoat	4 hours

NOTE: drying and curing 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.

Thinner	Amercoat 9HF
Cleaner	Amercoat 12

Amercoat 132

Application Procedure

Amercoat 132 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 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 vol.% of Amercoat 9HF thinner.
5. Stir during application to maintain uniformity of material. Apply a wet coat 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 150 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 Amercoat 12 Cleaner immediately after use or at least at the end of each working day or shift. When left in spray equipment, Amercoat 132 will cure and cause clogging.

Shipping Data

Packaging	
resin	8 l in 10 l can
cure	2 l in 2½ l can
Shipping weight	
resin	approx. 21 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 to 104°F).

Amercoat 132

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 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
PPG warrants its products to be free from defects in material and workmanship. PPG's sole obligations and Buyer's exclusive remedy in connection with the products shall be limited, at PPG'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 PPG 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 PPG of such non-conformance as required herein shall bar Buyer from recovery under this warranty.

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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.