AMERCOAT®

Protective Coatings

Amercoat 515
High-Build Chlorimated Rubber

Product Data/ Application instructions

- **A high-build intermediate coat over suitably primed surfaces**
- **Can also be used as topcoat**
- **High-build property reduces number of coats**
- **Durable in marine and industrial environments**
- **Air drying - no baking or oxidation required**
- **Easy repair and touch up**

Typical Uses
As a high-build coating for use on ship hulls, decks and superstructures, water treatment plants, structural steel tanks and piping in chemical plants, refineries, pulp and paper mills, offshore platforms and other structures exposed to weathering or salt spray.

Chemical Resistance Guide
(when applied over suitable primer)

Environment	Splash and spillage	Fumes and weathering
Acidic	Good	Very Good
Alkaline	Fair	Good
Solvents	Poor	Poor
Salt solutions		
Acidic	Good	Very Good
Neutral	Excellent	Excellent
Alkaline	Good	Very Good
Water	Excellent	Excellent

This chart is only a guide to show typical resistances of Amercoat 515. Your Ameron representative will help you evaluate your particular corrosion protection needs and make the correct recommendation for your specific requirements.

Typical Systems

Primer	Intermediate Coat
Steel: Inorganic primers Dimetcote 6, 9, and 11 **	Amercoat 515
Organic Primers: Amercoat 68 series	Amercoat 515

* Topcoat required where glossy finish and improved colour retention is desired.

** Prehydrolised zinc silicates must receive a water wash, or have been exposed to occasional rain or condensation before overcoating.

Consult your PPG representative for specific recommendation for ship hull systems.

Physical Data

Finish	low sheen
Colour	light grey (RAL 7035)
Substrate	suitably primed steel
Components	1
Curing mechanism	solvent release
Dry film thickness	125 µm per coat
Number of coats	1
Volume solids	46% (ASTM D2697 modified) *
VOC	39% by weight / 493 g/l
Calculated coverage	3.7 m²/l at 125 µm

Allow for application losses, surface irregularities, etc.

Application methods	airless or conventional spray or roller
Potlife	not applicable

Drying times at 20°C and 125 µm dft

dry to touch	2 hours
dry to recoat	4 hours
dry before service	24 hours

Mixing ratio	not applicable
Thinner	Amercoat 65 **
Cleaner	Amercoat 12

Flash points (Closed Cup)

Amercoat 515	24°C
Amercoat 65	24°C
Amercoat 101	61°C

Packaging	16 l in a 20 l can
Shipping weight	approx. 33.6 kg
Shelf life	1 year from shipment date when stored indoors in unopened, original containers at 5 to 40°C.

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

** For application in hot climate areas use Amercoat 515 with Amercoat 101

Amercoat 515

Application Data Summary
Amercoat 515 is a high-build chlorinated rubber coat. Refer to Amercoat 515 product data for properties and use. To obtain the maximum performance for which Amercoat 515 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
Proper surface preparation and application of underlying coats are essential. Refer to the product data sheet and application instructions for the particular primer or to be topcoated for any special requirements. All surfaces must be free of moisture, oil, grease, dust and other foreign matter. Be sure primer is clean and dry when Amercoat 515 is applied.

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 fluid tip with a 0.38 to 0.54 mm (0.015 to 0.021 inch) orifice.

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

Environmental Conditions
(during application)
Air temperature 0 to 50°C.
Surface temperature 0 to 50°C.
Surface must be dry. At freezing temperatures, surface must be free from ice. To prevent moisture condensation during application, surface temperature must be at least 3°C above dew point.
NOTE: For application in hot climate areas use Amercoat 515 with Amercoat 101.

Drying Times
(at 20°C at 125 µm dft)

dry to touch	2 hours
dry to recoat	4 hours
dry before service	24 hours

Amercoat 515

Application Procedure
Amercoat 515 is a one component material and is packaged in a 20 l can.
Thinner/cleaner Amercoat 101

1. Flush equipment with recommended cleaner before use.

2. Stir all material thoroughly before applying.

3. For spray application, thin only as needed for workability with no more than 10 vol % of recommended thinner. For airless spray normally no thinning is required. NOTE: For rolling, normally no thinning is required.

4. Spray on heavy wet coat, making parallel passes and overlapping each pass 50%. Follow with a "cross-spray" pass at right angles to first pass. Give special attention to angles, corners, rough spots, edges, etc. to avoid bare areas, pinholes or holidays.

5. Double coat all welds, rough spots, sharp edges and corners, rivets, bolts, etc.

6. Application at 270 µm wet film thickness will normally provide 125 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 repaired by simply applying additional material.

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.

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
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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Due to PPG'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 PPG Protective & Marine Coatings website at www.ppgpmc.com

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.