



Amercoat 3323

Epoxy primer

Product Data/ Application Instructions

- Primer for durable systems wide range of top coats including Polyurethanes and Acrylics
- Rust inhibitive Epoxy primer
- Easy application
- No leads pigments added to 3323
- VOC compliant
- Wide film build range

Typical Uses

- Industrial structural steel, machinery and piping.
- Tank exteriors in oil refineries, paper mills, chemical Facilities and waste water treatment plants.
- Decks, hulls and superstructures of ships, barges and work boats.
- Piers, offshore platform and related structures.

Physical Data

Finish	flat
Colour	Oxide Red
Components	2
Mixing ratio (by volume)	
resin	1 part
cure	1 part
Curing mechanism	solvent release and chemical reaction between components
Volume solids	65% *
VOC	2.5lb/gal (300 g/l)
Dry film thickness	100- 150 µm
Number of coats	1 or 2
Theoretical coverage.....	ft ² /gal m ² / ltr
at 1 mil (25 microns)	1040 25.5
Allow for application losses, surface irregularities, etc.	
Flash point (SETA)	°F °C
resin	128 53
cure	80 27

* Volume solid 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

Coating performance is proportional to the degree of surface preparation. Refer to specifications for the specific primer to be used. Prior to coating, primed surface must be clean, dry, undamaged and free of all contaminants including salt deposits. Round off all rough welds and remove all weld spatters

Steel –Remove all loose rust, dirt, grease or other contaminants by one of the following depending on the degree of cleanliness required.

For more severe service and immersion. Clean to SSPC-SPI0. The choice of surface preparation will depend on the system selected and end-use service conditions.

Blast to achieve a surface profile not to be exceed 3 mil (75 microns), as indicated by a keane-Tator surface profile Comparator testex tape. Increase coating thickness if profile greater than 3 mils

Aged coatings: All surfaces must be clean, dry, tightly bonded and free of all loose paint, corrosion products or chalky residue. Clean by pressure water blast (1000 psi or greater) SSPC-SP1, 2.3 or 7.

Amercoat 3323 is compatible over most types of properly applied and tightly adhering coatings. However, a test patch is recommended to confirm compatibility.

Repair: Prepare damaged areas to original surface preparation specifications feathering edges of intact coating. Thoroughly remove dust or abrasive residue before touch up.

Application Equipment

Use of following equipment is suggested, but suitable equipment from other manufacturers may be used.

Adjustments of pressures and change of tip size may be needed to obtain the proper spray characteristics.

AIRLESS SPRAY - Standard airless spray equipment, such as Graco Bull dog Hydra-Spray or larger with a 0.15 to 0.021 inch (0.38 to 0.63 mm.) fluid tip.

CONVENTIONAL SPRAY - Industrial equipment such as DeVilbiss MBC or JGA gun with 78 or 765 air cap and "E" fluid tip, or Binks No. 18 or 62 gun 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.

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

Application Data Summary

To obtain the maximum performance for which Amercoat 3323 is formulated, strict adherence to all application instructions, precautions, conditions and limitations is necessary.

Application Data

Substrate Steel
Application methods airless or conventional spray
Pot life (at 21°C/70°F) 4 hours

Pot life is dependent on temperature and quantities mixed.

Environmental Conditions
(during application)
Air temperature: 4 to 49°C 40 to 120°F
Surface temperature: 4 to 49°C 40 to 120°F

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

Never apply coatings under adverse environmental conditions. Ensure good ventilation when applied in confined areas to assist evaporation and elimination of solvents.

Drying Time 21°C/70°F
dry to touch..... 4 hours
dry though 24 hours

Dry to recoat
Minimum..... 16 hours
Maximum..... 14 days

Drying times are dependent on film thickness, temperature and ventilation

Thinner Amercoat 65

Amercoat 3323

Application Procedure

Amercoat 3323 consists of two components which must be mixed together before use.

1. Flush equipment with Amercoat 65 before use.
2. Stir resin and cure separately to an even consistency with a power mixer, than combine and mix until uniform.
3. Thin only (if necessary) for workability, add Amercoat 65 up to pint (approximately 6%) per gallon of Amercoat 3323. Use Amercoat 65 when faster drying is required. Use only PPG recommended thinners.
4. Do not mix more materials than will be used within pot life. Pot life is shortened by higher temperatures.
5. Amercoat 861 accelerator may be used for application when low Temperatures are expected or to achieve faster time to service at below 50 °F, When 861 is used with white or light colours of Amercoat 3323, a colour variation may result. Do not use more than 1 pint Amercoat 861 per 5-gallon unit.
6. For conventional spray, use adequate air pressure and volume to ensure proper atomization. Apply a wet coat in even, parallel passes; overlap each pass 50 percent. If required, cross-spray at right angles to avoid holidays, bare areas and pinholes.

Note: When applying directly over inorganic zincs or zinc-rich primers, a mist coat may be required to minimize bubbling. This will depend on the age of the Dimetcote, surface roughness and conditions during curing.
7. Normal recommended dry film thickness per coat is 4 to 6 mils for Amercoat 3323. However if, greater thickness is applied in local areas because of overlapping no runs or sags will normally occur at a dry film thickness up to 10 mils for Amercoat 3323.
8. A wet film thickness of 6 mils (150 microns) normally provides 4 mils (100 microns) of dry film.
9. When using brush or roller application method, additional coats may be required to achieve proper film thickness.
10. Clean all equipment with Amercoat 65 immediately after use.

Shipping Data

Packaging unit.....	0.5 gal	2 gal
resin	0.23 gal	1 gain
cure	0.23 gal	1 gain

Shipping weight (approx)		
resin	3.33 kg	1.50 kg
cure	3.10 kg	1.40 kg

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

This mixed product is photo chemically reactive as defined by the South Coast Air Quality Management District's Rule 102 or equivalent regulators.

Amercoat 3323

Caution

This product is flammable. 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, 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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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.

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