



Amercoat 178

Wash Primer

Product Data/ Application Instructions

- Chemically reactive polyvinyl butyral wash primer
- Pre-treatment primer on clean steel and other metal surfaces to increase adhesion of coating systems.
- Conforms to Navy Formula 117, MIL-P-15328B and SSPC-PT-64

Amercoat 178 is a 2 component chemically reactive wash primer pre-treatment system, intended for application on abrasive blasted steel surfaces (free of rust and scale), or other metal surfaces (clean galvanized metal), where subsequent compatible primer and topcoats are to be applied. It is used to increase the adhesion of the coating system. Almost all paints will adhere to this primer except certain types of vinyls or lacquers; these may require an intermediate or bonding coat.

Amercoat 178 primer is made in accordance with Navy MIL-P-15328B and SSPC-PT-64

Notes

1. Amercoat 178 primer is not intended as a permanent primer. To insure best results, Amercoat 178 should be coated with permanent primers or topcoats as soon as possible.
2. Amercoat 178 shall be applied on a dry film thickness of 8-13 microns and not more than 15 microns

Application Data Summary

For complete information on procedures, equipment and all safety pre-cautions, see the application instructions accompanying shipment. Like all high performance coatings, Amercoat 178 primer must be applied as recommended to obtain the maximum performance.

Physical Data

Finish.....	flat
Colour	Green-Yellow
Surface.....	Clean metal surfaces
Components.....	2
Curing mechanism.....	solvent release and chemical reaction between components
Volume solids	9.6% (ASTM D2697 modified)
Dry film thickness	8 - 13 µm (0.3-0.5 mils)
Number of coats.....	1
Calculated coverage at 10 µm	9.6 m ² /l (391 sq ft/ gal)
Allow for application losses, surface irregularities, etc.	
Application.....	Airless, Conventional spray or brush
Pot life	8 hrs at 21°C (70°F)
Drying time to recoat.....	30 minutes at 21°C (70°F)
Pot life, drying and curing times are dependent on temperature.	
Dry temperature resistance continuous	65°C (150°F)
Mixing ratio (by volume)	Resin.....4 parts Cure.....1 part
Thinner	Amercoat 9HF
Cleaner	Amercoat 12
Specific gravity (mixed)	0.90 kg/l
Flash points (Closed Cup) °C	°F
Curing solution	11 52
Resin solution.....	11 53
Amercoat 9HF.....	3 38
Amercoat 12.....	21 38

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Amercoat 178 is a two component polyvinyl butural wash primer for use on clean metal surfaces as a treatment prior to the application of organic protective coatings.

To obtain the maximum performance for which Amercoat 178 is formulated, strict adherence to all application instructions, pre cautions, conditions and limitations is necessary. If conditions exist that are not within the requirements or limitations described, consult your OAL representative.

Surface Preparation

STEEL - Blast in accordance with SA 2.5 Swedish Standard SIS 05 5900 - 1967, ISO 8501-1 or SSPC-SP-10.

OTHER METAL SURFACES- Like new galvanized surfaces or zinc- remove any oil, grease or soap film with Amercoat 57 oil cleaner. For optimum adhesion and results, roughen by light sweep blasting.

WEATHERED GALVANIZED SURFACES- Remove oil or grease with neutral detergent or emulsion cleaner (like Amercoat 57 oil cleaner) If galvanizing has been exposed to exterior weathering for 6 Months or more, remove zinc corrosion by light sweep blasting or mechanical means (like power sander).

IMPORTANT- Apply Amercoat 178 as soon as possible after surface preparation to prevent any contamination. Do not leave blasted steel uncoated overnight. In case of contamination, remove all contaminants. Spot blast steel if needed. Amercoat 178 will provide only temporary protection and should be top coated as soon as possible.

Application Equipment

The following has been listed as a guide and suitable equipment from other manufacturers may be used. Adjustments of pressures and changes 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 0.28 to 0.33 mm (0.011 to 0.033 inch) orifice.

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 agitators and a moisture and oil trap in the main air supply are recommended.

MIXER- Use power mixer (must be powered by an air motor or an explosion proof electric motor).

Environmental Conditions during application:

Air temperature.....	0 to 50°C	32 - 120°F
Surface temperature ...	0 to 55°C	32 - 130°F

WEATHER CONDITIONS- To prevent moisture condensation during application, surface temperature must be at least 3°C (5°F) above dew point.

Drying and Top coating times at 21°C (70°F)
dry to handle 15-30 minutes.
dry to recoat 30 minutes.

Caution

Amercoat 178 curing solution is acidic. Contact with eyes, skin or clothing should be avoided. In event it is splashed in eyes or skin, check product safety data sheet.

Application Procedure

1. Flush equipment with Amercoat 12.
2. Stir pigmented resin solution (in larger container) to an even consistency with a power mixer.
3. Add curing solution to resin solution and continue stirring for 5 minutes. Note: since the pot life is limited and shortened by high temperatures, do not mix more material that will be used in 8 hours at 21°C (70°F).
4. For conventional spray, thin within only needed for workability with no more than 10% Amercoat 9HF
5. Apply a wet coat by 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 105 microns (4 mils) wet film thickness will normally provide 10 microns (0.4 mils) dry film thickness.
8. Small damaged or bare areas and random pinholes or holidays can be touched up by brush. Repair larger areas by spray.

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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. When left in spray equipment, Amercoat 178 will cure and cause clogging.

Shipping Data

Packaging:

Resin solution 20 ltr in 25 ltr can.
Curing solution 5 ltr in 5 ltr can.

Shipping weight (approximate)

Resin..... 19.9 kg.
Curing 5.1 kg.

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

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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

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

OAL 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 OAL be liable for consequential or incidental damages.

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Due to OAL'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 OAL.

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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