



Amercoat 182ZP HB

Polyamide Cured Zinc Phosphate Epoxy Primer

Product Data/ Application Instructions

- A high build anti-corrosive primer
- Forms durable coating systems with wide range of topcoats
- Excellent shopprimer in corrosive environments
- Tiecoat over Dimetcote with suitable Amercoat topcoats

Typical Uses

(with suitable topcoats)

INDUSTRIAL - Structural steel, machinery, pipes and tank exteriors in paper mills, oil refineries, power plants, desalination plants, chemical process and waste treatment plants.

MARINE - Decks, topsides and superstructures of ships, barges and workboats. Piers, offshore platforms and related structures. Interiors of dry cargo holds.

Recommended Systems

With the proper topcoats, withstands splash or spillage of water, solvents, chemicals and petroleum products. Suitable topcoats are a.o. Amercoat epoxies, coaltar epoxies, PSX 700, acrylics, alkyds and polyurethanes. Amercoat 182ZP HB may be used as a primer at 100 µm dry film thickness for up to 6 months without a topcoat.

Approvals and Certificats

Complies with requirements for lead- and chromate-free epoxy primers (COT 16.76).
Approved primer for miscellaneous fire proofings.

Repair

Spot blast or power tool clean bare substrate to the requirements shown under surface preparation. Feather edges of intact coating. Remove dust, dirt and contamination before recoating.

Physical Data

Finish.....	flat
Colour.....	oxide red, beige
Components	2
Mixing ratio (by volume)	
resin	4 parts
cure	1 part
Curing mechanism	solvent release and chemical reaction between components
Volume solids	55% (ASTM-D2697, modified)*
VOC**	
EC SED 1999/13/EC	354 g/kg (471 g/l)
UK PG6/23(92) Appendix 3	424 g/l
Dry film thickness	100 µm per coat
Number of coats	1
Calculated coverage.....	5.5m ² /l at 100 µm
Allow for application losses, surface irregularities, etc.	
Specific gravity.	1.33 kg/l (mixed product)
Flash points (Closed Cup) .	°C °F
resin	26 79
cure	25 77
Thinner 91-83	26 79
Thinner 90-58	24 75

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

** VOC figures are quoted according to both the EC directive 1999/13/EC which are theoretically calculated figures and the UK PG6/23(92) Appendix 3 which are practically determined figures.

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Surface Preparation

STEEL - Blast in accordance with Swedish Standard Sa 2½ SIS 05 5900 - 1967, ISO 8501-1 or Steel Structures Painting Council SP-10. NOTE: blast to achieve a 25 to 65µm profile as determined *Testex* Tape or similar instrument. Remove abrasive residues and dust from surface.

NEWLY GALVANISED SURFACES - Remove any oil or soap film with Neutral oil cleaner, treat surface by a lightly blast with fine abrasive.

ALUMINUM SURFACES - Remove oil and grease with Neutral oil cleaner. Lightly blast with fine abrasive or apply chromate-type conversion treatment, such as Alodine 1200, by Henkel..

IMPORTANT - Apply Amercoat 182ZP HB 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.

DIMETCOTE - Surface must be free of any foreign matter. Remove any contamination. Refer to application instructions for the particular Dimetecote for any other special topcoating requirements.

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 0.38 to 0.53 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 and a mechanical pot agitator are recommended. A moisture and oil trap in the main air supply line is essential.

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

Application Data Summary

Like all high performance coatings, Amercoat 182ZP HB must be applied as recommended to obtain the maximum protection for which this coating is formulated. To obtain the maximum performance for which Amercoat 182ZP HB 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 OAL representative.

Application Data

Substrateprepared steel

Application methods.....airless or conventional spray

Environmental Conditions

(during application and drying)

Air temperature: 5 to 50°C 41 to 122°F

Surface temperature: 5 to 50°C 41 to 122°F

To prevent moisture condensation during application, surface temperature must be at least 3°C/5°F above dew point. Never apply coatings under adverse environmental conditions. Ensure good ventilation when applied in confined areas to assist evaporation and elimination of solvents. Minimum temperature for satisfactory cure is 10°C.

Drying Times

(in hours)	°C/°F	10/50	20/68	30/86
dry to touch.....		6	3	2
dry to handle.....		8	4	2

NOTE: drying 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. To topcoat Amercoat 182ZP HB must be in good condition, free of corrosion products or contaminants. Maximum topcoating intervals are dependent on temperature, degree of weathering, type of topcoat and service conditions of the complete coating system. Consult your OAL representative for specific recommendations.

Recoating Times

(in hours)	°C/°F	10/50	20/68	30/86
minimum		8	4	2
maximum			unlimited	

Induction time (at 20°C/68°F) not applicable

Potlife (at 20°C/68°F)8 hours

Potlife is dependent on temperature and quantities mixed.

ThinnerThinner 91-83

CleanerThinner 90-58

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Application Procedure

Amercoat 182ZP HB is packaged in the proper mixing proportions of resin and cure.

Resin 16 l in 20 l can

Cure 4 l in 5 l can

1. Flush equipment with recommended cleaner.
2. Stir pigmented resin solution (in the 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 potlife is limited and shortened by high temperatures, do not mix more material than will be used in 8 hours at 20°C.
4. For conventional spray, thin only as needed for workability with no more than approximately 10 vol % of recommended thinner. Thinning is normally not needed for airless spray.
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 170 µm wet film thickness will normally provide 100 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, Amercoat 182ZP HB will cure and cause clogging.

Shipping Data

Packaging

resin 16 l in 20 l can

cure 4 l in 5 l can

Shipping weight

resin approx. 27 kg

cure approx. 5 kg

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

Amercoat182ZPHB

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.

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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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