



Amercoat 383H

High-build epoxy intermediate coating

Product Data/ Application Instructions

- High build epoxy intermediate coating
- Reduced volatile organic compounds (VOC)
- High-build and High-solids
- Tough and durable
- Also available with 40% MIO pigmentation

Typical uses

Amercoat 383H Polyamide epoxy coating is used as an intermediate coating for atmospheric exposure in marine and industrial environments. Amercoat 383H is normally applied over an inorganic zinc-silicate or epoxy primer

Typical Global Systems using Amercoat 383H

ISO 12944 classification	First coat	Intermediate	Finish Coat
C5	Dimetecote	Amercoat 383H	Amercoat 450 Series
C5	Amercoat 68 Series	Amercoat 383H	Amercoat 450 Series
C4	Amercoat 385PA	Amercoat 383H	Amercoat 450 Series

Amercoat 383H is not recommended for direct to metal applications for use at continuous immersion conditions and is normally top coated for optimal performance

Approvals and Certificates

Amercoat 383H has been successfully tested to/ and meets the requirements of Norsok M501-rev.5 system1 as an intermediate coating in conjunction with Amercoat 68 Series primer and Amercoat 450 series topcoats. Consult your OAL representative for full system details.

Physical Data

Finish.....	semi-gloss	
Colour.....	Off White, Light Grey, MIO Pearl Grey, GR-3	
Components	2	
Mixing ratio (by volume)	1 part Resin 1 part Cure	
Curing mechanism	solvent release and chemical reaction between components	
Volume solids.....	77% (ISO 3233)*	
VOC**		
EC SED 1999/13/EC	148 g/kg (225 g/l)	
UK PG6/23(92) Appendix 3 ..	180 g/l (1.5 lbs/gal)	
Dry film thickness.....	50 – 200 µm per coat	
Number of coats.....	1	
Theoretical coverage		
At 100 microns/4 mil dft	7.7 m ² /l	314 ft ² /gal
At 200 microns/6 mil dft	3.80 m ² /l	157 ft ² /gal
Flashpoints.....	°C	°F
Cure	47	117
Resin.....	47	117
Mixed	47	117
Amercoat 65	24	75
Amercoat 12	21	75
Thinners	AM 65 (21-06)	
Cleaner.....	Amercoat 12	

* Volume solids is measured in accordance with ISO 3233. 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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Chemical Resistance Guide

When applied over suitable primer or intermediate coat and topcoated with Amercoat 450 Series:

Splash and Environment	Fumes and Spillage	Weather
Acidic	Very good	Excellent
Alkaline	Very good	Excellent
Salt solutions		
Acidic	Excellent	Excellent
Neutral	Excellent	Excellent
Alkaline	Excellent	Excellent
Water	Excellent	Excellent

This table is only a guide. For specific recommendations, contact your OAL representative for your particular corrosion protection needs.

Surface Preparation

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

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, having a 0.019 to 0.027 inch (0.38 to 0.53 mm) fluid tip.

CONVENTIONAL SPRAY

Industrial equipment with 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 Suitably primed steel coated with Amercoat 385PA, Dimetecote 9, Amercoat 68 Series

Application method Airless or conventional spray.

Environmental conditions

Air temperature 5-50 °C 41-122 °F
Surface temperature 5-60 °C 41-140 °F

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

Potlife (°C/°F) 32/90 21/70 10/50
 1 hrs 2hrs 4 hrs

Drying times (°C/°F) 32/90 21/70 10/50
Dry to touch..... 3 hrs 6 hrs 10 hrs
Dry through..... 10 hrs 16 hrs 24 hrs

Recoat or topcoat times (°C/°F) 32/90 21/70 10/50
Minimum 10 hrs 16 hrs 24 hrs
Maximum with epoxies and
with Amercoat 450 Series.... 30 days

Maximum recoating/topcoating time 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.

Drying times are dependent on temperature, ventilation and film thickness.

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Application Procedure

Amercoat 383H is packaged in the proper mixing proportions of resin and cure.

Resin 10 L (2.6 gal) in 20 L can
Cure 10 L (2.6 gal) in 10L can
Thinner: Amercoat 65
Cleaner: Amercoat 12

1. Flush equipment with recommended cleaner before use.
2. Mix, resin (in the larger container) to an even consistency with a power mixer.
3. Add cure to resin and stir to an even consistency.
NOTE: Since the potlife is limited and shortened by high temperatures, do not mix more material than will be used within the potlife period.
4. If thinning is necessary for workability do not add more than 10% of recommended thinner.
5. Mix during application to maintain uniformity of material. Apply a wet even coat in 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 125 µm dry.
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, the product will cure and cause clogging.

Shipping Data

Packaging

Resin 10 L (2.6 gal) in 20 L can
Cure 10 L (2.6 gal) in 10 L can

Shipping weight

	kg	lb
Resin	approx. 18	40
Cure	approx. 16	36

Shelf life

Resin and cure..... 1 year from shipment date
when stored indoors in
unopened, original
containers at 5 to 40°C (41
to 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 the 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

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.

Any recommendations or suggestion relating to the use of the products made by OAL, whether in its technical literature, or response to specific enquiry, or otherwise, is based on data believed to be reliable; however, the products and information are intended for use by Buyer's having requisite skill and know-how in the industry, and therefore it is Buyer to satisfy itself of the suitability of the products for its own particular use and it shall be deemed that Buyer has done so, as its sole discretion and risk. Variation in environment, changes in procedures of use, or extrapolation of data may cause unsatisfactory results.

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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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