



Amercoat 510

Chlorinated Rubber Primer

Product Data/ Application instructions

- **High-Build chlorinated rubber primer**
- **Suitable for Marine and Industrial use**
- **Dries by solvent evaporation over wide temperature range**
- **Easily applied by airless or conventional spray**

Typical Uses

Amercoat 510 is used as a Primer for chlorinated rubber topcoats in marine and industrial maintenance environments. Recommended chlorinated rubber topcoats is Amercoat 515 high build chlorinated rubber.

Consult your OAL representative for specific recommendations.

Physical Data

Finish.....Flat
 Colour.....Aluminum Gray and Oxide Red
 Substrate Steel or Concrete
 Components 1
 Curing mechanism.....solvent release
 Dry film thickness.....75 µm (3 mills)
 Number of coats.....1
 Volume solids.....38% (ASTM D2697 modified) *
 Calculated coverage 5.1 m²/l at 75 µm
 Allow for application losses, surface irregularities, etc.

Application methodsairless, conventional spray, brush or roller

Potlifenot applicable

Drying times at 21°C and 75 µm dft
 dry to touch.....1 hour
 dry to recoat 3-4 hours
 dry before service 2-4 hours
 Drying time depend on temperature

Mixing rationot applicable

Maximum dry temperature resistance
 Continuous..... 66°C (150°F)
 Intermittent..... 93°C (200°F)
 Thinner..... Amercoat 65 **
 Cleaner Amercoat 12

Flash points (Closed Cup)
 Amercoat 510 24°C (75°F)
 Amercoat 65 24°C (75°F)
 Amercoat 12 61°C (142°F)

Specific gravity:
 Aluminum, Gray.....1.23 kg/ ltr
 Oxide Red.....1.40 kg/ltr

Packaging.....25 l in a 25 l can

Shipping weight
 Aluminum Gray.....32.8 kg
 Oxide Red.....36.9 kg

Shelf life1 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

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Application Data Summary

Amercoat 510 is a chlorinated rubber primer for industrial and marine environments. Refer to Amercoat 510 product data for properties and use. To obtain the maximum performance for which Amercoat 510 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.

Surface Preparation

STEEL- Blast in accordance with Swedish Standard SA2,5, SIS 05 5900 1967 or Steel Structures Painting Council SP 10 .
NOTE: Blast to achieve a 25 to 50 microns profile as determined with a Keane-Tator Surface Comparator or similar instrument. Remove abrasive residues and dust from surface.

IMPORTANT: Apply Amercoat 510 as soon as possible after surface preparation to prevent any contamination. Do not leave blasted steel uncoated Overnight. In case of contamination, remove contaminants. Spotblast steel if needed.

Environmental Conditions

During application
Air temperature 0 to 50 °C (32 to 120°F)
Surface temperature 0 to 50 °C (32 to 120°F)

For temperature below 0°C (32°F), surface must be free of ice. To prevent moisture condensation during application surface temperature must be at least 3°C (5°F) above the dew point. Note: For application in hot climate areas Amercoat 510 should be used in combination with Thinner 65.

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 28:1 or higher pump ration and a fluid tip with a 0.38 to 0.54 mm (0.015 to 0.021 inch) orifice.

ROLLER - Soft & Smooth roller is recommended
BRUSH - For hard-to-reach areas, corner & edges
MIXER - Use power mixer powered by an air motor or an explosion proof electric motor.

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.

ROLLER - Soft & Smooth roller is recommended
BRUSH - For hard to reach areas, corner & edges

**Drying times at 75 microns (3 mills)
and 21°C(70°F)**
dry to touch

½ hour at 35°C(95°F)
1 hour at 21°C(70°F)
3 hours at 10°C(50°F)

Before topcoating

1-2 hours at 35°C(95°F)
2-4 hours at 21°C(70°F)
4-8 hours at 10°C(50°F)

Drying times are dependent upon ventilation, temperature and film thickness. Times are proportionally shorter at higher temperatures and longer at lower temperature.

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Application Procedure

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 198 µm wet film thickness will normally provide 75 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.

Packaging 25 l in a 25 l can

Shipping weight

Aluminum Gray 32.8 kg

Oxide Red 36.9 kg

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

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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 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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