



Amercoat 71SF

Epoxy Holding Primer

Product Data/ Application Instructions

- A superior two-component epoxy holding primer coating for solvent-free and other tanklinings
- Forms durable coating systems with tanklinings and other topcoats for immersion and non-immersion services
- Provides temporary protection of blasted steel during tanklining activities
- Compatible with cathodic protection

Typical Uses

Amercoat 71SF is designed as a holding primer for freshly blasted steel to be subsequently coated with OAL tanklining systems in both Industrial and Marine applications. Amercoat 71SF can be used with a number of OAL materials including Amercoat 90S, Amercoat 352GF, 391PC. It is also suitable for use for non-tanklining service in combination with other OAL products. For specific recommendations consult your OAL representative.

Amercoat 71SF provides temporary protection of freshly blasted steel facilitating the application process of internal tanklining systems. Amercoat 71SF shows broad compatibility with OAL tanklining systems with no reduction in the system performance. It exhibits excellent resistance to cathodic disbonding and a wide overcoating window with compatible topcoats

In combination with Amerlock 400GFA, Amercoat 71SF is prequalified to NORSOK M501 Rev 5 coating system 7, for subsea, tidal and splash zone areas.

Physical Data

Finish	flat
Colour	oxide red
Components	2
Curing mechanism	solvent release and reaction between components
Volume solids :	38% *
VOC**	
EC SED 1999/13/EC.....	438 g/kg (531 g/l)
Dry film thickness	20-40 µm per coat
Number of coats.....	1
Calculated coverage.....	15.2 m ² /l at 25 µm
Allow for application losses, surface irregularities, etc.	
Specific gravity.....	1.21 kg/l (mixed product)
Flash points (Closed Cup).....	°C °F
resin	22 72
cure	30 86
Thinner 91-83	26 79
Thinner 90-58	21 70

* 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 the EC directive 1999/13/EC which are theoretically calculated figures

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Surface Preparation - Primer

STEEL – Welds, sharp edges and other steel imperfections shall be ground smooth as being described in NACE Standard RP0178 or ISO 8501-3 grade P3.

Abrasive blast in accordance with Sa 2½, ISO 8501-1 or Steel Structures Painting Council SP-10. Blast to achieve a 50 to 75 µm profile as determined with *Testex* Tape or similar instrument. The profile should be sharp and angular as provided by grit. Remove abrasive residues and dust from surface.

IMPORTANT - Apply primer 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.

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 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 704 or 765 air cap and "E" fluid tip. Separate air and fluid pressure regulators, mechanical pot agitator and a moisture and oil trap in the main air supply line are recommended.

BRUSH/ROLLER – suitable for small areas only such as touch-up and repairs

Application Data

Substrateblasted steel,

Application methodsairless or conventional spray, brush or roller

Environmental Conditions (during application) relative humidity

Air temperature 5 to 50°C 41 – 122°F <80%

Surface temperature 5 to 60°C 41 – 140°F <80%

To prevent moisture condensation during application, surface temperature must be at least 3°C/5°F above the dew point. Minimum temperature for satisfactory cure is 10°C/50°F. Never apply coatings under adverse environmental conditions. Ensure good ventilation when applied in confined areas to assist evaporation and elimination of solvents.

Potlife in hours (°C/°F) 32/90 21/70 10/50
2 4 8

Potlife and drying time are dependent on temperature and quantities mixed.

Drying Times (°C/°F)32/90 21/70 10/50

dry to touch30 mins 45 mins 90mins dry to handle

(dry to through)..... 2 hours 3 hours 6 hours

overcoating.....

minimum16 hrs 16 hours 24 hours

maximum.....3 months 3 months 3 months

Drying and curing 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. The minimum and maximum overcoating times are relevant for overcoating with approved tanklining systems. Before overcoating the Amercoat 71SF must be clean, dry and free of contaminants such as grit, dirt, debris, grease, oil, salts, etc. Any areas that are showing corrosion must be spot-blasted before overcoating. The maximum overcoating time is not an indication of how long Amercoat 71SF is able to hold a blast. This time is dependent upon a number of variable factors. As a guidance Amercoat 71SF will hold a blast for up to 28 days in the typical environment of a semi-enclosed tank interior

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Application Procedure

Amercoat 71SF 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 resin (in the larger container) to an even consistency with a power mixer.
3. Add cure to resin 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 4 hours at 21°C (70°F)
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. Stripe coat all welds, rough spots, pitted areas, sharp edges and corners, rivets, bolts, etc.
7. Application at 66 µm wet film thickness will normally provide 25 µm dry film. The product should not be overapplied with dft being maintained below 40 microns for solvent-free tanklining systems.
8. Check thickness of dry coating with a non destructive dry film thickness gauge, such as a Mikrotest or Elcometer. If less than specified thickness, apply additional materials as needed.
9. Small damages 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 71SF 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. 22 kg

cure approx. 4.6 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.

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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OAL's liability on any claim of any kind, including claims based upon OAL's negligence or strict liability, for any loss or damage arising out of, connected with, or resulting from the use of the products, shall in no case exceed the purchase price allocable to the products or part thereof which give rise to the claim.

In no event shall OAL be liable for consequential or incidental damages.

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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