



Amercoat 891

Silicone Acrylic

Product Data/ Application Instructions

- High temperature resistant silicone acrylic
- Resistant to temperatures up to 204°C/399°F
- Can be applied on steel and Dimetcote primers
- Excellent colour retention in weathering exposure

Typical Uses

Exteriors of steel structures exposed to high temperatures in chemical plants, marine structures, ships, power plants, oil production and refining plants.

Outstanding Characteristics

Amercoat 891 is a high performance, high temperature resistant coating. Amercoat 891 can be used as a self priming coating system over abrasive blast cleaned steel. Amercoat 891 may also be applied over most Dimetcote primers.

Physical Data

Finish	semi-gloss
Colour	RAL 9006 (aluminium) light grey (SC 707) and white *
Components	1
Cure	evaporation of solvents
Volume solids	36.7% (aluminium 32.6%) (ASTM D2697 modified)**
VOC***	
EC SED 1999/13/EC	511 g/kg (620 g/l)
UK PG6/23(92) Appendix 3	620 g/l
Dry film thickness	25 µm per coat ****
Number of coats.....	on steel: 2 on Dimetcote: 2
Calculated coverage	14.8 m ² /l at 25 µm (aluminium 13 m ² /l)
Allow for application losses, surface irregularities, etc.	
Specific gravity	1.21 kg/l
Temperature resistance	up to 204°C/399°F dry heat when applied over steel or Dimetcote
Flash points (Closed Cup). °C °F	
Amercoat 891	43 109
Thinner 21-06	24 75

* Uniform appearance may require two coats of Amercoat 891 in a light colour on tanks and other large structures over contrasting primers or intermediate coats.

** 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.

**** Application at higher thicknesses may result in cracking and insufficient adhesion.

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Surface Preparation

STEEL - blast in accordance with Sa 2½ Swedish Standard SIS 05-5900 1967, ISO 8501-1 or Steel Structures Painting Council SP-10.

NOTE: Blast to achieve a 25 to 40 µm profile as determined with *Testex* Tape or similar instrument. Remove abrasive residues and dust from surface.

IMPORTANT - Apply Amercoat 891 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 requirement.

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 fluid tip with 0.33 to 0.42 mm (0.013 to 0.017 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 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 Summary

Like all high-performance coatings, Amercoat 891 must be applied as recommended to obtain the maximum protection for which this coating is formulated. To obtain maximum performance for which Amercoat 891 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

Surface steel, Dimetecote primers, stainless steel

Application methods conventional or airless spray

Environmental Conditions
(during application)

Air temperature: 0 to 50°C 32 to 122°F

Surface temperature: .. 0 to 55°C 32 to 131°F

Drying Times

(at 25 µm and 21°C/70°F)

dry to touch 2 hours

dry to recoat 4 hours

dry before service 24 hours

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

Thinner / cleaner Thinner 21-06

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Application Procedure

Amercoat 891 is a one component material and is packaged in a 25 l can.

1. Flush equipment with recommended cleaner.
2. Stir all material thoroughly before applying.
3. If thinning is necessary for workability, thin with no more than 10 vol% of recommended thinner. For airless spray normally no thinning is required.
4. Spray on an even 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 pinholes, bare areas and holidays.
5. The application of a wet film thickness of 70 µm will normally provide approximately 25 µm dry film.
6. Check dry film with non destructive dry film thickness gauge, such as Elcometer or Mikrotest.
7. To repair or touch up bare areas, pinholes or holidays, simply apply additional materials. Smaller areas may be brushed. Allow 4 hours at 21°C/70°F between full coats.
8. 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.
9. Clean all equipment with recommended cleaner immediately after use or at least after each working day or shift.

Shipping Data

Packaging 20 l in 20 l can

Shipping weight approx. 26 kg

Packaging 5 l in 5 l can

Shipping weight approx. 6.7 kg

Shelf life 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 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.

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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.

Oasis Ameron Company Ltd

Dammam 2nd Industrial City P.O.Box 4926
J Al Khobar 31952 Saudi Arabia
Tel: +966 3 812 1300 | Fax : +966 3 812 1128
Email: sales@oasisameronpaints.com

www.oasisameron.com