



Performance Coatings & Finishes

Amercoat® 68HS

Zinc rich epoxy primer

Application Instructions

Refer to the Product Data Sheet for properties and uses.

Adhere to all instructions, precautions, conditions and limitations during storage, handling, application and drying periods to obtain maximum performance. For conditions outside the requirements or limitations described, contact your Ameron representative.

Surface Preparation

Coating performance, in general, is proportional to the degree of surface preparation. Surface must be clean, dry and free of all contaminants.

Steel – Without pits or depressions: blast SSPC-SP6.

Rusted and pitted: blast SSPC-SP10.

For mild exposures, power tool clean SSPC-SP3 is acceptable.

Blast to achieve a 1- to 2-mil (25- to 50-micron) profile as indicated by a Keane-Tator Surface Profile Comparator. Testex Tape or similar device.

Apply Amercoat 68HS as soon as possible to prevent blasted surface from rusting. Keep moisture, oil, grease or other organic matter off surface before coating. Spot blast to remove any contamination; solvent-wiping is not satisfactory.

Repair inorganic zinc surfaces – must be clean, dry, free of all contaminants and loose paint. Blast damaged areas to SSPC-SP10 or mechanically clean.

Epoxy or urethane surfaces – abrasive or brush blast to mechanically roughen damaged areas. Remove all contaminants before applying coating.

Application Equipment

The following is a guide; suitable equipment from other manufacturers may be used. Changes in pressure, hose and tip size may be needed for proper spray characteristics.

Conventional spray – Industrial equipment such as DeVilbiss MBC or JGA, or Binks #18 or 62 spray gun. A moisture and oil trap in the main air supply, mechanical pot agitator, separate regulators for air and fluid pressure are recommended.

Airless spray – Standard equipment such as Graco Bulldog Hydra-Spray or larger with a 0.017-inch tip with preorifice or fine finish tip.

Power mixer – Jiffy Mixer powered by an air or explosion-proof electric motor.

Environmental Conditions

Resin and cure material must be a minimum of 40°F before mixing. For satisfactory cure, air and surface temperatures must be above 50°F (10°C).

Temperature	°F	°C
air	32 to 120	0 to 49
surface	32 to 140	0 to 60
material (minimum)	40	4

Surface temperatures must be 5°F (3°C) above the dew point to prevent condensation.

Application Procedure

1. Flush all equipment with thinner or Amercoat 12 before use.
2. Stir each component separately, then mix cure into resin and mix until uniform. Slowly stir in zinc dust and mix until uniformly blended.

Pot life (hours)	°F/°C		
	90/32	70/21	50/10
nonaccelerated	8	16	24
accelerated (¼ pt 861/5 gal)	5	9	16

3. Thinning may be required; thin with up to ½ pint Amercoat 65 per gallon of Amercoat 68HS.
4. Apply to wet coat in even, parallel passes; overlap each pass 50 percent to avoid holidays, bare areas and pinholes. If required, cross spray at right angles to first pass.
5. Touch up random pinholes, holidays and small damaged or bare areas by brush when film dry to touch. Larger areas should be resprayed.

Drying time (ASTM D1640) (hours)	°F/°C			
	90/32	70/21	50/10	32/0
nonaccelerated	¼	½	1	NR
touch	4	8	36	NR
topcoat (minimum)	1	2	6	NR
topcoat (maximum months)	6	6	6	NR
accelerated (¼ pt/861/5 gal)				
touch	–	½	½	2
through	1 ½	4	16	96
topcoat (minimum)	¾	1 ½	4	24
topcoat (maximum months)	6	6	6	6

NR=Not Recommended

6. Clean equipment with thinner or Amercoat 12 immediately after use.

Safety Precautions

Read each component's material safety data sheet before use. Mixed material has hazards of each component. Safety precautions must be strictly followed during storing, handling and use.

CAUTION – Improper use and handling of this product can be hazardous to health.

Do not use this product without first taking all appropriate safety measures to prevent property damage and injuries. These measures may include, without limitation: implementation of proper ventilation, use of proper lamps, wearing of proper protective clothing and masks, tenting and proper separation of application areas. Consult your supervisor. Proper ventilation and protective measures must be provided during application and drying to keep spray mists and vapor concentrations within safe limits and to protect against toxic hazards. Necessary safety equipment must be used and ventilation requirements carefully observed, especially in confined or enclosed spaces, such as tank interiors and buildings.

This product is to be used by those knowledgeable about proper application methods. Ameron makes no recommendation about the types of safety measures that may need to be adopted because these depend on application environment and space, of which Ameron is unaware and over which it has no control.

If you do not fully understand these warnings and instructions or if you cannot strictly comply with them, do not use the product.

Note: Consult Code of Federal Regulations Title 29, Labor, parts 1910 and 1915 concerning occupational safety and health standards and regulations, as well as any other applicable federal, state and local regulations on safe practices in coating operations.

This product is for industrial use only. Not for residential use.

Warranty

Ameron warrants its products to be free from defects in material and workmanship. Ameron's sole obligation and Buyer's exclusive remedy in connection with the products shall be limited, at Ameron's option, to either replacement of products not conforming to this Warranty or credit to Buyer's account in the invoiced amount of the nonconforming products. Any claim under this Warranty must be made by Buyer to Ameron 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 Ameron of such nonconformance as required herein shall bar Buyer from recovery under this Warranty.

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