



Amercoat 180SG

Semi-Gloss Modified Alkyd

Product Data/Application

Instructions

- One component
- Low VOC
- Direct to metal
- Fast drying
- Compatible with wide range of primers
- Contains no lead or chromates

Typical Systems using Amercoat 180SG

1st	2nd
Amercoat 180SG	
Amercoat 180 or 185HS	180SG

Application Instructions

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

Surface Preparation

Coatings performance is, in general, proportional to the degree of surface preparation. Refer to specifications for the specific primer being used. Prior to coating, all surfaces must be clean, dry, undamaged and free of all contaminants, including salt deposits.

Steel, non immersion-New steel surface to a minimum SSPC-SP6 or pickle in accordance with SSPC-SP8. Blast to achieve a 1 to 2 mils (25 to 50 microns) profile as indicated by a Keane-Tator Surface Profile Comparator, Testex Tape or a similar device. For mild exposures, power tool cleaning in accordance with SSPC-SP3 or SSPC-SP11 is acceptable.

Galvanizing-Remove oil or soap film with neutral detergent or emulsion cleaner; then use zinc treatment such as Galvaprep or equivalent or blast lightly with fine abrasive.

Aluminum-Remove oil, grease or soap film with neutral detergent or emulsion cleaner; treat with

Alodine 1200, Alumiprep or equivalent or blast lightly with fine abrasive.

Physical Data

Finish	Semi-Gloss	
Color	Selected	
Components	1	
Curing mechanism	Solvent release and air oxidation	
Volume solids (calculated)	58%±3%	
Dry film thickness per coat	4-6 mils (100-150 microns)	
Theoretical coverage	ft ² /gal	m ² /L
1 mil (25 microns)	930	22.8
5 mils (125 microns)	186	4.6
VOC	lb/gal	g/L
Mixed	3.0	359
Mixed, thinned (1/2 pt/gal)	3.1	371
Flash point (SETA)	°F	°C
Amercoat 180SG	82	28
Amercoat 12 Cleaner	2	-17
Amercoat 65 Thinner	81	28

Application Data

Applied over	Prepared steel, galvanizing, aluminum	
Surface preparation	SSPC-SP6 or 10	
Method	Airless or conventional spray, brush or roller	
Thinner	Amercoat 65	
Equipment cleaner	Amercoat 12	
Drying time (minutes) at 5 mils	DFT	F/C
90/32	70/21	50/10
touch	15	45
through	75	130
recoat/topcoat	2 hrs	4 hrs
(minimum)	2.5 hrs	

Environmental conditions

Temperature	°F	°C
air and surface	45 to 100	7 to 38
Surface temperature must be at least 5° F (3° C) above dew point to prevent condensation.		

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 spray gun. Separate regulators for air and fluid pressure, mechanical pot agitator and a moisture and oil trap in the main air supply line are recommended.

Airless spray-Standard equipment such as Graco, DeVilbiss, Nordson, Spee-Flo or others have 28:1 or higher pump ratio and fluid tip with a 0.015 to 0.019 inch (0.38 mm to 0.53 mm) orifice.

Brush-Natural bristle. Maintain a wet edge.

Roller-Industrial solvent-type. Level any air bubbles with a bristle brush.

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

Application Procedure

1. Flush equipment with thinner or Amercoat 12.
2. Stir to uniform consistency. Strain through cheesecloth or equivalent to remove skin particles or other contamination.
3. If thinning is necessary for workability, add up to ½ pt of Amercoat 65 thinner per 1 gallon of Amercoat 180SG.t 132.
4. Apply a wet coat in even, parallel passes: overlap each pass 50 percent to avoid bare areas, pinholes or holidays. Excessive wet film thickness will cause sags and runs.
5. Store unused materials in tightly closed containers. Partially filled containers may show surface skinning after storage. Strain before use to remove skin.
6. Clean application equipment with thinner or Amercoat 12.

Safety Precautions

Read material safety data sheet before use. Safety precautions must be strictly followed during storage, handling and use.

CAUTION -Improper use and handling of this product can be hazardous to health and cause fire or explosion.

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 solvent vapour 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.

Shipping Data

Packaging units	1 gal	5 gal
Shipping weight (approx)lb		kg
1-gal can	13.5	6
5-gal can	67	30.5
Shelf life when stored indoors at 40 to 100° F(4 to 38° C)	One year from shipment date	

Numerical values are subject to normal manufacturing tolerances, color and testing variances. Allow for application losses and surface irregularities.

This product is photochemically reactive as defined by the South Coast Air Quality Management District's Rule 102 or equivalent regulations.

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 non-conformance as required herein shall bar Buyer from recovery under this Warranty.

Ameron makes no other warranties concerning the product. No other warranties, whether express, implied, or statutory, such as warranties of merchantability or fitness for a particular purpose, shall apply. In no event shall Ameron be liable for consequential or incidental damages.

Any recommendation or suggestion relating to the use of the products made by Ameron, whether in its technical literature, or in response to specific inquiry, or otherwise, is based on data believed to be reliable; however, the products and information are intended for use by Buyers having requisite skill and know-how in the industry, and therefore it is for 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, at its sole discretion and risk. Variation in environment, changes in procedures of use, or extrapolation of data may cause unsatisfactory results.

Limitation of Liability

Ameron's liability on any claim of any kind, including claims based upon Ameron'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 gives rise to the claim. **In no event shall Ameron be liable for consequential or incidental damages.**

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Amercoat Canada

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