



Performance Coatings & Finishes

# Amercoat® 771



## Underwater hull coating

### Product Data/ Application Instructions (For Marine & Offshore use)

- Excellent seawater immersion resistance
- Compatible with vinyl tar, bituminous anti-corrosives and chlorinated rubber bottom systems
- Compatible with a broad range of antifouling paint, including copolymer, super tropical, and chlorinated rubber types
- Special order

#### Typical Uses

- Repair of vinyl tar, bituminous anti-corrosive and chlorinated rubber bottom systems
- Complete anti-corrosive bottom system
- As a sealer coat for TBT-copolymer antifouling prior to application of ABC3 tin-free self-polishing antifouling
- As a tie coat between epoxy anticorrosive and antifouling paints

#### Surface Preparation

Coating 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 surfaces to a minimum SSPC-SP6. Blast to achieve a 1½ to 2½ mils (38 to 63 microns) profile as indicated by a Keane-Tator Surface Profile Comparator, Testex Tape or a similar device.

**Steel, immersion** – SSPC-SP10

**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.

**Existing coatings** – Epoxy or coal tar epoxy – abrasive sweep blast to roughen. Non-curing anti-corrosive – high pressure water cleaning or abrasive sweep blast.

#### 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.

#### Physical Data

Finish	Flat	
Colors	Brown, black	
Components	1	
Curing mechanism	Solvent release	
Volume solids (ASTM D2697)	52%±3%	
Dry film thickness per coat	4 mils (100 microns)	
Coats	1 or 2	
Theoretical coverage	ft <sup>2</sup> /gal	m <sup>2</sup> /L
1 mil (25 microns)	81	20
4 mils (100 microns)	205	5
VOC (EPA Method 24)	lb/gal	g/L
	3.47	417
Flash point (SETA)	°F	°C
Amercoat 771	82	28
Amercoat® 12	2	-17
Amercoat 65	81	27

#### Application Data

Applied over	Prepared or primed steel, galvanizing, aluminum		
Surface preparation	SSPC-SP6 or 10		
Method	Airless or conventional spray. Brush or roller for touch up only.		
Thinner	Amercoat 65		
Equipment cleaner	Thinner or Amercoat 12		
Drying time (hours) at 8 mils DFT	°F/°C		
	90/32	70/21	50/10
touch	½	¾	1
through	1½	3	5
recoat minimum	2	4	6
recoat maximum	None		

Note: When used as a tiecoat over Amercoat 235, 240, 370, or 385, Amercoat 771 must be applied within 1-7 days of the last coat of epoxy when substrate temperatures are 70°F (21°C) or lower. At substrate temperatures higher than 70°F (21°C), Amercoat 771 must be applied within 16 hours to 4 days.

#### Environmental Conditions

Temperature	°F	°C
air and surface	14 to 100	-10 to 38

Surface temperatures must be at least 5°F (3°C) above dew point to prevent condensation. When application is done at temperatures below freezing, particular care must be taken to ensure that the surface is free of frost or ice.

*Formerly HMP 771*

**Airless spray** – Standard equipment such as Graco, DeVilbiss, Nordson, Spee-Flo or others having 28:1 or higher pump ratio and fluid tip with a 0.019- to 0.023-inch (0.48mm to 0.58mm) 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.

## Mixing and Thinning

Stir well before application. Thinning is not normally required or desired; however at extreme environmental conditions, small amounts (5% or less) of Amercoat 65 thinner may be added depending on local VOC and air quality regulations. The addition of thinner can result in low film thicknesses or sagging.

## Application Procedure

1. Flush all equipment with thinner or Amercoat 12.
2. Stir to uniform consistency.
3. If thinning is necessary for workability, add up to ½ pt of Amercoat 65 thinner per 1 gal of Amercoat 771.
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.
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 mist and solvent 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 interior 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.***

## Shipping Data

Packaging	1 gal	5 gal
Shipping weight (approx.)	lb	kg
1-gal can	12.0	5.4
5-gal can	59.7	27.1
Shelf life when stored indoors at 40 to 100°F (4 to 38°C)	1 year from shipment date	

Numerical values are subject to normal manufacturing tolerances, colors 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 nonconformance 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 give rise to the claim. **In no event shall Ameron be liable for consequential or incidental damages.**



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