



Performance Coatings & Finishes

# Amercoat® 185HS

Universal primer

## Application Instructions

Refer to the Product Data Sheet for properties and uses. Adhere to all application instructions, precautions, conditions and limitations to obtain maximum performance. For conditions outside the requirements or limitations described, contact your Ameron representative.

### Surface Preparation

Coating performance is, in general, proportional to the degree of surface preparation. Prior to coating, surface must be clean, dry, undamaged and free of all contaminants, including salt deposits. Areas to be primed - round off all rough welds and sharp edges, remove weld spatter.

**Steel – New without pits or depressions:** blast SSPC-SP6 or pickle SSPC-SP8.

**Previously painted or pitted steel:** blast SSPC-SP6 or 7. For mild exposures: power tool cleaning SSPC-SP2 is acceptable.

Blast to achieve 1- to 2-mils (25- to 50-microns) profile as determined with a Keane-Tator Surface Profile Comparator, Testex Tape or similar device. Remove abrasive residue and dust from surface. If profile is greater, additional thickness may be needed.

**Aluminum** – Remove oil, grease or soap film with a neutral detergent or emulsion cleaner. Apply chromate-type conversion treatment, such as Alodine® 1200, Alumiprep® or equivalent, or lightly blast with fine abrasive.

**Galvanizing** – Remove any oil or soap film with neutral detergent or emulsion cleaner. Use zinc treatment such as Galvaprep® or equivalent or lightly blast with fine abrasive.

**Dimetcote®** – Surface must be clean and dry. Remove any contamination, including curing residue. If surface is glazed, roughen by sweep blasting. Refer to specific Dimetcote application instructions for any other special topcoating requirements.

Systems Using Amercoat 185HS

1st Coat	2nd Coat	2nd or 3rd Coat
185HS		Amershield™, 385, 450HS, 5401HSA Amerlock® 400,
Dimetcote®	185HS*	Amershield™, 450HS, 5401HSA
78HB, 385, 400	185HS** tie coat	70ESP, 279, 698HS, 635

*\*In some cases a mist coat/full coat technique may be required to prevent application bubbling.*

*\*\*When applying Amercoat 185HS over epoxy or coal tar epoxy anticorrosive coatings, apply 185HS while epoxy or coal tar epoxy is still tacky or soft to fingernail pressure. Failure to apply 185HS while epoxy or coal tar epoxy is still tacky may result in poor adhesion between coatings and eventual delamination of antifoulant.*

## Environmental Conditions

Temperature	°F	°C
air and surface	35 to 120	2 to 49

Surface temperatures 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.

**Airless spray** – Standard equipment such as Graco Bulldog Hydra-spray or larger with a 0.017-inch fluid tip.

**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.

**Brush** – Natural bristle. Maintain a wet edge.

**Roller** – Solvent resistant. Level any air bubbles with a bristle brush.

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

## Application Procedure

1. Clean equipment with thinner or Amercoat 12 before use.
2. Stir material thoroughly with an air or explosion-proof power mixer until uniformly blended.
3. Thinning is normally not required. If necessary for workability, thin with Amercoat 65 or 101 up to 1/2 pint per gallon of Amercoat 185HS for airless and conventional spray.

Temperature	Thinner
below 70°F (21°C)	Amercoat 65
above 70°F (21°C)	Amercoat 101

4. Apply a wet coat in even, parallel passes; overlap each pass 50 percent to avoid holidays, bare areas and pinholes.
5. Double coat all welds, rough spots, sharp edges and corners, rivets, bolts, etc.

Drying time (ASTM D1640)	°F/°C			
	90/32	70/21	50/10	32/0
touch (min)	10	20	60	120
through (hrs)	3	6	12	16
recoat				
minimum (hrs)	2	4	8	16
Immersion service topcoat (maximum)	6 months			

*Roughen surface if maximum recoat time is exceeded.*

6. Random pinholes, holidays and small damaged areas can be touched up by brush when film is dry to touch. Larger areas should be resprayed.
7. Clean all equipment with thinner or Amercoat 12 immediately after use.

**Formerly Amercoat 3153A**

## 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 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, 1915 and 1916 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 professional 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.

**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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