



AMERON
INTERNATIONAL

Performance Coatings & Finishes

Amercoat® 329

High-build modified epoxy

Product Data/ Application Instructions

- Excellent water immersion resistance
- One coat application for significant reduced labor costs
- Durable high build film properties
- Abrasion resistant and good flexibility
- Good application properties and recoatability
- Does not contain coal-tar

Typical Uses

Marine structures, piling, bilges, ballast tanks, ship bottoms; pipe coating and lining. Lining for intermittent or continuous immersion in salt solutions, fresh or brackish water and seawater.

Typical Properties

Humidity Resistance ASTM D 2247, 1000 hours	No effect on film integrity or adhesion.
Salt Fog Resistance ASTM B 117, 2000 hours	No effect on film integrity or adhesion. Less than 3/32 inch undercutting at scribe. Less than 3% rust at edges.

Surface Preparation

Coating performance is proportional to the degree of surface preparation. Prior to coating, all surfaces must be clean, dry and free of all contaminants, including salt deposits.

Steel – Remove all loose rust, dirt, grease or other contaminants by one of the following depending on the degree of cleanliness required: SSPC-SP 2, 3, 6 or 7. For more severe service and immersion, clean to SSPC-SP10. The choice of surface preparation will depend on the system selected and end-use service conditions.

Blast to achieve an anchor profile of 2-3 mils (50-75 microns) as indicated by a Keane-Tator Surface Profile Comparator or Testex Tape. Previously blasted steel may be ultra-high pressure water jetted to NACE No. 5/SSPC-SP 12 WJ-2L/SC-1. The wet surface can be dried by blowing with dry compressed air giving special attention to horizontal surfaces and recesses.

Concrete – Light abrasive blast to remove all previous coatings, chalk, and surface glaze or laitance. If blasting is not possible, acid etch uncoated concrete to obtain a glaze-free surface with a slightly granular texture. Rinse with clean water and allow to dry thoroughly. After blasting or acid etching, fill all small holes or voids with material such as Nu-Klad® 114A filler compound.

Aged coatings and Shop-primed Surfaces – All surfaces must be clean, dry, tightly bonded and free of all loose paint, corrosion products or chalky residue. Clean by pressure water blast (1000 psi or greater), SSPC-SP 1, 2, 3 or 7. Amercoat 329 is compatible over most types of properly applied and tightly adhering coatings. However, a test patch is recommended to confirm compatibility.

Repair – Prepare damaged areas to original surface preparation specifications, feathering edges of intact coating. Thoroughly remove dust or abrasive residue before touch up.

Physical Data

Finish	Flat	
Color	Black, Oxide Red and Pearl Gray	
Components	2	
Curing mechanism	Solvent release and chemical reaction between components	
Volume solids (ASTM D2697 modified)	85% ± 3%	
Dry film thickness per coat	8-16 mils (200-400 microns)	
Coats	1 or 2	
Theoretical coverage	ft ² /gal	m ² /L
8 mil (200 microns)	170	4.2
16 mils (400 microns)	85	2.1
VOC (EPA 24) mixed	lb/gal	g/L
	1.97	237
Temperature resistance	°F	°C
dry	250	121
neutral salt solutions	160	71
fresh water	140	60
Flash point (SETA)	°F	°C
resin	126	52
cure	144	62
mixed	131	55
Amercoat 12	2	-17
Amercoat 65	78	25
Amercoat 101	145	63
T-10	80	27

Application Data

Applied over	Prepared steel or concrete
Method	Airless or conventional spray
Mixing ratio (by volume)	8 parts resin to 1 part

Drying time (ASTM D 1640) 16 mils DFT	°F/°C		
	90/32	70/21	50/10
Through (hours)	10	20	48
Recoat (hours)			
minimum (hours)	6	12	24
maximum (days)	14	30	30

Formerly Amercoat 3476

Application Equipment

The following is a guide. Suitable equipment from other manufacturers may be used. Changes in pressure and tip size may be needed to achieve the proper spray characteristics.

Airless spray – Standard equipment, such as Graco King 45:1 or larger, with a 0.021- to 0.027-inch (0.46 to 0.69 mm) fluid tip.

Conventional spray – Industrial equipment such as DeVilbiss MBC or JGA or Binks 18 or 62 spray gun. A pressure material pot with mechanical agitator and a moisture and oil trap in the main air supply line are essential. Separate pressure regulators for air and fluid pressure are recommended.

Power mixer – Jiffy Mixer powered by air or explosion-proof electric motor. Propeller-type mixing head is satisfactory.

Environmental Conditions

Temperature	°F	°C
air	40 to 122	4 to 50
surface	50 to 122	4 to 50
material	50 to 100	10 to 38

Surface temperature must be at least 5°F (3°C) above dew point at all times to prevent condensation.

Note – For maximum film build and ease of application, air, surface and material temperature should be 70 to 90°F (21 to 32°C). Higher or lower temperatures may require spray technique modification.

Application Procedure

Amercoat 329 is packaged in the proper proportions which must be mixed together before use.

1. Flush equipment with Amercoat 12 cleaner before use.
2. Stir base (pigmented material) with a power mixer to an even consistency.
3. Add cure to resin and continue stirring for five minutes.

	°F/°C		
	90/32	70/21	50/10
Induction Time (Minutes)	15	30	45
Pot life (hours)	3	5	9

Note – Do not mix more material than will be used within pot life. Higher temperatures shorten pot life.

4. Thinning is normally not required when using airless spray equipment.
5. For conventional spray, thin only as necessary for workability. Use up to one pint Amercoat 65, 101, or T-10 thinner per gallon of mixed coating.
6. Apply in even, parallel passes with 50 percent overlap. Immediately follow with cross-spray passes to obtain a continuous film without bare spots, pinholes, or holidays.
7. Double-coat all welds, corners, sharp edges, rivets and bolts, rough spots, etc.
8. A 19 mil (475 micron) wet film thickness will normally provide 16 mils (400 microns) of dry film.
9. Check thickness of dry but uncured coating with a nondestructive gauge, such as Mikrotest or Elcometer. If thickness is less than specified, apply additional material as needed. Allowable thickness range is 8 to 16 mils (200 to 400 microns), depending upon service.
10. For a pinhole-free coating, check continuity of dry but uncured coating with a nondestructive holiday detector such as Tinker and Razor Model AP/W at minimum volts needed for the applied thickness. Repair by brushing Amercoat 329 over affected areas.
11. Apply additional material to correct film thickness and repair pinholes or damaged areas. See Recoat Schedule. The surface must be clean and dry when repair coat is applied.
12. Inside tanks, pipes and other confined areas, ventilate during application and curing to remove solvents.
13. Clean all equipment with Amercoat 12 cleaner immediately after completion of work. Gelled Amercoat 329 will plug spray equipment.

Shipping Data

Packaging units	1 gal	5 gal
resin	.89 gals in 1-gal can	4.45 gals in 5-gal pail
cure	.11 gals in 1-pt. can	.55 gals in 1-gal can
Shipping weight (approx)	lb	kg
1-gal unit		
resin	13.2	6.0
cure	.9	.4
5-gal unit		
resin	65.0	27.7
cure	5.0	2.0

Shelf life when stored indoors at 40 to 100°F (4 to 38°C)

cure and resin 1 year from shipment date

Numerical values are subject to normal manufacturing tolerances, color and testing variances. Allow for application losses and surface irregularities. See application instructions for complete information and safety precautions.

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

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 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.

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.

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.**



Ameron U.S.A. • 13010 Morris Rd, Suite 400, Alpharetta, GA 30004 • (678) 393-0653
Ameron B.V. • J. F. Kennedylaan 7, 4191 MZ Geldermalsen, The Netherlands • (31) 345-573341