



Performance Coatings & Finishes

Amercoat® 335

Waterborne epoxy acrylic

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 proportional to the degree of surface preparation. Primed surface must be free of moisture, grease or other contaminants.

Steel – Remove all loose rust, dirt, grease or other contaminants by one of the following depending on the degree of cleanliness required: SSPC-SP3; SSPC-SP2; SSPC-SP6; SSPC-SP7. Water blasting is also acceptable. For more severe service, clean to SSPC-SP10. The choice of surface preparation will depend on the system selected and end-use service conditions.

Galvanizing – Remove oil or soap film with neutral detergent or emulsion cleaner. Then use zinc treatment such as Galva-Prep® 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.

Concrete/masonry – Clean concrete surface, abrasive blast (ASTM D4259) or acid-etch (ASTM D4260). Fill concrete voids with Nu-Klad® 965 or 114A. Clean masonry surface by ASTM D4261. Fill masonry block with Amerlock® 400BF Block Filler.

Wood – Sand new and bare wood to remove any surface contamination and surface cells. Remove oil spots, sap or pitch by wiping with Amercoat 65. Properly dispose of solvent rags to avoid spontaneous combustion hazards. A wood primer or a first coat of Amercoat 335 may be used to prime surface. To recoat primed wood, remove all dirt, grease or oil with a cleaner. Rinse with clean water. Remove wax with commercial dewaxer. Sand loose paint to a tight, adherent surface.

Aged coating – 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-SP1, SSPC-SP3 or SSPC-SP7.

Drywall – Tape all joints, fill cracks and nail holes with patching paste or spackle; sand smooth. Remove all dust. Unsealed surfaces will require two coats of Amercoat 335.

Dimetcote® 21-5 – When applying directly over inorganic zinc or zinc-rich primer, a mist coat may be required to minimize bubbling. This will depend on age of coating, surface roughness and conditions during curing. Refer to Dimetcote 21-5 Application Instructions.

Application Equipment

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

Airless spray – Standard 30:1 airless pump or equivalent with a 0.017-inch fluid tip.

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

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

Brush – Natural bristle. Maintain a wet edge.

Roller – Industrial solvent resistant roller. Level any air bubbles with bristle brush. Amercoat 855 flow control additive is recommended when brushing or rolling for improved appearance (use maximum of 1/2 pint per 1 gal mix or 1 quart per 5 gal mix).

Environmental Conditions

Temperature	°F	°C
air	40 to 110	4 to 43
surface	40 to 120	4 to 49
Relative humidity		
40°F	maximum 60%	
50 to 100°F	maximum 85%	
above 100°F	maximum 95%	

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

Application Procedure

1. Stir resin using power mixer to disperse pigments
2. Add cure to resin. Mix thoroughly until uniformly blended. **Induction time before application is required** for proper film build and appearance.
3. Do not mix more material than will be used within pot life. Pot life is shortened by higher temperatures.

Pot life/Induction times	°F/°C		
	90/32	70/21	50/10
Pot life (hours)	4	8	16
Induction (minutes)	15	30	60

4. If required for workability, add up to 1/2 pint water per gallon of Amercoat 335 and stir thoroughly. Do not exceed thinning limit. Film build will be reduced.
 5. Drying times (ASTM D1640)
@ 2 mils DFT
- | | °F/°C | | |
|------------------|---|-------|-------|
| | 90/32 | 70/21 | 50/10 |
| touch (minutes) | 10 | 30 | 90 |
| through (hours) | 1 1/2 | 6 1/2 | 48 |
| full cure (days) | 3 | 7 | 14 |
| Recoat time | | | |
| minimum (hours) | 1 1/2 | 2 | 48 |
| maximum (days) | None. See surface preparation for aged coatings | | |

6. Apply a 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.
7. Clean all equipment immediately after use with clean water, followed by Amercoat 928 to remove any partially dried material.

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 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 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 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.

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