



AMERON
INTERNATIONAL

Performance Coatings & Finishes

Amercoat® 369

Aliphatic polyurethane gloss enamel

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

- Highest gloss and gloss retention
- Outstanding color retention properties
- Durable film properties
- Excellent application properties
- Excellent aged recoatability

Typical Uses

Amercoat 369 enamel will provide the maximum gloss and color retention as well as resistance to moderate-severe corrosive environments for:

- Fishing fleets
- Passenger vessels
- Support vessels
- Offshore structures

Recommend for steel, aluminum, masonry or fiberglass when properly primed.

Surface Preparation

Coating performance, in general, is proportional to the degree of surface preparation. Refer to application instructions for specific primers and intermediate coats being used for application and curing procedures. All previous coats must be clean and dry. Aged epoxy coatings must be roughened before applying Amercoat 369.

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 equipment such as Graco, DeVilbiss, Binks, Speedflo, or others having a 28:1 or higher pump ratio and a fluid tip with 0.013- to 0.015-inch (0.33- to 0.38-mm) orifice.

Conventional spray—Industrial equipment such as DeVilbiss MBC or Binks BBR spray gun. Separate air and fluid pressure regulators, mechanical pot agitator and a moisture and oil trap in main air supply line are recommended.

Brush or roll—Additional coats may be required to attain proper thickness.

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

Physical Data

| | | |
|--|--|-------------------|
| Finish | High gloss | |
| Color | See color card | |
| <i>Yellow, red and orange colors will fade faster than other colors due to the replacement of lead-based pigments with lead-free pigments in these colors.</i> | | |
| Components | 2 | |
| Curing mechanism | Solvent release and chemical reaction between components | |
| Volume solids (ASTM D2697 modified) | 56% ± 3% | |
| Dry film thickness per coat | 2-3 mils (50-75 microns) | |
| Coats | 1 | |
| <i>Uniform appearance may require two coats on tanks and other large structures previously coated with contrasting primer or intermediate coat.</i> | | |
| Theoretical coverage | ft ² /gal | m ² /L |
| 1 mil (25 microns) | 898 | 22.1 |
| 2 mils (50 microns) | 449 | 11.1 |
| | lb/gal | g/L |
| VOC (EPA 24) | 3.2 | 388 |
| Temperature resistance (Dry) | °F | °C |
| continuous | 200 | 93 |
| intermittent | 250 | 121 |
| Flash point (SETA) | °F | °C |
| converter | 88 | 31 |
| base | 78 | 26 |
| Amercoat® 12 | 2 | -17 |
| T-9 | 100 | 38 |

Application Data

| | | | |
|---|--|----------|-------|
| Applied over | Primed concrete or steel | | |
| Surface preparation | See specific primer or intermediate coat | | |
| Primers | Amercoat 385, 235, 236 | | |
| Method | Air or airless spray, brush or roller | | |
| Environmental conditions | | | |
| Temperature | °F | °C | |
| air and surface | 20 to 120 | -7 to 49 | |
| Surface temperature must be at least 5°F (3°C) above dew point to prevent condensation. | | | |
| Mixing ratio (by volume) | 4 parts base to 1 part converter | | |
| Induction time | 15 minutes | | |
| | | °F/°C | |
| | 90/32 | 77/25 | 50/10 |
| Pot life (hrs) | 4 | 8 | 12 |
| Drying time (ASTM D1640) (hours) | | °F/°C | |
| | 90/32 | 70/21 | 50/10 |
| hard (hours) | 3 | 8 | 18 |
| Recoat Time | | | |
| minimum (hours) | 2 | 5 | 8 |
| maximum (days)* | 7 | 14 | 28 |
| *Treat surface with Prep 88 when recoat time exceeds maximum. | | | |
| Thinner | Amercoat 923, 924 | | |
| Equipment cleaner | Thinner or Amercoat 12 | | |

Formerly Devthane™ 369

Application Procedure

Amercoat 369 is packaged in two components in the proper proportions which must be mixed together before use:

- 1. Flush equipment with thinner or Amercoat 12 before use. It is important that all mixing equipment is free of moisture and that moisture does not contaminate the coating.
- 2. Stir each component thoroughly, then add converter to base and mix until uniformly blended to a workable consistency. After the converter add is complete, continue to mix for 5 minutes. Allow another 15 to 20 minutes induction time before application.

Do not mix more material than will be used within 8 hours at 70°F (21°C). Pot life is shortened by higher temperatures.

- 3. Thinning is not normally required or desired, and excessive thinning can adversely affect application and appearance properties. However, at lower temperatures, small amounts (5% or less) of a recommended thinner may be added depending on local VOC and air quality regulations. Small amounts (5% or less) of Amercoat 923, 924 thinner will improve roller or brush application.
- 4. When applying by conventional spray, use adequate air pressure and volume to ensure proper atomization.
- 5. Apply a wet coat in even parallel passes, overlap 50 percent to avoid holidays, bare areas and pinholes. If required, cross spray at right angles.
- 6. Application of 3.5 mils (87.5 microns) wet film thickness will normally provide 2 mils (50 microns) dry film.
- 7. Clean all equipment with thinner or Amercoat 12 immediately after use.
- 8. Keep containers tightly closed since repeated exposure to moisture will cause gelation. Moisture contaminated material is also subject to gassing on storage. Handle bulged containers with caution; lids may eject forcibly.
- 9. Rate of curing is dependent on temperature. At 70°F/21°C a full cure requires seven days.

Shipping Data

| | | |
|---|---------------------------|--------------------|
| Packaging units | 1 gal | 5-gal |
| converter | 0.2 gal in 1-qt can | 1 gal in 1-gal can |
| base | 0.8 gal in 1-gal can | 4 gal in 5-gal can |
| Shipping weight (approx) | lb | kg |
| 1-gal unit | | |
| converter | 2.1 | 1.0 |
| base | 10.2 | 4.6 |
| 5-gal unit | | |
| converter | 9.6 | 4.4 |
| base | 50.6 | 23.0 |
| Shelf life when stored indoors at 40 to 100°F (4 to 38°C) | 1 year from shipment date | |
| resin and cure | | |

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 nonphotochemically 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 both components; gives off harmful vapor of solvents and isocyanates. Use only with adequate ventilation. A positive pressure air-supplied respirator (TC19C NIOSH/MSHA) is recommended. Follow directions for respirator use. Wear respirator for the entire time of mixing, spraying and until all vapors and mists are gone. 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 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.

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.

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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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