



Performance Coatings & Finishes

Amercoat® 370

Fast-dry multi-purpose epoxy

Application Instructions

Adhere to all application instructions, precautions, conditions and limitations during storage, handling, application and drying periods to obtain the 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. Surface must be clean, dry, undamaged and free of all contaminants prior to coating.

Welds should be continuous with no overlapping steel surfaces or rough edges. Remove all weld spatter.

Steel, non-immersion – Remove all loose rust, dirt, grease or other contaminants by one of the following depending on the degree of cleanliness required: SSPC-SP2, 3, 6, 7 or 11. Water blasting is also acceptable.

Steel, immersion – 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 a surface profile not to exceed 3 mils (75 microns) as indicated by a Keane-Tator Surface Profile Comparator Testex Tape. Increase coating thickness if profile greater than 3 mils.

Primed steel – Prepare surface in accordance with application instructions for the specific primer being used. Be sure primer is clean and dry when Amercoat 370 is applied. Remove all loose rust, dirt, moisture, grease or contaminants.

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

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 0.015- to 0.021-inch (0.38 mm to 0.53 mm) fluid tip.

Conventional spray – Industrial equipment, such as DeVilbiss, MBC or JGA gun with 78 or 765 air can and “E” fluid tip, or Binks No. 18 or 62 gun with a 66x63PB nozzle set up. Separate air and fluid pressure regulators, mechanical pot agitator, and a moisture and oil trap in the main air supply line are recommended.

Environmental Conditions

Temperature	°F	°C
air and surface	20 to 120	-7 to 49
material	40	4

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

Application Procedure

Amercoat 370 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.
2. Stir each component thoroughly, then combine and mix until uniform.
3. If thinning is necessary for workability, add Amercoat 927 below 60°F or Amercoat 101 at 60°F and above. Thin in quantities up to 1 pint per gallon of Amercoat 370.
4. Do not mix more material than will be used within 4 hours at 70°F (21°C). Pot life is shortened by higher temperatures. Thinning may be necessary for workability periodically throughout pot life.

Pot Life and Dry Times

Temperature (°F/°C)	Pot-Life (Hours)	Touch Dry (Min.)	Through Dry (Hours)	Recoat (Hours)
20/-7	—	90	20	2½
32/0	—	60	9	2
40/4	7	45	7	2
50/10	6	30	4½	1½
60/16	5	22	2¾	1
70/21	4	15	1½	½
80/27	3	12	1¼	½
90/32	2	10	1	½

Topcoat or recoat time (days) (maximum)

	°F/°C			
	90/32	70/21	50/10	20/-7
Amercoat 450HS, Amershield™	14	30	45	60

Amercoat 370

non-immersion 6 months – Clean surface required
immersion 1 month – Clean surface

Amercoat 698HS, 70ESP,
635, 279, 275E

Apply while Amercoat 370 is tacky,
soft to fingernail*

* Failure to apply antifoulings while coating is still tacky or soft to fingernail may result in poor adhesion and eventual delamination.

If maximum topcoat time is exceeded, either clean and roughen the Amercoat 370 surface or clean and apply a tack coat of Amercoat 370 before topcoating with Amercoat 450HS, Amershield or antifouling.

Time before service @ 8 mils (hours)

	°F/°C				
	90/32	70/21	50/10	32/0	20/-7
Amercoat 370					
non-immersion**	6	12	24	96	120
immersion	12	24	48	168	NR

NR=Not recommended

**Cure to full physical properties.

5. When applying by conventional spray, use adequate air pressure and volume to ensure proper atomization.
6. When applying over inorganic zinc or zinc rich primers, a “mist coat” 1-1½ mils wet, full coat technique may be required to minimize bubbling. This will depend on the age of the Dimetecote, surface roughness and conditions during curing. When applying Amercoat 370 over Dimetecote at 60°F and above, use Amercoat 101 thinner up to 1 pint per gallon. For potable water tanks, use only Amercoat 65 thinner.

Formerly Amercoat 3303

7. Normal recommended dry film thickness is 5 mils (125 microns). Total dry film thickness must not exceed 15 mils (375 microns).
8. The application of a wet film thickness of 7 to 8 mils (175 to 200 microns) will normally provide 5 mils (125 microns) of dry film.
9. Clean all equipment with thinner or Amercoat 12 immediately after use.

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.

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.

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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