

# Amercoat® 385ASA Cure

## Anti-slip epoxy

### Product Data/ Application Instructions

- Tough durable coating with anti-slip grit
- Withstands abrasion and heavy traffic
- Easy application
- VOC compliant

#### Typical Uses

Amercoat 385ASA Cure mixed with Amercoat 385 Resin, is a tough anti-slip epoxy coating used to provide corrosion protection and long lasting anti-slip surface over steel. Used on ships, barges, workboats and offshore platforms.

Use with Amercoat 385 Resin.

### Physical Data

Finish	Flat			
Color	Standard Amercoat 385 colors			
Components	Use with Amercoat 385 resin			
Curing mechanism	Solvent release and chemical reaction between components			
Volume solids (calculated - mixed with Amercoat 385 Resin)	66% ± 3%			
Dry film thickness per coat	10 to 30 mils (250 to 750 microns)			
Coats	1 or 2			
Theoretical coverage	ft²/gal		m²/L	
20 mil (500 microns)	53.0		1.30	
VOC	lb/gal		g/L	
(calculated)				
mixed	2.5		300	
mixed/thinned	2.8		340	
Temperature	Wet		Dry	
	°F	°C	°F	°C
continuous	140	60	200	93
intermittent	175	79	250	121
Flash point (SETA)	°F		°C	
cure	118		48	
resin	128		53	
Amercoat 65	78		25	

### Application Data

Applied over substrates	Prepared steel			
Method	Spray or roller			
Mixing ratio (by volume)	1 part Amercoat 385 resin to 1 part Amercoat 385 ASA Cure			
Pot life (hours)				
°F/°C	90/32	70/21	50/10	
385ASA cure with 385 resin	1 1/2	3	5	
Environmental conditions				
Temperature	°F		°C	
air and surface	40 to 120		4 to 49	
Surface temperatures must be at least 5°F (3°C) above dew point to prevent condensation.				
Drying time (ASTMD1640) @ 20 mils, DFT (hours)				
	°F/°C			
	90/32	70/21	50/10	32/0
touch	1	2	3	6
through	10	16	24	168
Recoat or topcoat time				
minimum (hrs)	6	8	10	72
maximum (days)	3	7	14	25
time of service (hrs)	24	48	72	240
Thinner	Amercoat 65			
Equipment cleaner	Amercoat 12			

## Surface Preparation

Coating performance is proportional to the degree of surface preparation. Refer to specifications for the specific primer being used. Prior to coating, surface must be clean, dry, undamaged and free of all contaminants including salt deposits. Round off all rough welds and remove all weld spatter.

**Steel** – 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 or 7. Water blasting is also acceptable. For more severe service clean to SSPC-SP10.

Blast to achieve a surface profile not to exceed 5 mils (75 microns) as indicated by a Keane-Tator Surface Profile Comparator or Testex Tape. Increase coating thickness if profile greater than 5 mils.

**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

**Spray** – The following spray equipment is recommended, but other equipment may be used: bottom feed 2-gal or larger pressure pot with follower plate and air control; fluid hose  $\frac{1}{2}$  inch diameter or larger; Binks 18D mastic gun with  $\frac{3}{16}$  inch fluid tip or larger and a 241 air cap.

**Roller** – Short nap.

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

## Application Procedure

Amercoat 385ASA Cure is mixed with Amercoat 385 Resin before use. It is packaged in the proper portions in 2 or 5 gallon units.

1. Flush equipment with thinner or Amercoat 12 before use.
2. Stir each component thoroughly, then combine resin and cure and mix until uniform.
3. If thinning is necessary for workability add up to  $\frac{1}{2}$  pint Amercoat 65 per gallon of mixed Amercoat 385ASA Cure and 385 Resin. Use only Ameron recommended thinner.
4. Do not mix more material than can be used within the pot life. Pot life shortened at higher temperature.
5. Clean equipment with Amercoat 12.

## 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.**

## Shipping Data

Packaging units	2 gal	5 gal
Amercoat 385 ASA Cure	1 gal in 1-gal can	5 gal in 5-gal can
Amercoat 385 resin	1 gal in 1-gal can	5 gal in 5-gal can
Shipping weight (approx.)	lb	kg
2-gal unit		
Amercoat 385 Cure	14.4	6.5
Amercoat 385 resin	13.6	6.2
5-gal unit		
Amercoat 385 Cure	71.8	32.6
Amercoat 385 resin	67.0	30.5
Shelf life when stored indoors at 40 to 100°F (4 to 38°C)		
cure, 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.

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

Improper use and handling of this product can be hazardous to health and cause fire or explosion. Safety precautions with application instructions must be strictly followed during storage, handling, application and drying periods.

***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 invoices 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.



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