

# Amercoat<sup>®</sup> 395

*High-solids amine-cured epoxy tank lining*

## Application Instructions

Refer to Amercoat 395 Product Data Sheet for properties and uses. Adhere to all application instructions, precautions, conditions and limitations to obtain the 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 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** – Abrasive blast to SSPC-SP10. Blast to achieve an anchor profile of 1 to 2 mils (25 to 50 microns) as determined with a Keane-Tator Surface Profile Comparator, Testex Tape or similar device. Remove abrasive residue or dust from surface.

Apply the first coat of Amercoat 395 as soon as possible to prevent blasted surfaces from rusting. Surface must be dry and free of contamination. Spot blast if needed.

Intact Amercoat 3207 should be cleaned of all dirt, moisture, grease and other contaminants prior to topcoating with Amercoat 395 or 395FD.

**Surfaces previously coated with Amercoat 3207 Shop Primer** – Abrasive blast loosened or damaged areas to SSPC-SP10 or tool clean to SSPC-SP11.

### 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, 0.019-0.023 inch tip.

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

**Power mixer** – Such as Jiffy mixer powered by air or explosion-proof electric motor. Normal propeller-type mixing head is satisfactory.

### Environmental Conditions

Temperature	°F	°C
Air		
Amercoat 395	40 to 122	4 to 50
with 395FD cure	32 to 122	0 to 50
Surface		
Amercoat 395	40 to 140	4 to 60
with 395FD cure	32 to 140	0 to 60
Material		
optimum workability	70 to 80	21 to 27

Surface temperature must be at least 5°F (3°C) above dew point to prevent condensation during surface preparation and between coats. At freezing temperatures surfaces must be free of ice.

**Relative humidity** – 40 to 85 percent. Curing mechanism of this product requires moisture for proper and complete cure. If relative humidity is below 40 percent, suitable means should be employed to raise moisture level.

Pot life (hours)	°F/°C			
	90/32	70/21	50/10	32/0
395 cure and 395FD cure	4	10	24	NR
NR = Not Recommended				

Drying time (ASTM D1640)(hours)	°F/°C			
through	120/49	70/21	50/10	32/0
395 cure	14	24	84	NR
395FD cure	6	14	72	110

recoat				
minimum (hours)	8	16	48	96
maximum (weeks)	1	3	5	8

*If maximum recoat time exceeded, roughen surface.*

Cure for immersion service (days)				
395 cure and 395FD cure	2	7	14	NR

## Application Procedure

Amercoat 395 is packaged in the correct proportions of resin and cure which must be mixed together before use.

1. Flush equipment with thinner or Amercoat 12 before use.
2. Stir each component separately, then add all the cure (clear) to resin (pigmented). Mix together thoroughly, scraping sides and bottom of container. Mixer with an explosion-proof motor is recommended.
3. Allow an induction period of 30 minutes at 70°F (21°C).
4. Thin only as required for workability. Up to 20 percent Amercoat 65 per gallon of Amercoat 395 or 395FD may be needed depending upon temperature and equipment capabilities.
5. Stir during application to maintain homogeneity.
6. Apply a wet coat in even, parallel passes; overlap 50 percent to avoid holidays, bare areas or pinholes. If required, cross spray at right angles.
7. Recommended dry film thickness per coat is 3 to 5 mils. Do not exceed 7 mils dry film thickness per coat; otherwise, curing will be impaired and performance may be affected.
8. Should puddling or sagging occur due to excessive buildup, brush out evenly over adjacent areas.
9. Allow first coat of Amercoat 395 to dry in accordance with drying time, and apply second coat following the above procedure.
10. After allowing minimum dry time for Amercoat 395 system, check film thickness with a nondestructive gauge, such as Mikrotest or Elcometer. If less than specified thickness, apply additional material as needed.

*Note: Because of high solids content, film thickness builds rapidly. Check thickness frequently and if too thick use smaller spray gun tip or add more thinner.*

11. If a test for film continuity is required, check for bare areas, pinholes or holidays with a nondestructive holiday detector such as Tinker-Rasor Model M-1. Apply additional Amercoat 395 to areas requiring touch-up.
12. Clean all equipment with thinner or Amercoat 12 immediately after use.

## Drying and Curing

The curing process requires evaporation of solvents, reaction of curing agent with moisture in the air and chemical reaction between the components, and is dependent upon time, temperature, relative humidity and proper ventilation.

To ensure proper cure, relative humidity must be above 40 percent. If film thickness is greater than recommended, a longer drying time is required. At low temperatures, dry film thickness should be in the 3 to 4 mil range for the first coat to achieve good drying properties. However, in no instance should film thickness per coat exceed 7 mils; otherwise, curing will be impaired. Ventilation with clean air is required between coats and during curing period following final coat.

## Repair

For repair of damaged, imperfect or thin areas, additional Amercoat 395 should be applied in accordance with the above schedule to ensure proper adhesion. After three weeks maximum, roughen the surface to recoat.

## 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.

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## Limitation of Liability

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