



Performance Coatings & Finishes

Amerthane® 487

Elastomeric polyurethane

Application Instructions

Refer to the Product Data Sheet for properties and uses. Adhere to all 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. All surfaces must be clean and dry before coating. Round off all rough welds and sharp edges, remove all weld spatter.

Steel – Abrasive blast hot-rolled steel to SSPC-SP6; rusted and pitted steel to SSPC-SP10. Prime as needed for recommended service.

Aluminum and galvanizing – Remove oil, grease or other contaminants with neutral detergent or solvent emulsion cleaner; treat aluminum with Alumiprep®; galvanizing with Galvaprep®. Prime with Amercoat® 385 or Amerlock® 400.

Concrete – Clean concrete and masonry surfaces, abrasive blast (ASTM D4259) or acid etch (ASTM D4260). Fill concrete voids with Nu-Klad® 114A or 965. Prime as needed for recommended service. Refer to Amerthane 487 product data sheet for substrate and primer recommendations.

Aged Amerthane 487 – Roughen; remove all contaminants.

Environmental Conditions

Air and surface temperature: 40° to 120°F (4° to 50°C).
Relative humidity: 15 to 95%. Surface temperature must be at least 5°F (3°C) above dew point to prevent condensation.

Application Equipment

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

Airless spray – Standard equipment Graco, DeVilbiss, Nordson-Bede, Speedflo, or others having a 30:1 or higher pump ratio and a fluid tip with 0.015- to 0.026-inch (0.38- to 0.53-mm) orifice.

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.

Application Procedure

1. Flush equipment with thinner or Amercoat 12 before use.
2. Moisture sensitive. Keep both containers tightly closed until ready to use. Repeated moisture exposure shortens pot life. Applicator should be suited and spray equipment ready before resin is added to cure.
3. Stir resin thoroughly. Add to cure and mix until uniform. Do not mix more material than can be used within pot life time. Mixing ratio is 4 parts cure to 1 part resin by volume.

Pot life (hours)	°F/°C		
	90/32	70/21	50/10
487	³ / ₄	1 ¹ / ₄	2

4. When thoroughly mixed, do not stir again. Skin can form on surface of mixture. Do not break as skin may plug spray gun.
5. Thinning normally not needed; if required, use 1/2 pint Amercoat 923 per gallon. Film build reduced at 1 pint/gallon.
6. Adjust pressures for equipment configuration and environmental conditions for proper atomization.
7. Apply in even parallel passes, overlap each pass 50 percent.
8. Wet film 10 to 45 mils normally provides 8 to 30 mils (200 to 750 microns) dry film thickness.

Drying time (ASTM D1640) @ 30 mils DFT (hours)	°F/°C		
	90/32	70/21	50/10
487			
touch	1	2	4
through	6	10	36

Recoat time			
487			
minimum	3	6	9
maximum (days)*	3	7	14

Before service (days)			
severe abrasion	6	14	30
mild abrasion	3	7	14
water immersion	3	7	14
Optimum physical properties	—	30	—

*Roughen surface if maximum recoat time is exceeded.

9. Clean all equipment with thinner or Amercoat 12 immediately.

Repair

Spot blast or power tool clean bare substrate to surface preparation requirements. Feather edges of intact coating. Remove dust, dirt and contamination before recoating.

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.

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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