



AMERON
INTERNATIONAL

Performance Coatings & Finishes

Amercoat® 68A

Zinc rich epoxy primer

Product Data

- Versatile shop and field primer
- Outstanding resistance to chemicals and severe weathering
- Excellent adhesion to inorganic zincs
- Easily applied by airless or conventional spray

Amercoat 68A forms a tough, abrasion resistant film which bonds strongly to steel, Dimetecote® and existing epoxy surfaces. Zinc content of the coating gives steel cathodic protection if the film is damaged. Rapid drying permits early movement of steel when Amercoat 68A is used as a shop primer for new construction projects by steel fabricators. Applies readily by spray to produce a smooth film. It will accept epoxy, aliphatic polyurethane and high build vinyl topcoats.

Typical Uses

Amercoat 68A is used as a shop primer for bare steel on new construction or major repair projects, and as a field maintenance primer over bare steel or steel coated with organic or inorganic zinc primers and epoxy topcoats. Amercoat 68A topcoated with Amercoat 320 and 320HS epoxy topcoat provides long term protection to railroad and hopper cars carrying corrosive, dry bulk chemicals. Amercoat 68A may be used to repair itself or inorganic zinc primers.

Resistance

Amercoat 68A, when used with a suitable topcoat, has excellent resistance to weathering, water, salts, refined petroleum products, alcohols, solvents, animal and vegetable oils (up to 2¹/₂ percent free fatty acid). Amercoat 68A is not recommended for immersion service in acid or alkaline solutions. For specific recommendations, consult your Ameron representative.

Physical Data

Finish	Flat	
Color	Reddish gray	
Components	2	
Volume solids (ASTM D2697 modified)	48% ± 3%	
Dry film thickness per coat	3 mils (75 microns)	
Coats	1	
Calculated coverage	ft ² /gal	m ² /L
1 mil (25 microns)	769	18.8
3 mils (75 microns)	256	6.3
VOC	lb/gal	g/L
mixed	4.1	492
Temperature resistance (dry) 200°F (93°C) maximum		
Flash point (SETA)	°F	°C
resin	79	26
cure	89	32
Amercoat 7	102	29
Amercoat 12	2	-17

Application Data

Applied over	New or previously coated steel			
Surface preparation	Dry abrasive blast, acid pickling or power tool cleaning.			
Method	Airless or conventional spray			
Mixing ratio (by volume)	4 parts resin to 1 part cure			
Pot life (hours)	°F/°C			
	90/32	70/21	50/10	
nonaccelerated	14	24	36	
accelerated (1/4 pt 861/5 gal)	7	12	18	
Induction time	15 minutes			
Environmental conditions				
Temperature	°F		°C	
air	32 to 120		0 to 49	
surface	32 to 140		0 to 60	
Surface temperatures must be at least 5°F (3°C) above dew point to prevent condensation.				
Drying time (ASTM D1640) (hours)	°F/°C			
	90/32	70/21	50/10	32/0
nonaccelerated				
touch	1/4	1/2	1	4
through	1/2	3/4	1 1/2	6
topcoat (minimum)	2 1/2	4	6	14
accelerated (1/4 pt 861/5 gal)				
touch	—	1/3	1/2	2
through	—	1/2	1	4
topcoat (minimum)	2	3	5	10
Topcoat required	Recommended Amercoat epoxy, polyurethane and vinyl topcoats			

Application Data Summary

See Application Instructions for complete information on surface preparation, equipment, environmental conditions, application procedures and safety precautions. To obtain maximum performance, apply as recommended. 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. Abrasive blasting is usually the most effective and economical method. Prior to coating, all surfaces must be clean, dry and free of all contaminants, including salt deposits.

Safety Precautions

Read each component's material safety data sheet before use. Mixed material has hazards of each component. Safety precautions with Application Instructions must be strictly followed during storage, handling, application and drying periods. Improper use and handling of this product can be hazardous to health and cause fire and explosion.

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.

Thinner

Amercoat 7

Equipment cleaner

Thinner or Amercoat 12

Shipping Data

Packaging unit	1 gal	5 gal
cure	1-qt can	1-gal can
resin	1-gal can	5-gal can

Shipping weight (approx)

1-gal unit	lb	kg
cure	1.8	.8
resin	18	8.2
5-gal unit		
cure	8.2	3.7
resin	92	42

Shelf life when stored indoors at 40 to 100°F (4 to 38°C)

cure and 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.

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

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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