



Performance Coatings & Finishes

PSX[®] 738

Engineered Siloxane[®] coating

Patent No. 4, 113, 665

Application Instructions

Refer to the 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, in general, proportional to the degree of surface preparation. Prior to coating all surfaces must be clean, dry, undamaged and free of all contaminants, including salt deposits.

Steel or Stainless Steel Types 304 & 316 – Dry abrasive blast according to SSPC-SP10.

Concrete – Clean according to ASTM D4258.

Dimetcote[®] 9 or 21-9 – Clean dry surface. See Dimetcote 9 or 21-9 Application Instructions for complete information and safety precautions.

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.

Conventional spray – Industrial equipment such as DeVilbiss MBC or JGA spray gun. An oil and moisture trap in the main air supply line are essential. Separate regulators for air and fluid pressure and mechanical pot agitator are recommended.

Environmental Conditions

Temperature	°F	°C
air	45 to 120	7 to 49
surface	See thinner recommendations	

Relative humidity during application and initial drying		
minimum	40%	
maximum	Avoid condensation	

Surface temperatures must be at least 5°F (3°C) above dew point to prevent condensation during application and initial dry through.

Application Procedure

1. Flush equipment with thinner or Amercoat 12 before use to remove moisture. Moisture can harden Amercoat 738 in spray equipment.
2. Slowly stir powder into liquid and continue to mix until powder is well dispersed. Do not reverse order.
3. Keep mixture in covered container until ready to use, as moisture from the atmosphere can cause skinning or gelling. Do not mix more material than can be used within the expected pot life, 5 hours at 70°F and 50% R.H.
4. Agitate slowly and continuously during spray application to maintain uniform suspension.

5. Apply a wet coat in multiple passes, if necessary, to obtain desired dry film thickness. **Maintain 18" maximum distance between spray gun and surface to avoid dry spray.**

Maximum DFT (mils)

	Thinner	No. of Coats	Service Temperature °F/°C		
			112/600	750/399	500/260
Stainless steel	15/101	2	10	14	20
Steel or Dimetcote 9 and 9HS	15/101	1	-----	10	15

Important: Exceeding maximum DFT may result in PSX 738 surface cracking.

Drying time* (ASTM D1640)(hours)

	°F/°C				
	120/49	90/32	70/21	50/10	40/4
Touch @ 50% R.H.					
unthinned	1/2	1	1 1/2	2	3
thinned w/ 15 or 101**	1/2	2	3	4	6
Through @ 50% R.H.					
unthinned	14	20	28	48	72
thinned w/15 or 101**	14	26	36	60	80
Through @ 75% R.H.					
unthinned	7	10	14	24	36
thinned w/15 or 101**	7	15	18	30	40
Recoat @ 50% R.H.					
unthinned	1	2	3	5	7
thinned**	2	4	6	10	14
Recoat @ 75% R.H.					
unthinned	1	1	2	3	4
thinned**	1 1/2	3	5	8	10

Cure* (days)

Service temp. up to 1000°F – same as Dry Through time

Service temp. above 1000°F

(thinned or unthinned)

@ 50% R.H.	4	8	13	30	50
@ 75% R.H.	2 1/2	4	7	19	32

Chemical resistance (days)

@50% R.H.					
unthinned	6	10	15	40	80
thinned**	10	15	25	60	NR
@ 75% R.H.					
unthinned	3	6	10	21	40
thinned**	6	10	15	36	72

NR = Not Recommended

*Note – at 15 mils total DFT Drying and Cure times will increase by 30 %.

**Note – Thinned material at 2 coats will increase cure times.

6. Thin with recommended thinner as required for workability, see below:

Thinners

Amercoat 15 (45 to 100°F surface temperature)
Amercoat 101 (45 to 140°F surface temperature)
Amercoat 935 (140° - 200°F surface temperature)

DO NOT use Amercoat 935 below 140°F surface temperatures.

7. Clean all equipment with thinner or Amercoat 12 cleaner immediately after use.

Formerly Amercoat 738

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 storing, 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 industrial use only. Not for residential use.

Warranty

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