



AMERON
INTERNATIONAL

Performance Coatings & Finishes

Amercoat® 861

Accelerator

Product Data/ Application Instructions

Amercoat 861 is used with mixed units of Amerlock® 400, 400AL, 400GFA, Amercoat 385, 385PA and 68HS to accelerate hardening at low temperatures.

Amercoat 861 Accelerator **must not** be used with Amercoat 83HS, 320HSA, 350FD and Amerlock 400FD.

Application Instructions

1. Mix thoroughly the resin and cure components for a 5-gal unit of coating. Refer to specific product's application instructions.
2. Add recommended amount of Amercoat 861 and mix thoroughly. Add Amercoat 861 only to mixed resin and cure.
Caution: The addition of Amercoat 861 shortens pot life and reduces viscosity. Do not use more than a total of 1-pt Amercoat 861 per 5-gal unit of coating.
3. Apply product according to specific product's application instructions.
4. Refer to specific product's application instructions for maximum recoat times.
5. Do not use Amercoat 861 with white or light colors of Amerlock as color variation may result.
6. Temperatures above 50°F (10°C) reduce pot life.
7. The applied coating must be thoroughly cured before it is placed in service. See drying and cure time information.

Safety Precautions

Read material safety data sheet before use. Safety precautions must be strictly followed during storage, handling and use.

Shipping Data

Packaging	1/2-pt and 1-pt can	
Shipping weight (approx)	lb	kg
1/2-pt can	0.64	0.29
1-pt can	1.2	0.55
Shelf life when stored indoors at 40 to 100°F (4 to 38°C)	1 year from date of shipment	

Numerical values are subject to normal manufacturing tolerances and testing variances.

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

Physical Data

Color	Clear amber	
Components	1	
VOC	0.0 lbs/gal	0.0 g/L
Flash point (SETA)	°F	°C
Amercoat 861	300	149

Application Data

Mixing ratio	1/4-pt per mixed 5-gal unit of		
Amercoat	68HS, 1/2-pt per mixed 5-gal unit of Amerlock 400AL, 383HS, 385, 385P, 1/2-pt or 1-pt per mixed 5-gal unit of Amerlock 400 or 400GFA		

Pot life (hours)		°F/°C			
861 Accelerator	Amerlock	90/32	70/21	50/10	32/0
Amount	/mixed 5 gal				
None	400, 400 GFA	1 1/2	2 1/2	4	7
	400AL	3 1/2	5 1/2	10	15
1/2 pt	400, 400 GFA	1	1 1/2	2 1/2	4
	400AL	1	1 1/2	2 1/2	4
1 pt	400, 400 GFA	1/2	1	1 1/2	2
	400AL	1/2	1	1 1/2	2

Environmental conditions	Amerlock 400, 400 AL, 400GFA	
Temperature	°F	°C
air and surface	40 to 122	4 to 50
Amerlock with 861	20 to 122	-6 to 50
material (minimum)	50	10
Relative humidity	40% minimum	

Surface temperatures must be at least 5°F (3°C) above dew point to prevent condensation. At freezing temperatures, surface must be free of ice.

Drying time (ASTM D1640) (hours)

Amerlock

861 Amt	Amerlock	touch °F/°C						
/mixed 5 gal		120/49	90/32	70/21	50/10	32/0	20/-6	
None	400, 400 GFA	1 1/2	4 1/2	9	28	96	NR	
	400AL	1	4	12	36	96	NR	
1/2 pt	400, 400 GFA	1 1/2	3	5	24	72	120	
	400AL	1	1 1/2	2 1/2	5	10	24	
1 pt	400, 400 GFA	1	2	4	15	48	96	
	400AL	1	1 1/2	2 1/2	5	10	24	
through								
None	400, 400 GFA	6	12	20	40	140	NR	
	400AL	1 1/2	7 1/2	24	72	216	NR	
1/2 pt	400, 400 GFA	3	6	10	30	96	180	
	400AL	2	4	9	24	48	120	
1 pt	400, 400 GFA	2 1/2	5	9	24	72	160	
	400AL	2	4	7	16	36	120	
Cure for immersion (days)								
None	400, 400 GFA	2	4	7	21	NR	NR	
	400AL	2	4	7	21	NR	NR	
1/2 pt	400AL	1	2	3	7	21	NR	
1 pt	400, 400GFA	1	2	3	7	21	NR	

Amercoat 861 Accelerator will slightly discolor Amerlock 400 white and other Amerlock light colors. Do not use 861 Accelerator with 400FD cure.

Amercoat 68HS

Dry time (ASTM D1640) (hours)		°F/°C			
nonaccelerated		90/32	70/21	50/10	32/0
touch		1 ¹ / ₄	1 ¹ / ₂	1	NR
through		4	8	36	NR
topcoat (minimum)		1	2	6	NR
accelerated (1/4 pt 861/mixed 5 gal)					
touch			1 ¹ / ₃	1 ¹ / ₂	2
through		1 ¹ / ₂	4	16	96
topcoat (minimum)		3 ³ / ₄	11 ¹ / ₂	4	24
Pot Life		°F/°C			
nonaccelerated		90/32	70/21	50/10	
		8	16	24	
accelerated (1/4 pt 861/mixed 5 gal)		5	9	16	

Amercoat 385 or 385PA

Time before service @ 8 mils (hours)		°F/°C			
		90/32	70/21	50/10	32/0
Amt. 861					
None/mixed 5 gal		24	48	72	240
1/2 pt/mixed 5 gal		12	24	48	168
		immersion (hot)			
None/mixed 5 gal		72	168	336	NR
		36	72	168	NR
		nonimmersion			
None/mixed 5 gal		12	24	36	168
1/2 pt/mixed 5 gal		6	12	24	96

Addition of 861 Accelerator does not change 385 or 385P dry-to-touch or dry-through times but does accelerate cure for service.

Pot Life		°F/°C			
nonaccelerated 385/385P		90/32	70/21	50/10	
		1 ¹ / ₂	3	5	
accelerated with 1/2 pt 861/mixed 5 gal		1/2	1	3	

NR = Not recommended

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 to 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.

Safety Precautions

Read product's material safety data sheet before 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 solvent 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 type 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.

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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