



**AMERON**  
INTERNATIONAL

Performance Coatings & Finishes

# Amercoat® 874HS

*Heat-resistant, Low VOC modified silicone topcoat*

## Product Data/ Application Instructions

- Low VOC
- Heat-resistant to 500° F
- Resistant to thermal cycling
- Color stable to 450° F
- No bake, ambient cure

Amercoat 874HS is a high performance, heat-resistant topcoat. It is applied over Amercoat 872 modified zinc silicone primer or Dimetcote primers, as part of a complete, heat-resistant coating system.

### Typical Uses

High temperature, exterior exposures for pipes, stacks, etc.

- Chemical plants
- Power plants
- Oil production, refining plants
- Marine structures, ships

### 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 with a 30:1 pump ratio, or larger, with a fine finish tip. Use the lowest possible pressure to achieve adequate atomization while retaining film thickness control.

**Conventional spray** – Industrial equipment, such as DeVilbiss MBC 510 gun (or equal) with an “E” needle and tip and 704 air cap (or equal). A moisture and oil trap in the main air supply line and separate air and fluid pressure regulators are essential. Adjust pressure as needed to achieve adequate atomization.

### Surface Preparation

Coating performance, in general, is proportional to the degree of surface preparation. Prior to coating the primed surface must be clean, dry and free of all contaminants, including salt deposits.

**Dimetcote®** – Dimetcote must be fully cured and surface free from contamination or curing residue. Dry film thickness of the Dimetcote primer must not exceed 3 mils.

### Physical Data

Finish	Semigloss	
Color	Selected colors (see color card)	
Components	1	
Curing mechanism	Solvent loss	
Volume solids		
Colors	44 % ± 3%	
Aluminum	33%± 3%	
Dry film thickness per coat	2-2.5 mil (50-68 microns)	
Coats	1	
Theoretical coverage	ft <sup>2</sup> /gal	m <sup>2</sup> /L
Colors		
1 mil (25 microns)	705	17.3
2.5 mils (63 microns)	282	6.9
Aluminum		
1 mil (25 microns)	529	13.0
2.5 mil (63 microns)	211	5.2
VOC	lb/gal	g/L
unthinned	3.5	420
thinned (1 pt/gal)	3.9	469
Temperature resistance	Dry	
	°F	°C
Peak and continuous	500	260
Color stability*	450	232
* Black and aluminum pigmented coatings are color stable to 500° F (260° C)		
Flash point (SETA)	°F	°C
Amercoat 874HS	0	-18
Amercoat 65	78	26
Amercoat 12	2	-17

### Application Data

Applied over  
Primer

Prepared and primed steel,  
Amercoat 872, Dimetcote

*A mist coat/full coat technique may be required to minimize bubbling when applied over inorganic zinc or zinc-rich primers.*

Surface preparation  
Method

See specific primer  
Airless, conventional spray,  
roller or brush

Environmental conditions

Temperature	°F	°C
air	50 to 95	10 to 35
surface	50 to 104	10 to 40

Surface temperatures must be at least 5°F (3°C) above dew point to prevent condensation.

Drying time (hours)

	°F/°C	
90/32	70/21	50/10
touch	1/2	4
through	12	36

Recoat time (hours)

	°F/°C	
90/32	70/21	50/10
minimum	2	8
maximum	4	
	none	

Thinner

Amercoat 65

Equipment cleaner

Thinner or Amercoat 12

## Application Procedure

1. Flush all equipment with thinner or Amercoat 12 before use.
2. Stir material thoroughly to a uniform consistency.
3. If necessary for workability, thin with up to 1 pint of Amercoat 65 per gallon of Amercoat 874HS.
4. Apply a wet coat in even, parallel passes, holding the spray gun at a right angle 10-12 inches from the surface. Overlap 50 percent to avoid holidays, bare areas and pinholes. If required, cross spray at right angles. Over inorganic zincs, a mist coat/full coat technique may be required to minimize bubbling.
5. When dry to touch, check film thickness with non-destructive dry film thickness gauge such as Elcometer or Mikrotest. Recoat if greater thickness is required. Do not exceed 2.5 mils dry film thickness.
6. Clean all equipment with thinner or Amercoat 12 immediately after use.

## Safety Precautions

Read material safety data sheet before use. 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 industrial use only. Not for residential use.***

## Shipping Data

Packaging	1-and 5-gal units	
Shipping weight (approx)	lb	kg
1-gal	13.3	6.0
5-gal	66.5	30.2

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

1 year from manufacture date

Numerical values are subject to normal manufacturing tolerances, color and testing variances. Allow for application losses and surface irregularities.

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

## 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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