



Performance Coatings & Finishes

Dimetcote® 9

Inorganic-zinc silicate primer

Application Instructions

Refer to the specific Dimetcote 9 Product Data Sheets for properties and uses.

Surface Preparation

Steel – New without pits or depressions – Dry abrasive blast, SSPC-SP6 or pickle.

Previously painted or pitted – Dry abrasive blast, SSPC-SP10. Remove all traces of previous organic coatings as Dimetcote 9 will not adhere to organic coatings.

Blast to achieve a 1- to 2-mil (25- to 50-microns) profile as determined with a Keane-Tator Surface Profile Comparator, Testex Tape or similar device. Rougher profiles are acceptable but require increased film thickness for equivalent protection.

Apply Dimetcote 9 as soon as possible to avoid rusting or other recontamination. Do not leave blasted steel uncoated overnight. Spot reblast if needed.

Galvanizing – Remove oil, soap film or grease with neutral detergent or emulsion cleaner and blast lightly with fine abrasive to SSPC-SP7.

Environmental Conditions

Temperature	°F	°C
air	0 to 120	-18 to 49
surface	0 to 130	-18 to 54

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

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, such as Graco Bulldog Hydra-Spray or Speeflo Alaskan PZ and a fluid tip with a 0.021-inch (0.53 mm) orifice or larger

Conventional spray – Industrial equipment such as a DeVilbiss MBC gun with 2E or 704E cap/tip, or a Binks 18 gun with a 66SS x 67PB nozzle setup. A variable speed agitator in the pressure pot and an oil and moisture trap in the main air supply line are essential. Separate air and fluid pressure regulators are recommended.

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

Application Procedure

Dimetcote 9 is packaged in the correct proportions which must be mixed together before use.

1. Flush all equipment with thinner or Amercoat® 12 to remove any moisture which that may be present. Moisture can cause hardening of coating in equipment.
2. Stir liquid with an explosion-proof power mixer.

3. Discard desiccant bag from powder can and gradually stir powder into liquid. Continue stirring until powder is well dispersed, and uniformly blended to a workable consistency.
4. Strain material through 30 mesh screen to remove undispersed material and to prevent possible clogging of equipment.
5. Do not mix more coating than will be used within the following times:

Pot life (hours)	°F/°C			
	120/49	90/32	70/21	50/10
	4	12	24	72

Important – At the end of the pot life, “kick-out” or separation of liquid and solids occurs, together with gassing. Do not keep mixed material which will not be used before the end of the pot life in tightly closed containers as gassing can create enough pressure to cause containers to burst. Cover containers loosely.

6. Keep containers loosely covered until ready to use to prevent skinning or gelling due to moisture in air. Skins should be skimmed off the top and the material strained through cheesecloth or 30 mesh screen to remove any remaining pieces of skin. Discard gelled material.
 7. Thin only for workability or when a rough film or “dry spray” is obtained due to fast solvent evaporation during hot weather or high wind. Use no more than 1 pint thinner per gallon mixed coating, as follows:
- | Surface temperature | Thinner |
|---------------------|--------------|
| above 70°F | Amercoat 101 |
| below 70°F | Amercoat 65 |
8. Adjust spray equipment to apply an even wet coat with minimum overspray.
 9. Continue slow stirring during application to maintain uniformity of material. Avoid fast stirring as this may cause a rise in material temperature, shortening pot life.
 10. Apply in even, parallel passes; overlap each pass 50 percent. Pay special attention to welds, cut-outs, sharp edges, rivets, bolts, etc., to insure proper thickness. Keep pressure pot at approximately the same elevation as spray gun for proper material delivery to gun.
 11. Prevent contact with water until the freshly applied coating is dry to touch.

Drying time (ASTM D1640) 2½ mils and 50-90% RH

	°F/°C	
	70/21	
touch (minutes)	10	
through (minutes)	18	
topcoat with most topcoats (hours)	24	

Exception: Time to topcoat directly with vinyl coating without a tie coat will vary and can be as long as one week for proper adhesion and/or absence of application blistering. Obtain specific recommendation from your Ameron representative.

12. When dry through, check film thickness with a nondestructive dry film thickness gauge. Recoat if greater thickness is required. Normal recommended thickness is 2½ mils. Allowable thickness range is 2 to 8 mils, assuming the surface profile is within the recommended range. Greater thicknesses may develop cracking.

Note – Drying and topcoating times will be longer when film thickness is over 2¹/₂ mils, ventilation and air movement are restricted, temperatures are lower or relative humidities are lower. A water mist sprayed over the coating when the film is dry to touch will accelerate hardening at lower humidities.

13. Random pinholes, holidays and small damaged or bare areas can be touched up by brush when film is dry to touch. Larger areas should be resprayed.

14. In confined areas, ventilate with clean air during application and drying until all solvents are removed. Temperature and relative humidity of the ventilating air must be such that moisture will not condense on the surface until after dry to touch.

15. Clean equipment with thinner or Amercoat 12 cleaner immediately after use or at least at the end of each working day or shift. Clean spray guns more often during hot weather. When left in equipment, Dimetcote 9 will harden and plug spray equipment.

Topcoating

Dimetcote 9 surface must be clean and dry before topcoating. Water soluble contaminants may be washed off with water. Remove grease and similar contaminants with an emulsion type cleaner or neutral detergent. Rinse with clean water and allow to dry. Solvent wiping is not satisfactory as contamination may only be spread and not removed. In some cases a mist coat/full coat technique may be required to prevent application bubbling.

Repair

Spot-blast rusted areas in accordance with surface preparation instructions before touching up with Dimetcote 9. When blasting is not practical, Amercoat 68HS may be used for repair. See primer product literature for selection according to topcoat compatibility.

Safety Precautions

Read each component's material safety data sheet before use. Mixed product has hazards of each component. 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 professional 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.**



Ameron U.S.A. • 13010 Morris Rd, Suite 400, Alpharetta, GA 30004 • (678) 393-0653

Ameron B.V. • J.F. Kennedylaan 7, 4191 MZ Geldermalsen, The Netherlands • (31) 345-587-587