

AMERCOAT® 132

DESCRIPTION

Two-component, zinc epoxy primer

PRINCIPAL CHARACTERISTICS

- High build anticorrosive zinc epoxy primer
- Forms durable coating systems with a wide range of topcoats
- Excellent compatibility with old existing coatings
- Easily applied by airless or conventional spray and brush
- Tough and adherent primer providing excellent resistance to corrosion

COLOR AND GLOSS LEVEL

- Greenish gray
- Flat

BASIC DATA AT 20°C (68°F)

Data for mixed product	
Number of components	Two
Mass density	2.1 kg/l (17.8 lb/US gal)
Volume solids	51 ± 2%
VOC (Supplied)	Directive 1999/13/EC, SED: max. 224.0 g/kg
Recommended dry film thickness	75 µm (3.0 mils) per coat
Theoretical spreading rate	6.7 m ² /l for 75 µm (273 ft ² /US gal for 3.0 mils)
Overcoating Interval	Minimum: 4 hours
Shelf life	Base: at least 24 months when stored cool and dry Hardener: at least 24 months when stored cool and dry

Note: See ADDITIONAL DATA – Curing time

AMERCOAT® 132

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

Steel

- Steel; blast cleaned to ISO Sa 2½ or SSPC-SP-10, blasting profile 25 – 50 µm (1.0 – 2.0 mils)
- Compatible previous coat must be dry and free from any contamination
- For mild exposures, power tool cleaned to ISO-St3 is acceptable

Notes:

- Apply primer as soon as possible after surface preparation to prevent any contamination.
- In case of contamination remove contaminants.
- Spot blast steel if needed.

Substrate temperature and application conditions

- Surface temperature during application should be between 5°C (41°F) and 60°C (140°F)
- Surface temperature during application should be at least 3°C (5°F) above dew point
- Ambient temperature during application and curing should be between 5°C (41°F) and 50°C (122°F)

INSTRUCTIONS FOR USE

Mixing ratio by volume: base to hardener 80:20 (4:1)

- Pre-mix base component with a pneumatic air mixer at moderate speeds to homogenize the container
- Add hardener to base and continue stirring until homogeneous
- The thinner should be added after mixing the two components
- Adding too much thinner results in reduced sag resistance

Induction time

15 minutes at 20°C (68°F)

Pot life

8 hours at 20°C (68°F)

Application

- Stir during application to maintain uniformity of material. Apply a wet coat even, parallel passes. Overlap each pass 50% to avoid bare areas, pinholes or holidays.
- Double coat all welds, rough spots, sharp edges and corners, rivets, bolts, etc.

AMERCOAT® 132

Air spray

Recommended thinner

THINNER 91-83

Volume of thinner

0 - 10%, depending on required thickness and application conditions

Nozzle orifice

1.5 – 3.0 mm (approx. 0.060 – 0.110 in)

Nozzle pressure

0.3 - 0.4 MPa (approx. 3 - 4 bar; 44 - 58 p.s.i.)

Airless spray

- 28:1 pump or larger

Recommended thinner

THINNER 91-83

Volume of thinner

0 - 5%, depending on required thickness and application conditions

Nozzle orifice

Approx. 0.38 – 0.53 mm (0.015 – 0.021 in)

Nozzle pressure

15.0 - 20.0 MPa (approx. 150 - 200 bar; 2176 - 2901 p.s.i.)

Brush/roller

- Only for touch-up and spot repair

Recommended thinner

THINNER 91-83

Volume of thinner

0 – 10%

Cleaning solvent

THINNER 90-58

Note: All application equipment must be cleaned immediately after use

AMERCOAT® 132

ADDITIONAL DATA

Curing time for DFT up to 75 µm (3.0 mils)

Substrate temperature	Dry to handle
20°C (68°F)	4 hours

Notes:

- Drying times are dependent on air and steel temperature, applied film thickness, ventilation and other environmental conditions
- Times are proportionally shorter at higher temperature and longer at lower temperatures

Pot life (at application viscosity)

Mixed product temperature	Pot life
20°C (68°F)	8 hours

Notes:

- Since the pot life is limited and shortened by high temperatures, do not mix more material that will be used within the pot life period
- Pot life and drying times are dependent on air and steel temperature, applied film thickness, ventilation and other environmental conditions

SAFETY PRECAUTIONS

- Since improper use and handling can be hazardous to health and cause of fire or explosion, safety precautions included with Product Data/Application Instruction and Material Safety Data Sheet must be observed during all storage, handling, use and drying periods
- Adequate ventilation to remove solvent must be maintained during application and curing

WORLDWIDE AVAILABILITY

It is always the aim of PPG Protective and Marine Coatings to supply the same product on a worldwide basis. However, slight modification of the product is sometimes necessary to comply with local or national rules/circumstances. Under these circumstances an alternative product data sheet is used.

REFERENCES

- | | | |
|--------------------------------------|-------------------|------|
| • CONVERSION TABLES | INFORMATION SHEET | 1410 |
| • EXPLANATION TO PRODUCT DATA SHEETS | INFORMATION SHEET | 1411 |

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AMERCOAT® 132

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