

# 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 <sup>2</sup> /l for 75 µm (273 ft <sup>2</sup> /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

## 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.



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## **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)
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## **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
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### **Induction time**

15 minutes at 20°C (68°F)

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### **Pot life**

8 hours at 20°C (68°F)

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### **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.
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### **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.)

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**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

**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

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## 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

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

## WARRANTY

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