



AMERON
INTERNATIONAL

Performance Coatings & Finishes

Amercoat® 68HS

Zinc rich epoxy primer

Product Data

- Outstanding resistance to chemicals and severe weathering
- Excellent adhesion to inorganic zincs
- Easily applied by airless or conventional spray
- Amercoat 861 Accelerator can be used for low temperature curing.

Typical Uses

Amercoat 68HS is a shop primer for bare steel on new construction or major repair projects, and as a field maintenance primer over bare steel or steel coated with organic or inorganic zinc primers and epoxy topcoats such as, Amercoat 385, Amerlock® 400 or Amershield™. Amercoat 68HS may be used to repair itself or inorganic zinc primers.

Surface Preparation

Coating performance, in general, is proportional to the degree of surface preparation. Surface must be clean, dry and free of all contaminants.

Typical Properties

Adhesion, Elcometer D4541 1000 psi

Qualifications

AASHTO – Standard Specification for Highway Bridges Table 10.32.3C Allowable Load for Slip Critical Connections Class B

AISC – Specification for Structural Joints Using ASTM A325 or A490 Bolts RCSC Specification for Structural Joints Table 3 Class B

Physical Data

Finish	Flat	
Color	Reddish gray	
Components	3	
Volume solids (ASTM D2697 modified)	70% ± 3%	
Coats	1	
Dry film thickness per coat	3 mils (75 microns)	
Theoretical coverage	ft ² /gal	m ² /L
1 mil (25 microns)	1123	27.5
3 mils (75 microns)	374	9.2
VOC	lb/gal	g/L
mixed	2.4	288
mixed/thinned (1/2 pt/gal)	2.8	335
Temperature resistance, dry continuous (maximum)	°F	°C
	200	93
Flash point (SETA)	°F	°C
cure	110	43
resin	82	28
mixed	82	28
Amercoat 65	78	25
Amercoat 12	2	-17

Application Data

Applied over	Steel			
Surface preparation	SSPC-SP3, 6 or 10			
Method	Airless or conventional spray			
Mixing ratio (by volume)	1- or 5-gal unit package			
Pot life (hours)	°F/°C			
	90/32	70/21	50/10	
nonaccelerated	8	16	24	
accelerated (1/4 pt 861/5 gal)	5	9	16	
Environmental conditions				
Temperature	°F		°C	
air	32 to 120	0 to 49		
surface	32 to 140	0 to 60		
material (minimum)	40	4		
Surface temperatures must be 5°F (3°C) above the dew point to prevent condensation.				
Drying time (ASTM D1640) (hours)	°F/°C			
	90/32	70/21	50/10	32/0
nonaccelerated				
touch	1/4	1/2	1	NR
through	4	8	36	NR
topcoat (minimum)	1	2	6	NR
topcoat (maximum months)	6	6	6	NR
accelerated (1/4 pt/861/5 gal)				
touch	–	1/3	1/2	2
through	11/2	4	16	96
topcoat (minimum)	3/4	1 1/2	4	24
topcoat (maximum months)	6	6	6	6

NR = Not Recommended

Application Data Summary

See Application Instructions for complete information on surface preparation, equipment, environmental conditions and application procedures. To obtain maximum performance, apply as recommended. For conditions outside the requirements or limitations described, contact your Ameron representative.

Safety Precautions

Read each component's material safety data sheet before mixing. Mixed material has hazards of each component. Safety precautions must be strictly followed during storage, handling and use.

This product is for industrial 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.

Thinner
Equipment cleaner

Amercoat 65
Thinner or Amercoat 12

Shipping Data

Packaging units	1 gal	5 gal
cure	1-qt can	1-gal can
resin	1-gal can	5-gal can
powder	1-gal can	EnviroPac
Shipping weight (approx)	lb	kg
1-gal unit		
cure	2	0.9
resin	5.4	2.5
powder	20.2	9.2
5-gal unit		
cure	8.4	3.8
resin	26.6	12
powder	98.5	44.7

Shelf life when stored indoors at 40 to 100°F (4 to 38°C)
cure, resin, powder 1 year from shipment date

Numerical values are subject to normal manufacturing tolerances, color and testing variances. Allow for application losses and surface irregularities. See application instructions for complete information and safety precautions.

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

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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