

AMERCOAT® 185 H

DESCRIPTION

Universal phenolic alkyd primer

PRINCIPAL CHARACTERISTICS

- VOC Compliant <2.8 lb/ gal
- Corrosion inhibitive formula
- Accepts a broad range of topcoats
- Can be topcoated in 2-4 hours
- Compliant with 40 CFR Part 63 subpart M for new and existing facilities
- Unlimited recoatable

COLOR AND GLOSS LEVEL

- Red oxide, off white, gray
- Flat

BASIC DATA AT 68°F (20°C)

Data for product	
Number of components	One
Volume solids	60 ± 2%
VOC (Supplied)	max. 2.8 lb/US gal (approx. 335 g/l)
Temperature resistance (Continuous)	To 200°F (93°C)
Recommended dry film thickness	2.0 - 3.0 mils (50 - 75 µm) depending on system
Theoretical spreading rate	481 ft ² /US gal for 2.0 mils (12.0 m ² /l for 50 µm)
Shelf life	At least 36 months when stored cool and dry

Notes:

- See ADDITIONAL DATA - Overcoating intervals
- See ADDITIONAL DATA - Curing time
- Color will drift at elevated temperatures

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

- Coating performance is, in general, proportional to the degree of surface preparation

Steel

- Remove all rust, dirt, moisture, grease or other contaminants from the surface
- Power tool clean in accordance with SSPC SP-3 or hand tool clean to SSPC SP-2 requirements. Alternately, abrasive blast to SSPC SP-7 requirements. Abrasive blasting to SSPC SP-6 or better is also allowable and will give the best possible system performance



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Non-ferrous metals and stainless steel

- Remove all rust, dirt, moisture, grease or other contaminants from the surface
- Treat with conversion coatings or phosphatizing agents. Applicable over surface treatments such as MIL-C-5541. Alternately, lightly abrasive blast with fine abrasive to produce a uniform and dense anchor profile of 1.0 – 3.0 mils (25 – 75 µm) in accordance with SSPC SP-16.

Galvanized steel

- Remove oil or soap film with detergent or emulsion cleaner, then use a phosphatizing conversion coating
- Not recommended over chromate sealed galvanizing

Substrate temperature and application conditions

- Surface temperature during application should be between 45°F (7°C) and 120°F (49°C)
- Surface temperature during application should be at least 5°F (3°C) above dew point
- Ambient temperature during application and curing should be between 45°F (7°C) and 100°F (38°C)
- Relative humidity during application and curing should not exceed 85%

SYSTEM SPECIFICATION

- Primers: Direct to substrate, application over aged coatings that are cleaned and abraded
- Topcoats: AMERCOAT 450-series polyurethanes, AMERSHIELD, PSX 700, AMERCOAT 229T, AMERCOAT Epoxies, AMERLOCK Epoxies, PSX 1001, PSX ONE, AMERCOAT 5400-Series Alkyds, 7-line Alkyds

Note: A test patch is recommended

INSTRUCTIONS FOR USE

- Agitate with a power mixer for 1 – 2 minutes until completely dispersed. Ensure good off-bottom mixing

Application

- Area should be sheltered from airborne particulates and pollutants
- Ensure good ventilation during application and curing
- Provide shelter to prevent wind from affecting spray patterns

Material temperature

Material temperature during application should be between 50°F (10°C) and 90°F (32°C)



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Air spray

- Separate air and fluid pressure regulators and a moisture and oil trap in the main air supply line are recommended.
- Use standard conventional equipment

Recommended thinner

THINNER 21-06 (AMERCOAT 65) (xylene), THINNER 21-25 (AMERCOAT 101) (recommended for > 90°F (32°C))

Volume of thinner

0 - 20%

Nozzle orifice

Approximately 0.070"

Airless spray

- 30:1 pump or larger

Nozzle orifice

0.013 - 0.015 in (approx. 0.33 - 0.38 mm)

Brush/roller

- Use a high-quality, natural-bristle brush and/or solvent-resistant, 0.25 in (64 mm) nap roller. Ensure the brush/roller is well-loaded to avoid air entrainment. Level air bubbles with a brush. Multiple coats may be necessary to achieve adequate film build

Recommended thinner

AMERCOAT 185H is typically used without thinning. If thinning is desired, use AMERCOAT 65 (xylene) or AMERCOAT 101 (recommended for >90°F (32°C))

Cleaning solvent

Amercoat 12 Cleaner (Thinner 90-58) or Amercoat 65 Thinner (Thinner 21-06)

ADDITIONAL DATA

Overcoating interval for DFT up to 3.0 mils (75 µm)				
Overcoating with...	Interval	50°F (10°C)	70°F (21°C)	90°F (32°C)
itself	Minimum	5 hours	2 hours	1.5 hours
	Maximum	Unlimited	Unlimited	Unlimited

Note: Dry times are dependent on air and surface temperatures as well as film thickness, ventilation, and relative humidity. Surface temperatures should be monitored, especially with sun-exposed or otherwise heated surfaces. Surface must be clean and dry. Any contamination must be identified and removed

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

Substrate temperature	Dry to touch	Dry hard
50°F (10°C)	1.5 hours	1 hour
70°F (21°C)	30 minutes	45 minutes
90°F (32°C)	20 minutes	30 minutes

Note: Drying times are dependent on air and surface temperatures as well as film thickness, ventilation and relative humidity

Product Qualifications

- Performance offset to Federal Standards TT-P-645, TT-P-664, and TT-P-1385
- MPI Category #76 – Quick drying alkyd metal primer
- IMO SOLAS approved per FTP code in a system with AMERCOAT 5420

SAFETY PRECAUTIONS

- For paint and recommended thinners see INFORMATION SHEETS 1430, 1431 and relevant Material Safety Data Sheets
- Although this is a solvent-free paint, care should be taken to avoid inhalation of spray mist, as well as contact between the wet paint and exposed skin or eyes

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
• SAFETY INDICATIONS	INFORMATION SHEET	1430
• SAFETY IN CONFINED SPACES AND HEALTH SAFETY, EXPLOSION HAZARD – TOXIC HAZARD	INFORMATION SHEET	1431

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Packaging: Available in 1-gallon and 5-gallon kits

Product code	Description
AT185H-278	Gray
AT185H-3	Off White
AT185H-724	Oxide Red

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