

# AMERCOAT® 4119

## DESCRIPTION

Two-component zinc rich epoxy primer

## PRINCIPAL CHARACTERISTICS

- >80% zinc in dry film
- Provides outstanding corrosion resistance
- Fast dry times for rapid topcoating

## COLOR AND GLOSS LEVEL

- Reddish gray
- Flat

## BASIC DATA AT 68°F (20°C)

| Data for mixed product         |  |
|--------------------------------|--|
| Number of components           | Two  |
| Volume solids                  | 68 ± 3%  |
| VOC (Supplied)                 | max. 2.3 lb/US gal (approx. 281 g/l)   |
| Recommended dry film thickness | 2.5 - 4.0 mils (64 - 101 µm) depending on system   |
| Theoretical spreading rate     | 363 ft <sup>2</sup> /US gal for 3.0 mils (14.0 m <sup>2</sup> /l for 76 µm)                                |
| Shelf life                     | Base: at least 24 months when stored cool and dry<br>Hardener: at least 24 months when stored cool and dry |

### Notes:

- See ADDITIONAL DATA - Overcoating intervals
- See ADDITIONAL DATA - Curing time

## RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

- Coating performance is proportional to the degree of surface preparation. All previous coats must dry and free of contaminants

### Steel

- Abrasive blast with an angular abrasive to an SSPC SP-6 or higher. Achieve a surface profile of 1.0 - 3.0 mils (25 - 75 µm)
- Higher surface profiles up to 5 mils (125 µm) are acceptable, but the product must be applied in a thickness great enough to achieve a minimum of 2.5 mils (65 µm) dry film thickness
- Apply this product as soon as possible to prevent blasted surface from rusting.
- Keep moisture, oil, grease and other organic matter off surface before coating
- For touch up and repair, power tool cleaning in accordance with SSPC SP-11 is acceptable



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## **Substrate temperature and application conditions**

- Ambient temperature during application and curing should be between 32°F (0°C) and 120°F (49°C)
- Surface temperature during application should be between 40°F (4°C) and 120°F (49°C)
- Surface temperature during application should be at least 5°F (3°C) above dew point
- Relative humidity during application and curing should not exceed 85%

Note: If abrasive blast preparation is not possible, use SSPC-SP11, power tool cleaning to bare metal (ISO-St3)

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## **SYSTEM SPECIFICATION**

- Primers: Direct to metal, can be used to touch up inorganic zincs such as DIMETCOTE 9-SERIES
  - Topcoats: AMERSHIELD, PSX 700, AMERCOAT 450 H, AMERLOCK 2/400, AMERCOAT 385, AMERCOAT 370, AMERCOAT Epoxies, PITTPROTECT Epoxies, DURATHANE DTM, PITTPROTECT ULTRA
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## **Mix as packaged**

- Pre-mix base component with a pneumatic air mixing at moderate speeds to homogenize the container. Add hardener to base and agitate with a power mixer for 2-3 minutes until completely dispersed
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## **Pot life**

8 hours at 70°F (21°C)

Note: See ADDITIONAL DATA – Pot life

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## **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 41°F (5°C) and 90°F (32°C)

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## **Air spray**

- A moisture and oil trap in the main line is essential. Product is sensitive to moisture contamination
- 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 - 10%

## **Nozzle orifice**

Approx. 0.070 in (1.8 mm)



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**Airless spray**

- 45:1 pump or larger

**Recommended thinner**

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

**Nozzle orifice**

Approx. 0.43 – 0.53 mm (0.017 – 0.021 in)

**Brush/roller**

- Use a high-quality natural-bristle brush. Brush application is only recommended for small touch-up and/or repair areas. Roller application is not recommended
- 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**

Thinner 21-06 (Amercoat 65, 97-727, xylene) or Thinner 21-25 (Amercoat 101) for temperatures > 90 F.

**Cleaning solvent**

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

Note: All application equipment must be cleaned immediately after use

**ADDITIONAL DATA**

| Overcoating interval for DFT up to 3.0 mils (75 µm)    |          |            |             |             |             |
|--|----------|------------|-------------|-------------|-------------|
| Overcoating with...                                    | Interval | 40°F (4°C) | 50°F (10°C) | 70°F (21°C) | 90°F (32°C) |
| various epoxy coatings, polyurethane coatings, and PSX | Minimum  | 24 hours   | 10 hours    | 4 hours     | 2 hours     |
|  | Maximum  | Extended   | Extended    | Extended    | Extended    |

Note: Before overcoating, ensure surface is clean and free from zinc salts and other contamination

| Curing time for DFT up to 3.0 mils (75 µm) |              |               |
|--|--------------|---------------|
| Substrate temperature                      | Dry to touch | Dry to handle |
| 40°F (4°C)                                 | 5 hours      | 36 hours      |
| 50°F (10°C)                                | 2 hours      | 16 hours      |
| 70°F (21°C)                                | 45 minutes   | 4 hours       |
| 90°F (32°C)                                | 20 minutes   | 1.5 hours     |



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| Pot life (at application viscosity) |          |
|-------------------------------------|----------|
| Mixed product temperature           | Pot life |
| 50°F (10°C)                         | 16 hours |
| 70°F (21°C)                         | 8 hours  |
| 90°F (32°C)                         | 4 hours  |

## Product Qualifications

- SSPC Paint 20, Type II, Level 2
- Zinc dust meets ASTM D520 type 2 standards

## SAFETY PRECAUTIONS

- For paint and recommended thinners see INFORMATION SHEETS 1430, 1431 and relevant Material Safety Data Sheets
- This is a solvent-borne paint and care should be taken to avoid inhalation of spray mist or vapor, 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 kits

| Product code | Description       |
|--------------|-------------------|
| AT4119-2     | Reddish Gray Base |
| AT4119-B     | Hardener          |

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