

Application Instructions

Dimetcote 11 is a single pack, self curing, solvent based inorganic zinc silicate used as a heavy duty primer or as a single coat protective coating in recommended services. Refer to Dimetcote 11 product data sheet for properties and uses. To obtain the maximum performance for which Dimetcote 11 is formulated, strict adherence to all application instructions, precautions conditions and limitations is necessary. If conditions exist that are not within the requirements or limitations described, consult your Ameron representative.

Surface Preparation

STEEL - Dry abrasive blast in accordance with Swedish Standard Sa 2½ SIS 05 5900 - 1967, ISO 8501-1 or Steel Structures Painting Council SP-10.

NOTE: Blast to achieve a 35 to 65 µm anchor profile as indicated with *Testex* Tape or similar device. Rougher profiles are acceptable but require increased film thickness for equivalent protection.

Remove abrasive residues or dust from surface.

Apply Dimetcote 11 as soon as possible to avoid rusting or other contamination. Do not leave blasted steel uncoated overnight. Spot reblast if needed.

STEEL COATED WITH DIMETCOTE STEEL PRIMER 210 OR 215 - Dependent on condition of shopprimer, Dimetcote 11 may be applied without sweepblasting. However, a specific recommendation should be obtained from your Ameron representative.

Application Equipment

The following equipment is listed as a guide and suitable equipment from other manufacturers may be used.

Adjustments of pressure and change of tip size may be needed to obtain the proper spray characteristics.

AIRLESS SPRAY - Standard airless spray equipment, such as Graco Hydra-Spray or others, with a fluid tip with a 0.53 mm (0.021 inch) orifice or larger.

CONVENTIONAL SPRAY - Industrial spray equipment such as a DeVilbiss MBC or JGA gun with 704E or 765E cap/tip with leather or teflon needle packing and heavy mastic spring. A variable speed agitator in the pressure pot and an oil and moisture trap in the main air supply line are essential. Separate air and fluid pressure regulators are recommended.

MIXER - Use a power mixer powered by an air motor or an explosion proof electric motor.

Environmental Conditions

Air temperature -5 to 50°C

Steel temperature -5 to 55°C

To prevent moisture condensation during application, surface temperature must be at least 3°C above dew point. At freezing temperatures surface must be free of ice.

Application Procedure

Dimetcote 11 is a one component material, and 8 liter is packaged in a 10 liter can.

Thinner/cleaner Amercoat 65

1. Flush all equipment with recommended cleaner to remove any moisture that may be present. Moisture can cause hardening of Dimetcote 11 in equipment.
2. Stir Dimetcote 11 with an explosion proof power mixer. NOTE: Dimetcote 11 may show a soft settlement of zinc on the bottom of the can. This settlement must be completely redispersed in the liquid.
3. Strain material through 60 mesh screen to prevent possible clogging of equipment.
4. Thinning is normally not required. Thin only for workability or when a rough film or "dry spray" is obtained because of fast solvent evaporation during hot weather or high wind. Use not more than approximately 10 vol % of Amercoat 65 thinner. Do not use any other thinner.
5. Keep containers loosely covered until ready to use to prevent skinning or gelling due to moisture in air. Skins should be skimmed off the top and the material strained through cheese-cloth or 60 mesh screen to remove any remaining pieces of skin. Discard gelled material.
6. Adjust spray equipment to apply an even wet coat with minimum overspray.
7. Continue slow stirring during application to maintain uniformity of material.
8. Apply in even, parallel passes, overlapping each pass 50%. Pay special attention to welds, cut-outs, sharp edges, rivets, bolts, etc., to insure proper thickness. Keep pressure pot at approximately the same level as spray gun for proper material delivery to gun.
9. When dry through, check film thickness with a non-destructive dry film thickness gauge. Recoat if greater thickness is required. Normal recommended thickness is 65 µm. Dimetcote 11 is tolerant to higher film thickness, up to 150 µm in one spray application. Greater thickness may develop mudcracking of the dry film. When the coating is not sound and well adhering due to mudcracking or dry spray, it should be removed and reapplied at the specified thickness.
10. Random pinholes, holidays and small damaged or bare areas can be touched up by brush when film is dry to touch. Larger areas should be resprayed.
11. Prevent contact with water until the freshly applied coating is at least dry to touch.

12. In confined areas, ventilate with clean air during application and drying until all solvents are removed. Temperature and relative humidity of the ventilating air must be such that moisture will not condense on the surface.
13. Clean equipment with recommended cleaner immediately after use or at least at the end of each working day or shift. Clean spray guns more often during hot weather. When left in equipment, Dimetcote 11 will harden and plug spray equipment.

Drying Times

(at 65 µm dry film thickness and 50-95% RH)

	10°C	20°C
dry to touch (minutes)	10	7
dry to handle (minutes)	30	20
dry to topcoat (hours)	24	16

Drying times are dependent on the temperature, film thickness, ventilation and other environmental conditions. Times are proportionally shorter at higher temperatures and longer at lower temperatures.

Topcoating

Dimetcote 11 surface must be clean and dry before topcoating. Water soluble contaminants may be washed off with water. Oil, grease and similar contaminants may be removed with an emulsion type cleaner such as Amercoat 57 oil cleaner. Rinse with clean water and allow to dry. Solvent wiping is not satisfactory as contamination may only be spread and not removed.
NOTE: a mist coat / full coat may be required when applying a subsequent coat on top of Dimetcote 11 to prevent application bubbling. Consult your Ameron representative for recommendations.

Repair

Rusted areas must be spotblasted in accordance with instructions under **Surface Preparation** before touching up with Dimetcote 11. When blasting is not practical, Amercoat 68 or 160HF zinc-based primers may be used for repair. See product literature for these primers for selection according to topcoat compatibility.

Caution

Dimetcote 11 is highly flammable. Keep away from heat and open flame. Keep container closed. Use with adequate ventilation. Avoid prolonged and repeated contact with skin. If used in confined areas, observe the following precautions to prevent hazards of fire or explosion or damage to health:

1. circulate adequate fresh air continuously during application and drying;
2. use fresh air masks and explosion proof equipment;
3. prohibit all flames, sparks, welding and smoking.

Do not empty into drains. Take precautionary measures against static discharges.

Safety

Since improper use and handling can be hazardous to health and cause fire or explosion, safety precautions included with application instructions must be observed during all storage, handling, use and drying periods. To avoid any confusion that may arise through translation into other languages, the English version of the Product Data/Application instructions will be the governing literature and must be referred to in case of deviations with product literature in other languages.

Warranty

Ameron warrants its products to be free from defects in material and workmanship. Ameron's sole obligations 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 response to specific enquiry, or otherwise, is based on data believed to be reliable; however, the products and information are intended for use by Buyer's having requisite skill and know-how in the industry, and therefore it is 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, as its sole discretion and risk. Variation in environment, changes in procedures of use, or extrapolation of data may cause unsatisfactory results.

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.

Conditions of Sale

All our transactions are subject to our Terms and Conditions of Sale.

If welding is to be performed in confined spaces on steel coated with Dimetcote 11 do so in accordance with instructions in U.S.A. Standard Z 49.1-1973. For specific information on hazardous ingredients, required ventilation, possible consequences of contact, and safety measures see Safety Data Sheet.

