



AMERON
INTERNATIONAL

Performance Coatings & Finishes

Dimetcote® 302

Reinforced inorganic-zinc primer

Product Data/ Application Instructions (For Marine & Offshore use)

- Applies easier than any other inorganic zinc by all application equipment—spray, roller, brush, or even dip.
- Can be top coated with most organic type coatings as soon as Dimetcote 302 is solvent free, usually in 30 minutes.
- An excellent cathodic protection primer for most corrosion conditions
- Can be used with all Ameron's High Performance Coating systems
- Zinc dust is already mixed into the liquid base
- Good resistant to dry spray, mudcracking and top coat bubbling

Typical Uses

Dimetcote 302 Primer is a proven cathodic primer for protecting steel.

On all types of ships and barges, offshore platforms, drilling rigs and all marine structures

Dimetcote 302 Primer is ideal for touch-up and repair because of its ease of mixing, ease of application, fast recoat and wide compatibility.

Surface Preparation

Steel—New without pits or depressions – Dry abrasive blast, SSPC-SP6 or pickle.

Previously painted or pitted—Dry abrasive blast, SSPC-SP10. Remove all traces of previous organic coatings as Dimetcote 302 will not adhere to organic coatings.

Blast to achieve a 1 1/2 to 2 1/2 mil (37 to 62 microns) profile as determined with a Keane-Tator Surface Profile Comparator, Testex Tape or similar device. Rougher profiles are acceptable but require increased film thickness for equivalent protection.

Apply Dimetcote 302 as soon as possible to avoid rusting or other recontamination. Do not leave blasted steel uncoated overnight. Spot reblast if needed.

Galvanizing—Remove oil, soap film or grease with neutral detergent or emulsion cleaner. Use a zinc treatment such as Galvaprep® or equivalent or blast lightly with fine abrasive.

Environmental Conditions

Temperature	°F	°C
air	0 to 120	-18 to 49
surface	0 to 130	-18 to 54

Surface temperature must be at least 5°F (3°C) above dew point to prevent condensation. At freezing temperatures, surface must be free of ice.

Physical Data

Finish	Flat	
Color	Green	
Components	2	
Curing mechanism	Solvent release and cure reaction	
Dry film thickness	3 mils (75 microns)	
Coats	1	
Theoretical coverage	ft ² /gal	m ² /L
1 mil (25 microns)	898	22
3 mils (7.5 microns)	299	7.3
VOC	lb/gal	g/L
mixed	3.6	429
mixed/thinned (1 pt/gal)	4.0	480
Temperature resistance, dry	°F	°C
intermittent	400	205
continuous	200	93
Flash point	°F	°C
base	80	27
converter	76	24
T-10	76	24
Amercoat 65	78	25
Amercoat 101	145	63
Amercoat 12	2	-17

Application Data

Applied over	Prepared steel, galvanizing			
Surface preparation	Abrasive blast SSPC-SP6 or 10, Pickling SSPC-SP8			
Method	Airless or conventional spray, brush, roller			
Mixing ratio (by volume)				
base to converter	4:1			
Pot life (hours)	°F/°C			
	70/21			
	8			
Drying time (ASTM D1640) 3 mils	°F/°C			
	90/32	70/21	50/10	40/5
hard (hours)	3	5	9	14
through (hours)	5	9	16	--
topcoat with most topcoats (hours)	24			
recoat (hours)	1	1 1/2	3	5

Formerly Catha-Coat® 302

Application Equipment

The following is a guide; suitable equipment from other manufacturers may be used. Changes in pressure, hose and tip size may be needed for proper spray characteristics.

Airless spray—Standard equipment, such as Graco Bulldog Hydra-Spray or Speeflo Alaskan PZ and a fluid tip with a 0.021-inch (0.53 mm) orifice or larger.

Conventional spray—Industrial equipment such as a DeVilbiss MBC gun with 2E or 704E cap/tip, or a Binks 18 gun with a 66SS x 67PB nozzle setup. 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.

Power mixer—Jiffy Mixer, powered by air or explosion-proof electric motor.

Application Procedure

Dimetcote 302 Primer is supplied in either a 5 gallon or 1 gallon kit which contains the proper ratio of ingredients. The entire contents of each container must be mixed together.

1. Converter zinc metal is ready mixed in the base portion. Stir thoroughly with a slow speed mixer while slowly adding the liquid component. Continue to mix at slow speeds to a homogeneous condition.
2. At temperatures lower than 60°F (16°C), allow a 15 minute induction time before using. Add about 10 minutes for each 10°F (6°C) lower temperature.
3. Thinning is not normally required or desirable; however, at lower temperatures, up to 10% T-10 Thinner can be added to the mixed components depending on local VOC and air quality regulations. The pot life, 8 hours at 70°F (21°C), will be longer at lower temperatures and shorter at higher temperatures.

Topcoating

Dimetcote 302 surface must be clean and dry before topcoating. Water soluble contaminants may be washed off with water. Remove grease and similar contaminants with an emulsion type cleaner or neutral detergent. Rinse with clean water and allow to dry. Solvent wiping is not satisfactory as contamination may only be spread and not removed. In some cases a mist coat/full coat technique may be required to prevent application bubbling.

Repair

Spot-blast rusted areas in accordance with surface preparation instructions before touching up with Dimetcote 302. When blasting is not practical, Amercoat 68HS may be used for repair. See primer product literature for selection according to topcoat compatibility.

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.

Thinner

below 70°F (21°C)	Amercoat 65 or T-10
above 70°F (21°C)	Amercoat 101

Equipment cleaner	Amercoat 12
-------------------	-------------

Use "E" version of thinner and cleaner in air pollution control areas.

Shipping Data

Packaging units	1 gal	5 gal
Shipping weight (approx)	lb	kg
1-gal unit		
converter	7.6	3.4
base	14.5	6.6
5-gal unit		
converter	36	16.4
base	71	32.2

Shelf life when stored indoors at 40 to 100°F (5 to 38°C)	
converter and base	1 year from shipment date

Numerical values are subject to normal manufacturing tolerances, color and testing variances. Allow for application losses and surface irregularities.

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

Safety Precautions

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

Caution – Improper use and handling of this product can be hazardous to health and cause fire or explosion.

Do not use this product without first taking all appropriate safety measures to prevent property damage and injuries. These measures may include, without limitation: implementation of proper ventilation, use of proper lamps, wearing of proper protective clothing and masks, tenting and proper separation of application areas. Consult your supervisor. Proper ventilation and protective measures must be provided during application and drying to keep solvent vapor concentrations within safe limits and to protect against toxic hazards. Necessary safety equipment must be used and ventilation requirements carefully observed, especially in confined or enclosed spaces, such as tank interiors and buildings.

This product is to be used by those knowledgeable about proper application methods. Ameron makes no recommendation about the types of safety measures that may need to be adopted because these depend on application and space, of which Ameron is unaware and over which it has no control.

If you do not fully understand the warnings and instructions or if you cannot strictly comply with them, do not use the product.

Note: Consult Code of Federal Regulations Title 29, Labor, parts 1910 and 1915 concerning occupational safety and health standards and regulations, as well as any other applicable federal, state and local regulations on safe practices in coating operations.

This product is for professional 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.



Ameron U.S.A. • 13010 Morris Rd, Suite 400, Alpharetta, GA 30004 • (678) 393-0653
Ameron B.V. • J.E Kennedylaan 7, 4191 MZ Geldermalsen, The Netherlands • (31) 345-587-587