

ARCHCO™ 310 EPOXY ZINC

Two Part Organic Zinc Primer

Description

Archco™ 310 Epoxy Zinc is an organic zinc rich epoxy polyamide primer for protection of steel. It has excellent performance in salt and heavy weathering environments.

Uses

Corrosion protection of steel structures, tanks and pipes in marine and industrial environments. The coating can be applied as a repair system over properly prepared inorganic zinc, galvanized or epoxy surfaces.

Features

- Long term protection in corrosive environments
- Low 2.8 VOC content
- Excellent salt spray resistance
- Application by conventional or airless spray
- Compatible with other coatings for touch-up or repair
- Can be applied to variety of surfaces

Application

All contaminants shall be removed from the steel surface to be coated. Oil and grease should be removed in accordance to SSPC-SP-1. Surfaces shall be free from projections, sharp edges, high points and fillets must be ground smooth including all corners. Prepare surfaces by grit blasting to a clean white finish, SSPC-SP 5-63 or Sa 3.

Conventional or airless spray is recommended however this product maybe brushed or rolled. Mix component A thoroughly then add component B and mix thoroughly and take care to eliminate any lumps. Strain contents through a 30-mesh screen and let stand for 15 to 30 minutes before application. The coating shall be applied with a single pass with a 50% overlap. The coating thickness should be measured using a wet film thickness gauge. Clean up equipment with Archco™ Thinner 400E or equivalent.

FOR AIRLESS SPRAY

Use 3/8" ID material hose
 Fluid Pump Ratio min. 45:1
 Fluid Orifice, Inches .025"-.031" (0.6 mm - 0.78 mm)
 Approx. Fluid Pressure 1500-2000 psi (10.3 MPa - 13.7 MPa)

FOR CONVENTIONAL SPRAY

Binks #18
 Fluid Tip 66
 Fluid Needle 65
 Air Cap 66PA
 Air to gun 60 to 70 psi (0.41 MPa - 0.48 MPa)
 Air to pot 10 to 12 psi (0.07 MPa - 0.08 MPa)
 Pot should be equipped with agitator



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PROPERTY SPECIFICATIONS

PROPERTIES

VALUE

Solids Content	68 to 70%
Minimum Temperature & Humidity	Do not apply below 50°F (10°C) & above 85% humidity
Operating Temperature	
Immersed	175°F (80°C)
Atmospheric	225°F (108°C)
Percent of zinc in dried film by weight	82%
Dry Film Thickness	3 mils to 6 mils (76 - 152 microns)
Number of coats	One
Theoretical Coverage at 3 to 6 mils (76 to 152 microns)	374 - 182 SF/Gal (35 - 17 m ² /L)
Thinning required	10 to 15%
Shelf Life @ 41°F (5°C) to 110°F (43°C)	1 year
Flash Point	77°F (25°C)
Pot Life	
@ 77°F (25°C)	6 hours
Dry to Touch	
@ 77°F (25°C)	30 minutes
Dry to Handle	
@ 77°F (25°C)	6 hours
Topcoat Time	
@ 77°F (25°C)	12 hours
Thinner	10-15% with Archco™ Thinner 400E
Ratio by volume (A to B)	4:1 Ratio
Performance Data	
Oil Immersion (ASTM D-1308)	Passes 1000 hours
Salt Water Immersion (ASTM D-1308)	Passes 1000 hours
Slip Co-Efficient (ASTM A-328)	Meets Class B rating
Pencil Hardness (ASTM D-3363)	H
Adhesion (ASTM D-4541)	1000 psi (6.9 MPa)
Salt Fog Resistance (ASTM (B-117)	Passes 1000 hours
Colour	Grey or Green

STORAGE: Store in containers in a dry well ventilated area. The containers should be kept tightly sealed. Shelf Life: 12 months when stored between 41°F – 110°F (5°C-43°C).

CLEANING: Clean equipment with Archco™ Thinner 400E or equivalent solvent cleaner.

HEALTH AND SAFETY: Wear protective clothing and ensure adequate ventilation. Avoid contact with skin and eyes. See safety data sheets for further information.

PACKAGING: 1 and 5 gallon (3.7 and 19 L) kits



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