

# 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



# Archco 310 Epoxy Zinc

## PROPERTY SPECIFICATIONS

PROPERTIES	VALUE
<b>Solids Content</b>	68 to 70%
<b>Minimum Temperature &amp; Humidity</b>	Do not apply below 50°F (10°C) & above 85% humidity
<b>Operating Temperature</b>	
Immersed	175°F (80°C)
Atmospheric	225°F (108°C)
<b>Percent of zinc in dried film by weight</b>	82%
<b>Dry Film Thickness</b>	3 mils to 6 mils (76 - 152 microns)
<b>Number of coats</b>	One
<b>Theoretical Coverage at 3 to 6 mils (76 to 152 microns)</b>	374 - 182 SF/Gal (35 - 17 m <sup>2</sup> /L)
<b>Thinning required</b>	10 to 15%
<b>Shelf Life @ 41°F (5°C) to 110°F (43°C)</b>	1 year
<b>Flash Point</b>	77°F (25°C)
<b>Pot Life</b>	
@ 77°F (25°C)	6 hours
<b>Dry to Touch</b>	
@ 77°F (25°C)	30 minutes
<b>Dry to Handle</b>	
@ 77°F (25°C)	6 hours
<b>Topcoat Time</b>	
@ 77°F (25°C)	12 hours
<b>Thinner</b>	10-15% with Archco Thinner 400E
<b>Ratio by volume (A to B)</b>	4:1 Ratio
<b>Performance Data</b>	
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
<b>Color</b>	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 material safety data sheets for further information.

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



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