

## ARCHCO™ 320 INORGANIC ZINC

### Two Part Inorganic Zinc

#### Description

Archco™ 320 Inorganic Zinc is an inorganic zinc 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 has good application properties and can be top coated.

#### Features

- Service temperatures up to 750°F (399°C)
- Long-term protection in corrosive environments
- Superior abrasion resistance
- Excellent salt spray resistance
- Low temperature/high humidity cure
- Application by conventional or airless spray
- Excellent resistance to fuels and organic solvents

#### 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. Maximum product performance will be achieved by blasting with 16-40 mesh silica sand, G-50 steel grit or equivalent material to obtain a 1-1/2 mil (38 microns) angular profile.

Archco™ 320 can be sprayed by conventional or airless spray. Mix Part A (liquid) thoroughly then add Part B (dust). Mix thoroughly with mechanical agitation while adding Part B (dust). Do not mix in reverse. Mix until free of any lumps, then pour mixture through a 30 mesh screen. The coating shall be applied with a single pass with a 50% overlap holding the gun 10-12 inches (254 - 305 mm) from surface at a parallel right angle. The coating thickness should be measured using a wet film thickness gauge. Clean up equipment with Xylene or equivalent solvent.

#### FOR AIRLESS SPRAY

Use 3/8" (9.5 mm) ID material  
 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™ 320 Inorganic Zinc

## PROPERTY SPECIFICATIONS

PROPERTIES	VALUE
Solids Content (+/- 2%)	68%
Minimum Temperature & Humidity	Do not apply below 50°F (10°C) & above 85% humidity
Operating Temperature	
Immersed	Consult Denso representative regarding application
Atmospheric	750°F (399°C)
Percent of zinc in dried film by weight	78%
Dry Film Thickness	2.5 mils to 6 mils (63.5 to 152 microns)
Number of coats	One
Theoretical Coverage at 76 to 152 micron	11 - 5 m <sup>2</sup> /L
Thinning required	10 to 15% with Xylene
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)	12 hours
Dry to Touch	
@ 77°F (25°C)	15 - 30 minutes
Dry to Handle	
@ 77°F (25°C)	8 - 12 hours
Topcoat Time	
@ 77°F (25°C)	12 - 16 hours
Thinner	10-15% with Xylene
Ratio by volume (A to B)	10 Parts A to 14.3 Parts B
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)	600 psi (4 MPa)
Salt Fog Resistance (ASTM (B-117)	Passes 1000 hours
Weight solids % (ASTM D-2369)	76%
Colour	Green

**STORAGE:** Store in containers in a dry well ventilated area. The containers should be kept tightly sealed. Shelf Life: 6 months when stored between 41°F – 110°F (5°C-43°C).

**CLEANING:** Clean equipment with Xylene 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:** 1.5 and 5 gallon (5.7 L and 19 L) kits



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