Archco 320™ Inorganic Zinc Rich Primer
Spray Application Specifications

1.0 Scope

1.1 This specification covers the surface preparation and coating for exterior structures.

2.0 Material and Storage

2.1 Material shall be Denso Archco Tank Lining system as manufactured by Denso North America, 9710 Telge Road, Houston, TX 77095 (Tel) 281-821-3355 (Fax) 281-821-0304 or 90 Ironside Crescent Unit 12, Toronto, Ontario, Canada M1X1M3 (Tel) 416-291-3435 (Fax) 416-291-0898. E-mail: info@densona.com.

2.2 Material shall meet the physical properties of the attached product data sheet.

2.3 Store in a dry, well-ventilated area between 40°F to 105°F (4°C to 41°C) in original, unopened containers. It is recommended that all components be stored between 68°F to 86°F (20°C to 30°C) for 24 hours prior to use for optimum pumping and productivity.

3.0 Equipment

3.1 Equipment shall be a single-leg airless spray unit. The unit shall have a minimum of 30:1 airless pump. Filter, 40 mesh. Spray tip, .019-.021" (483 to 533 microns). May be sprayed conventional. Thin as needed up to 15% by volume for airless and conventional. Continuous agitation of mixture during application is required.

3.2 MIBK (Methyl isobutyl ketone) is recommended to clean the equipment.

3.3 Wet film thickness gauges.

4.0 Surface Preparation

4.1 All contaminants shall be removed from the steel surface to be coated. Oil and grease should be removed in accordance with SSPC SP-1 using detergent, emulsion, or a fresh-water power wash.

4.2 If substate is in a marine environment, manufacturer recommends that the substrate be treated for salts prior to any work being performed.

4.3 If soluble salts are found on the surface over 3ppm, the surface must be treated to remove all salts

4.4 Material for abrasive cleaning shall be the appropriate blend of grit to produce an angular surface profile of 2.5 - 3 mils.

4.5 All surfaces to be coated shall be grit blasted to a near-white finish (SSPC SP-10, NACE No. 2 or ISO 8505-1 Sa 2 1/2). *Note: Near-white finish is interpreted to mean that all metal surfaces shall be blasted clean to remove all dirt, mill scale, rust, corrosion products, oxides, paint and other foreign matter. Very light shadow, very light streaks or slight discolorations shall be acceptable; however, at least 95% of the surface shall have the uniform gray appearance of a white metal blast cleaned surface as defined by Swedish Pictorial Surface Preparation Standard Sa 2 1/2 or SSPC VIS-1.*

4.6 Blasted surfaces must be vacuumed to ensure all loose debris is removed from blasted surfaces and anchor profile prior to application of coating. The Contractor shall check the surface profile depth by using a suitable surface profile gauge (Press-O-Film Gauge or equal).

5.0 Application

5.1 The surface shall have no condensation, precipitation or any other forms of contamination on the blasted surface prior to coating.

5.2 The substrate temperature range for application of Archco 320 is 15°F (-9°C) to 100°F (38°C). The substrate temperature must be a minimum of 5°F (3°C) above the dew point temperature before proceeding with the coating operation. Humidity levels must be between 40% to 95% for application.

5.3 Each component (A and B) shall be thoroughly mixed using an air driven Jiffy mixer or equivalent prior to spraying. If using airless spray technique, add zinc powder to the Part A container and mix thoroughly until free of lumps, then pour through a 30-mesh screen until uniform color is achieved. If a thinner viscosity is desired, add Xylene to the mixture at substrate temperatures between 15°F (-9°C) to 85°F (29°C) for temperatures between 85°F (29°C) to 100°F (38°C) use Hisol 100 and continue to mix. It is recommended that no more than 15% by weight be added. Once mixed, the system is ready for spraying.

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5.4 Using the prescribed equipment (Section 3.0), Archco 320 shall be applied using A wet-on-wet spray technique should be used to achieve a thickness of 3 to 5 mils (76 to 127 microns) DFT. Total thickness should not exceed 6 mils (152 microns).

5.5 The thickness of Archco 320 should be checked continuously by wet film gauge to achieve the minimum/ maximum film thickness specified. Notification to the applicator of any inadequately coated sections must be made immediately and repaired.

6.0 Inspection

6.1 The finished coating shall be smooth and of uniform millage with no holidays. All surfaces shall have the required minimum/maximum DFT. In general, the surface of the coating shall be no rougher than the base or substrate material.

6.2 After Archco 320 has cured to a hard cure condition, the owner's representative and/or contractor's inspector should measure the film thickness by magnetic gauge and notify the applicator of their acceptance.

6.3 Denso and/or the owner's representative immediately upon completion of the work shall make final inspection of the completed application. Notification of all defects must be made within a reasonable time frame from completion of the work to allow for all repairs within the allowed time frame for the project.

7.0 Safety Precautions

7.1 Follow the guidelines detailed in the Safety Data Sheets (SDS).

7.2 Keep containers closed when not in use. In case of spillage, absorb with inert material and dispose of in accordance with applicable regulations.

7.3 No open flames, smoking or welding will be allowed in the immediate vicinity during the spray application of Archco Tank Lining.

7.4 Always refer to project specifications as they may supercede Denso specifications.

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