

# PRODUCT DATA SHEET

## ARCHCO 320™ Inorganic Zinc Rich Primer

### Description

Archco 320, is a solvent-based, two-component, inorganic ethyl silicate, zinc-rich coating. A fast-drying, high-solids, low VOC coating with 76% by weight of zinc dust in the dry film.

### Uses

- Bridges
- Shop or field application
- Refineries, pipelines and tanks
- Drilling rigs
- As a permanent primer for severe corrosive environments (pH 5-9)
- Ideal for low temperature application or high service temperatures and/or high humidity conditions

### Features

- Coating self-heals to resume protection if damaged
- Provides cathodic/sacrificial protection like galvanizing
- Forms an inorganic barrier to moisture and solvents
- High-temperature water resistance
- Meets Class B requirements for slip coefficient
- Resists a wide range of chemicals, produced water, and seawater

### 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 near-white finish, SSPC-SP 10, NACE No. 2 or Sa 2-1/2. Appropriate angular grit shall be used to achieve 2 mil (50 micron) anchor profile.

To spray the Archco 320, a single-leg airless spray unit shall be used. The unit shall have a minimum of 30:1 airless pump. Filter, 30 mesh. Spray tip, .019-.021" (483 to 533 microns). May be sprayed conventional. Thin as needed up to 5% by volume for airless and conventional. Continuous agitation of mixture during application is required. 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). The coating thickness should be measured using a wet-film thickness gauge.



# Archco 320™

## TECHNICAL DATA

PROPERTIES	VALUE
<b>Solids Content (by Volume)</b>	68%
<b>Binder Component @ 77°F (25°C)</b>	
Viscosity	57 KU
Color	Light yellow
<b>Zinc Dust Component @ 77°F (25°C)</b>	
Viscosity	N/A
Color	Gray
<b>Mixing</b>	Slowly power mix zinc dust into binder, mix uniform, strain 30 mesh screen. Mixed material must be used within 8 hours.
<b>DryTimes</b>	<b>@ 77°F (25°C)</b> <b>@ 40°F (5°C)</b>
Touch	20 minutes                              30 minutes
Through	8 - 12 hours                              3 days
Topcoat	16 - 24 hours                              4 days
<b>Theoretical Coverage</b>	364 - 218 ft <sup>2</sup> /gallon
<b>Coating Thickness</b>	3 to 5 mils ( 76 to 127 microns)
<b>Pencil Hardness (ASTM D3363)</b>	2H
<b>Adhesion to Steel (ASTM D4541)</b>	1250 psi
<b>Dry Heat Resistance (ASTM D2485)</b>	750°F (339°C)
<b>Salt Fog Resistance (ASTM B117), 1000 hours</b>	Rating 10 for blistering Rating 10 for rusting
<b>Slip Coefficient</b>	Class B, 0.67

**STORAGE:** 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.

**CLEANING:** Clean equipment with N-butanol or Methyl Ethyl Ketone (MEK)

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

**PACKAGING:** 5 gallon (19 Liters) kits. Other sizes available upon request.



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