

**FORCE
INDUSTRIES
DIVISION**

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PRODUCT INFORMATION

AMCO 3017

(326)

GALVANIZED COATING REPAIR BAR

AMCO 3017 is cadmium free zinc based solder alloy in a 1/4 inch square by 13 inches long bar designed to deposit a protective metallic coating over ferrous metal. It is suitable for repairing galvanized coating damaged by rough handling or welding.

PHYSICAL DATA

- ◆ Composition: Tin, lead and zinc. (Ref. ASTM A-780)
- ◆ Melting Range: 446 - 527°F (230 - 275°C)
- ◆ Density: 8.43 @ 68°F

APPLICATION

- ◆ Clean the surface to be reconditioned using a wire brush, a light grinding action, or mild blasting. To ensure that a smooth reconditioned coating can be effected, surface preparation shall extend into the surrounding undamaged galvanized coating.
- ◆ If the area to be reconditioned includes welds, first remove all flux residue by blast cleaning or chipping.
- ◆ Preheat the cleaned area to at least 600°F. Do not overheat the surface beyond 750°F nor allow the surrounding galvanized coating to be burned. Wire brush the surface during preheating.
- ◆ Rub the cleaned, preheated area with the repair stick to deposit an evenly distributed layer of the zinc alloy. Spread out the coating with a spatula or similar tool.
- ◆ When the repair has been effected, remove flux residue by rinsing with water or wiping with a damp cloth.
- ◆ Take thickness measurements with suitable coating thickness gauge to ensure that the supplied coating is as specified. Coverage – 600 ft.² - 4 mil thick.

PACKAGING

- ◆ 1 lb is approximately three bars
- ◆ 25 lbs per carton.

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