

**FORCE  
INDUSTRIES  
DIVISION**

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## **PRODUCT INFORMATION**

### **AMCO 321**

(333)

#### **General Characteristics and Uses**

*AMCO 321* is a heterogeneous blend of flux and powdered galvanizing metals formulated for repair of galvanized surfaces. The resulting coating is a bright metallic film of zinc alloy that gives both barrier and cathodic protection to ferrous metal thus preventing premature corrosion. Conforms to ASTM A780-93 § 4.2.1.

#### **Physical Data**

- Appearance. Fine gray powder with hygroscopic property
- Metal to flux ratio. 61:39
- Working temperature. Approx 400-450° F
- Residue. Slightly corrosive but easily removed with water or wet cloth.

#### **Application**

Mix AMCO 321 with small amount of water to form a brushable paste or slurry. Isopropyl alcohol may also be used and is preferred. Apply flux mixture to clean ferrous metal surface only. The surface must be clean of oil, soil and loose rust. Heat the area to be treated with a flame until the metal melts. A wood scraper may be used to spread the coating evenly on the surface while the alloy is molten. Let the surface cool. Do not overheat the surface. Remove flux residue with wet cloth.

**Caution:** Burn and injury may result. Do not touch the heated metal surface.

#### **Storage & Handling**

- Shelf Life. Approximately one year in unopened and undamaged container stored away from heat and high humidity.
- Keep container tightly closed when not in use.
- Corrosive material – keep away from skin and eyes. Read MSDS.

#### **Packaging**

- 1 lb cans
- Larger sizes available upon request

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