

**FORCE
INDUSTRIES
DIVISION**

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PRODUCT INFORMATION

AMCO 322

(334)

General Characteristics and Uses

AMCO 322 is a blend of inorganic flux with powdered zinc, tin and lead alloys compressed into 4" x 5/8" sticks, three of which equals a pound. The product is specially designed for ease of repairing damaged galvanized coatings. 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. Sticks wrapped in tin/lead foil, which becomes part of the metal coating.
- Metal to flux ratio. 80:20
- Working temperature. Approx 350° F
- Residue. Slightly corrosive but easily removed with water or wet cloth.

Application: Apply AMCO 322 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. Frequently touch the heated surface with the AMCO 322 until the stick melts at the point of contact. Rub the bar all across the surface. The flux component will clean the metal surface of light and incipient oxidation and the galvanizing metal will readily wet and adhere to the metal surface. Continue applying the stick until all the desired area is completely coated. Apply heat only up to the point where Amco 322 melts. Do not overheat the surface. Spread the coating with a dry cloth and then let the surface cool. Remove flux residue with wet cloth.

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

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 boxes packed 24 to a carton .

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