

AF1000

COLD GALVANIZING COMPOUND

CERTIFICATION

TECHNICAL DATA



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AF1000
COLD GALVANIZING COMPOUND



AF1000 is a single package zinc rich coating. This coating contains 95% metallic zinc in the dry film to provide cathodic corrosion protection for iron and steel. Cold Galvanizing Compound is also excellent for the repair of worn or damaged galvanized steel. This product is not intended for use on rusted steel. AF1000 meets the performance requirements of ASTM A-780-01 (par. 4.1.2, 4.1.3, 4.2.2).

KEY BENEFITS

- Rust-proofs weld
- Field applied
- Quick dry

SURFACE PREPARATION

ALL SURFACES: Remove all dirt, grease, oil, salt, and chemical contaminants by washing the surface with a cleaner/degreaser, commercial detergent or other suitable cleaner. Mold and mildew must be cleaned with a chlorinated cleaner or bleach solution. Rinse with fresh water and allow to thoroughly dry.

STEEL: At minimum, clean in accordance to SSPC-SP-11 Power Tool Clean to Bare Metal. AF1000 is intended to be applied only to bare steel or existing sound galvanized steel. It is not intended for application to sound rust.

APPLICATION

Apply only when air and surface temperatures are between 32-100°F (0-38°C) and surface temperature is at least 5°F (3°C) above the dew point. The coating can be applied by brush or spray. Thinning is not normally necessary, but if needed for spraying, thin up to 10% by volume using a thinner. Dry to handle in 1-2 hours, recoat in 12 hours; cooler temperature will increase dry time. Recommended wet film thickness is 3.5-4.5 mils (87.5-112.5 μ) to achieve a dry film thickness of 2.5-3.5 mils (62.5-87.5μ). Coverage rate is 310-440 sq. ft/gal (7.6-10.8 ml) when applied at the typical dry film thickness of 2.5-3.5 mils (62.5-87.5μ); excessive film thickness will prevent proper curing. Do not apply in excess of 4.5 mils wet (112.5μ).

EQUIPMENT RECOMMENDATIONS

BRUSH: For touch-up only. Use a good quality natural or polyester bristle brush.

ROLLER: Not recommended.

AIR-ATOMIZED SPRAY:

<u>Method</u>	<u>Tip Size</u>	<u>Fluid Delivery</u>	<u>Atomizing Pressure</u>
Pressure	0.055-0.070	16 Oz./min.	25-60 psi

AIRLESS SPRAY:

<u>Fluid Pressure</u>	<u>Tip Size</u>	<u>Filter Mesh</u>
2100-2400 psi	0.019-0.021	60

THINNING

BRUSH: Normally not required.

AIR-ATOMIZED SPRAY: Use a thinner. Normally not required. If needed, use up to 5% by volume.

AIRLESS SPRAY: Use a thinner. Normally not required. If needed, use up to 5% by volume.



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CLEAN UP

Use a thinner or mineral spirits.

CYCLIC PROHENSION

RATING 1-10, 10 = BEST

METHOD: ASTM D5894, 5 Cycles, 1680 hours

RESULT: 10 ASTM D714 for blistering

RESULT: 10 ASTM D1654 for corrosion

RESULT: 9 ASTM D610 for rusting

CONICAL FLEXIBILITY

METHOD: ASTM D-522

RESULT: Pass >33%

**AF1000**
COLD GALVANIZING COMPOUND**PHYSICAL PROPERTIES****TABLE 1: PHYSICAL PROPERTIES OF AF1000 COLD GALVANIZING COMPOUND**

RESIN TYPE	Epoxy ester	
PIGMENT TYPE	Metallic zinc	
SOLVENTS	Aliphatic hydrocarbons	
WEIGHT	PER GALLON	28.3 lbs.
	PER LITER	3.4 kg
SOLIDS	BY WEIGHT	89.5%
	BY VOLUME	54.1%
VOLATILE ORGANIC COMPOUNDS	<360 g/l (3.0 lbs./gal.)	
RECOMMENDED DRY FILM THICKNESS (DFT) PER COAT	2.5-3.5 mils (62.5-87.5 μ)	
WET FILM TO ACHIEVE DFT (UNTHINNED MATERIAL)	3.5-4.5 mils (87.5-112.5 μ)	
THEORETICAL COVERAGE AT 1 MIL DFT (25 μ)	1,280 sq. ft./gal. (7.6-10.8 m ² /l); based on wet to dry ratio	
PRACTICAL COVERAGE AT RECOMMENDED DFT (ASSUMES 15% MATERIAL LOSS)	310-440 sq. ft./gal. (7.6-10.8 m ² /l); based on wet to dry ratio	
DRY TIMES AT 70-80°F (21-27°C) AND 50% RELATIVE HUMIDITY	TACK-FREE	30-60 minutes
	HANDLE	1-2 hours
	RECOAT	12 hours
DRY HEAT RESISTANCE	212°F (100°C)	
SHELF LIFE	5 years	
SAFETY INFORMATION	Combustible liquid and vapor. Harmful if inhaled. May affect brain or nervous system causing dizziness, headache or nausea. Causes respiratory tract, eye and skin irritation. For industrial or commercial use only. Keep out of reach of children. See the product material safety data sheet (MSDS) and label warnings for additional safety information.	

CALCULATED VALUES ARE SHOWN AND MAY VARY SLIGHTLY FROM THE ACTUAL MANUFACTURED MATERIAL.

The technical data and suggestions for use contained herein are correct to the best of our knowledge, and offered in good faith. The statements of this literature do not constitute a warranty, express, or implied, as to the performance of these products. As conditions and use of our materials are beyond our control, we can guarantee these products only to conform to our standards of quality, and our liability, if any, will be limited to replacement of defective materials. All technical information is subject to change without notice.

ORDERING INFORMATION**TABLE 2: ORDERING INFORMATION OF AF1000 COLD GALVANIZING COMPOUND**

PART NUMBER	SIZE	FINISH/COLOR	QTY/BOX
12AF1000-1Q	1 Quart	Light Gray	1
12AF1000-1G	1 Gallon	Light Gray	1