

# S Q U A R E T U B I N G



Introducing the newest  
member of Allied Tube's  
family of fine fence products.

# THE FLO-COAT®

## FOR EXTRA CORROSION PROTECTION

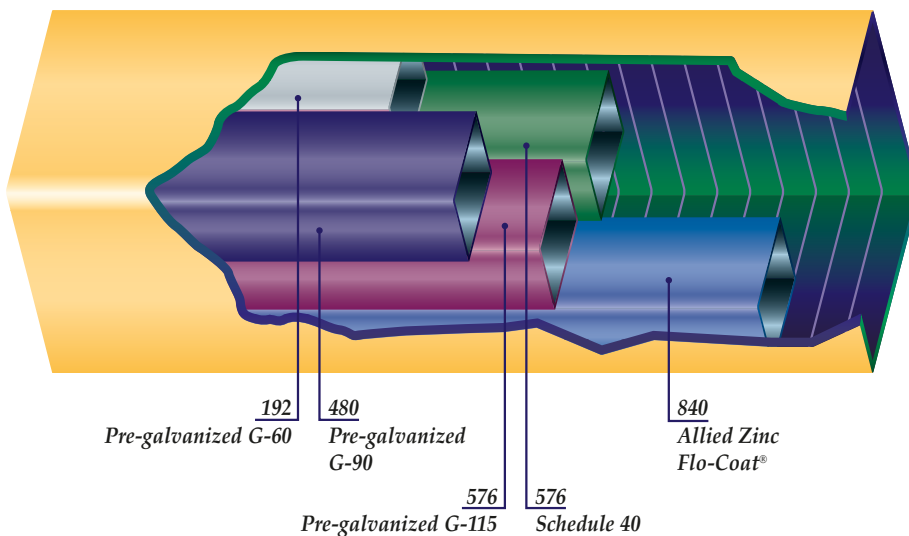
Allied's unique Flo-Coat process is the superior method of galvanizing steel tubing. It begins with flat strip steel, which is then cold-formed and electric-resistance or induction welded. After welding, the tube receives a triple layer of protection - zinc, chromate conversion coating, and a clear organic top-coat - all applied in-line to assure a uniform coating. The result is an end product with a smooth shiny finish that is unmatched in terms of strength and durability.

Flo-Coat tubing exhibits greater corrosion resistance because of the synergism created between the coatings; the chromate conversion coating passivates the zinc to slow down the white rust growth process, and the clear top-coat then "seals in" the protection. The clear third coating also acts as a primer for powder-coating and painting. Extensive pre-cleaning is unnecessary, and excellent adhesion and abrasion characteristics are achieved, even at high baking temperatures.

*For nearly forty years, Allied Tube products have meant quality & integrity in the chain link fence industry. Now, that confidence can be extended to Ornamental*

### Salt Spray Tests -

*Galvanized Products (First Sign of Red Rust-No. of Hours)*



### Special Note:

In addition, Allied tubular products exhibit superior sunlight and temperature (variation -10°F to 120°F) resistance properties.

Weight of exterior zinc coating may range from .035 to 0.9 oz./ft<sup>2</sup>±0.1 oz./ft<sup>2</sup>. Call your local Allied Fence Division Sales Representative for details.

Tests independently conducted by Scientific Control Laboratories, Chicago, IL in accordance with ASTM B-117. Detailed Scientific Laboratories' tests results are readily available from your local Allied Sales Representative.

### Coating Resistance

#### Test Results

Allied's coatings resist the following\*

- Salt
- Gasoline
- Motor Oils
- Common Household Chemicals
- Wines, Beers, Soft Drinks, Hard Liquor
- Fertilizer
- Insecticides
- Scratches
- Disinfectants (Household / Commercial Varieties)
- Abrasion
- Meat Products
- Bleach
- Damage by Impact
- Citrus Products

\*These tests were conducted in a controlled environment, and our tube was subjected to these substances for a short duration of time. Tests were conducted over Allied's organic clear OD coating as a final finish.

# P R O C E S S

## *Powder-Coating or Painting*

*over Allied's galvanized steel tubing provides greater corrosion resistance than coating over steel that is not galvanized.*

### **Surface Preparation**

It's easy to paint or powder-coat over Allied's galvanized steel tubing.

Simple surface cleaning is required due to an accumulation of dirt and/or dust that results during normal storage and transportation. Most cleaning can be performed by wiping off the tubing before painting or powder-coating using a mild cleaning solution.

In addition, Allied's tubing withstands most in-line chemical baths and rinses without damage or contamination to any part of your cleaning system.

### **Coating**

Allied's galvanized tube products are protected by a clear organic top coating which provides excellent adhesion properties to most thermoset powder coatings, as well as to the following air dry and bake topcoats:

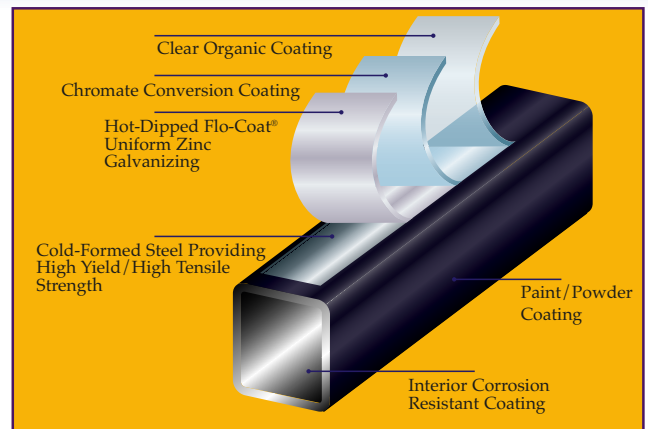
#### **Paint**

- Two-part urethane or epoxy
- Solvent-based paints for metals
- Solvent-based paints for wood
- Solvent-based high-solids paints
- Oil-based paints
- Paints for car bodies or appliances

#### **Powder-Coat**

- High-bake thermoset acrylic
- High-bake alkyd
- High-bake polyester
- Other powder-coating methods may require individual evaluation

Nearly all liquid paints will work well over our clear topcoat. If the paint you are using does not fall into one of the above categories, or you have any questions, please contact Allied's Fence Division for more specific information.



### **Welding**

To maintain corrosion protection in the weld area, Allied suggests four cold galvanizing compounds that are heat resistant (up to 750°F) and act as a primer before powder-coating or painting.

1. ZRC cold galvanizing compound (battleship gray).
2. ZRC Galvilite cold galvanizing compound (shiny).
3. Rustolastic #234-A-120 (sales code 073258).
4. Kalcor 75% zinc dust epoxy.

## Available Sizes

Size	Gauge	Pcs/Bdl	Length
3/4"	18	180	24'
3/4"	16	180	24'
1"	16	243	24'
1-1/4"	16	144	24'
2"	16	25	24'
2"	14	25	24'
2-1/2"	14	25	24'
2-1/2"	12	25	24'
3"	14	25	24'
3"	11	25	24'
4"	11	16	24'
4"	13	16	24'

Call your local sales representative for stock availability and special sizes.

### Allied Tube products are manufactured:

- With steel strip conforming to ASTM A 569.
- With zinc conforming to ASTM B 6 High Grade and Special High Grade Zinc.

Call our Toll-free number for assistance.

# 1-800-882-5543

Visit our website at [www.industry.net/allied.tube.conduit](http://www.industry.net/allied.tube.conduit)

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The specifications, descriptions, information and illustrated material herein is not intended nor should it be relied upon to provide anyone with all of the relevant information required for welding, painting and powder-coating Allied Tube & Conduit Corporations' galvanized steel tubing. The material is submitted solely for evaluation by others and Allied Tube & Conduit Corporation assumes no responsibility whatsoever for its accuracy or application. Reference should be made to original or primary source data along with standard accepted industry practice. The material herein is as the date of publication and is subject to change without notice.

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