

ARCHCO™ 400 EPOXY

Two Part Epoxy Phenalkamine for Internal Tank Linings

Description

Archco™ 400 Epoxy is a two-part epoxy-phenalkamine system designed as an internal tank lining and primer with superior wet-out properties suitable for sealing heavily pitted floors. The system has excellent low-temperatures cure properties.

Uses

Designed to be used for internal steel tanks and pipes storing crude oil, seawater, wastewater, fuels, solvents and lubricants. Also, can be used as a primer / sealer for other Archco™ linings.

Features

- Excellent adhesion
- Excellent penetration properties
- 60 day re-coat window at 70°F (21°C) with 450, 460 and 470
- Cures at temperatures down to 35°F (2°C)
- Fast dry and set times
- Tough abrasion resistance
- Cures under cool and damp climates
- Good flexibility and impact resistance

Application

All contaminants shall be removed from the steel surface to be coated. Oil and grease should be removed in accordance to SSPC-SP-1. Surfaces shall be free from projections. Sharp edges, high points and fillets must be ground smooth including all corners. Prepare surfaces by grit blasting to a clean near-white finish, per SSPC-SP 10, NACE No. 2 or Sa 2-1/2. Appropriate angular grit shall be used to achieve a 3 to 5 mil (76 - 127 microns) anchor profile.

To spray the Archco™ 400 Epoxy a single-leg airless unit shall be used. The unit shall have a minimum of 68:1 airless pump. No thinner should be used. A wet-on-wet spray technique should be used to achieve 5 to 8 mils (127 - 203 microns) DFT when used as a primer. If using as a lining, apply 2 layers at 10 mils (254 microns) DFT. The coating thickness should be measured using a wet-film thickness gauge.

For complete application instructions please refer to Archco™ 450 Epoxy Lining Application Specifications.



Archco™ 400 Epoxy

PROPERTY SPECIFICATIONS

PROPERTIES	VALUE
Solids by Weight	85-87%
Solids by Volume	77-79%
Minimum Dewpoint/Substrate Differential	Dewpoint +5°F (+3°C)
Minimum Substrate Temperature	35°F (2°C)
Operating Temperature	-4°F (20°C) to 150°F (65°C)
Dry Film Thickness per coat	5 mils to 8 mils (127 - 203 microns) (primer) 10 mils (254 microns) (lining)
Theoretical Coverage	320 SF / Gal @ 5 mils (127 microns)
Spray Equipment Required	68:1 airless
Airless Spray Tip Size	0.017 – 0.027 in. (0.43 - 0.68 mm)
Shelf Life @ 41°F (5°C) to 110°F (43°C)	18 Months Minimum
Flash Point	28°F (-2°C)
Pot Life	
@ 77°F (25°C)	45-50 Minutes
@ 97°F (36°C)	30-35 Minutes
Dry to Handle	
@ 35°F (2°C)	72 Hours
@ 50°F (10°C)	36 Hours
@ 77°F (25°C)	10 Hours
@ 100°F (38°C)	6 Hours
Overcoating Time (Minimum)	
@ 35°F (2°C)	36 Hours
@ 50°F (10°C)	14 Hours
@ 77°F (25°C)	5 Hours
@ 100°F (38°C)	2 Hours
Thinner	Not Recommended
Ratio by volume (A to B)	3:1 Ratio
Colour	Red Oxide
VOC	1.50 lbs/gal (0.68 kg/L)

STORAGE: Minimum 18 months when stored in original containers @ 41°F (5°C) to 110°F (43°C).

CLEANING: Clean equipment with MEK, Archco™ 400E Thinner or equivalent solvent cleaner.

HEALTH AND SAFETY: Wear protective clothing and ensure adequate ventilation. Avoid contact with skin and eyes. See material safety data sheet for further information.

PACKAGING: 4 gallon (15 L) kits standard. Other kit sizes are available upon request.



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