

ARCHCO™ 401 EPOXY

Penetrating Epoxy Sealer

Description

Archco™ 401 Penetrating Epoxy Sealer is a two-part, 100% solids epoxy system designed to be applied over heavily pitted tank floors requiring sealing prior to overcoating with Archco™ lining systems. Best applied using single-leg airless spray or roller.

Uses

Sealing of heavily pitted tank floors. Suggested top-coats include Archco™ 400HB, Archco™ 476 and the Archco™ 453 series.

Features

- Excellent penetration properties
- Very low viscosity
- Contains no solvent - zero VOC

Application

All components shall be removed from the steel surface to be coated. Oil and grease should be removed in accordance to SSPC-SP-1. Surface 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 2 to 3 mil (51 to 76 micron) anchor profile.

To spray the Archco™ 401 Penetrating Sealer, a single-leg, airless spray unit shall be used. The unit shall have a minimum of 45:1 airless pump. No thinner should be used. A wet-on-wet spray technique should be used to achieve 5 to 6 mils (127-152 micron) DFT. The coating thickness should be measured using a wet-film thickness gauge.

Note: Not to be used as a holding primer.

For complete application instructions, please refer to Archco™ 401 Epoxy Application Specifications.



Archco™ 401 Epoxy

TECHNICAL DATA

PROPERTIES	VALUE
Solids Content	100%
Ratio by Volume (A to B)	2:1
Colour	Clear
Mixed Viscosity @ 22°C	60 - 120 cP
Operating Temperature	-4°F (-20°C) to 150°F (65°C)
Min. Substrate Temperature	50°F (10°C)
Minimum Dewpoint/Substrate Differential	Dewpoint +5°F (+3°C)
Dry Film Thickness Per Coat	5 to 6 mils (127 - 152 microns)
Theoretical Coverage Rate	320 SF/Gal @ 5 mils (7.9 m ² /L @ 127 micron)
Spray Equipment Required	45:1 Airless unit
Airless Spray Tip Size	0.013 - 0.017 in. (0.33 - 43 mm)
Steel Temperature Application	40°F to 120°F (4°C to 49°C)
Pot life @ 77°F (25°C)	60 minutes
Pot life @ 90°F (32°C)	30 minutes
Dry to Handle	
@ 50°F (10°C)	20 - 24 h
@ 77°F (25°C)	10 - 12 h
@ 90°F (32°C)	5 - 6 h
Flash Point	225°F (107°C)
Performance Data	
Crude Oil	Excellent
Water	Excellent
Solvents	Very Good
Acids (inorganic)	Very Good
Salt	Excellent

STORAGE/SHELF-LIFE: 24 months when stored between 4°C to 43°C.

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

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



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