



# Archco™ 401 Penetrating Epoxy Sealer Spray Application Specifications

## 1.0 Scope

- 1.1 This specification covers the internal surface preparation and coating of storage tanks and vessels. **Not to be used as a holding primer.**

## 2.0 Material and Storage

- 2.1 Material shall be Denso Archco™ Tank Lining system as supplied by Denso (Australia) Pty Ltd.
- 2.2 Material shall meet the physical properties of the product data sheet.
- 2.3 Storage of the material shall be in a warm dry place, between 40°F (4°C) to 95°F (35°C) The containers shall be stored up right.

## 3.0 Equipment

- 3.1 Equipment shall be a single airless or hydraulic spray unit capable of pumping the specified Archco™ coating (see product data sheet). For airless spray the unit shall be a recommended pump 70:1, minimum of 45:1 spray pump with a recommended hose length, 100 ft ½" (30.6 m), 25 ft 3/8th" (7.7 m) hose (150' max.) with a 25 ft ¼" (7.6 m) whip. A Graco mastic gun, used with a 13 thou to 17 thou (0.30 mm to 0.40 mm) tip size, is recommended.
- 3.2 Archco™ 400 Thinner is recommended to clean the equipment.
- 3.3 Wet film thickness gauges.

## 4.0 Surface Preparation

- 4.1 All contaminants shall be removed from the steel surface to be coated. Oil and grease should be removed in accordance with SSPC SP-1 using detergent, emulsion, or a fresh-water power wash.
- 4.2 Material for abrasive cleaning shall be the appropriate blend of grit to produce an angular surface profile of 1 - 3 mils (25 - 76 µm).
- 4.3 All surfaces to be coated shall be grit blasted to a near-white finish (SSPC SP-10, NACE No. 2 or ISO 8505-1 Sa 2 1/2). *Note: Near-white finish is interpreted to mean that all metal surfaces shall be blasted clean to remove all dirt,*

*mill scale, rust, corrosion products, oxides, paint and other foreign matter. Very light shadow, very light streaks or slight discoloration's shall be acceptable; however, at least 95% of the surface shall have the uniform grey appearance of a white metal blast-cleaned surface as defined by Swedish Pictorial Surface Preparation Standard Sa 2 1/2 or SSPC VIS-1.*

- 4.4 Blasted surfaces must be vacuumed to insure all loose debris is removed from blasted surfaces and anchor profile prior to application of coating. The Contractor shall check the surface profile depth by using a suitable surface profile gauge (Press-O-Film Gauge or equal).
- 4.5 After blasting, an approved rust inhibitor and chloride remover and holding primer, such as Archco™ 400 Epoxy, may be used to hold the blast until the coating application can be completed. Metal areas that develop flash rust due to exposure to moisture shall be given a sweep blast to return them to their original blasted condition prior to coating.
- 4.6 Any gaps due to the presence of plates or supports, etc. shall be caulked prior to the finish coat application.

## 5.0 Application

- 5.1 The surface shall have no condensation, precipitation or any other forms of contamination on the blasted surface prior to coating.
- 5.2 The substrate temperature range for application of Archco™ 401 is 50°F (5°C) to 140°F (60°C). The substrate temperature must be a minimum of 5°F (3°C) above the dew point temperature before proceeding with the coating operation. Ambient temperature can be lower if the substrate is heated. (Heating air within closed tank).
- 5.3 Each component (A and B) shall be thoroughly mixed using an air driven Jiffy mixer or equivalent prior to spraying. If using airless spray technique, add Part B to the Part A container and mix thoroughly until a uniform colour is achieved. Once mixed, the system is ready for spraying.
- 5.4 Sweat in time of 5 to 10 minutes based on ambient temperature (cooler longer, warmer shorter)
- 5.5 Using the prescribed equipment (Section 3.0), Archco™ shall be applied using a wet on wet technique to the specified Dry Film Thickness (DFT).

## 8.0 Safety Precautions

- 8.1 Follow the guidelines detailed in the Safety Data Sheets (SDS).
- 8.2 Keep containers closed when not in use. In case of spillage, absorb with inert material and dispose of in accordance with applicable regulations.
- 8.4 Always refer to project specifications as they may supercede Denso specifications.



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