PRODUCT DATA SHEET

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 when LT hardener is used.

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 400HB and 460
- Cures at temperatures down to 35°F (2°C)
- Cures at temperatures down to 25°F (-4°C) when LT hardener is used
- 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 2 to 3 mil (51 - 76 microns) minimum 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 3 to 5 mils (76 - 127 microns) DFT when used as a primer. If using as a lining, apply 2 layers at 8 to 10 mils (203 - 254 microns) DFT. For heavily pitted floors, apply 10 - 12 mils (254 - 305 microns) DFT. The coating thickness should be measured using a wet-film thickness gauge.

For complete application instructions please refer to Archco 400HB Epoxy Lining Application Specifications.

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Property Specifications

Properties	Value	LT Hardener Added
Solids by Weight	85 - 87%	69 - 71%
Solids by Volume	77 - 79%	52 - 55%
Minimum Dewpoint/Substrate Differential	Dewpoint +5°F (+3°C)	
Minimum Substrate Temperature	35°F (2°C)	25°F (-4°C)
Operating Temperature	-4°F (-20°C) to 150°F (65°C)	
Dry Film Thickness per coat	3 mils to 5 mils (76 - 127 microns) (primer) 8 - 10 mils (203 - 254 microns) (lining) 10 - 12 mils (254 - 305 microns) (heavily pitted floors)	
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	24 Months Minimum
Flash Point	28°F (-2°C)	80°F (27°C)
Pot Life		
@ 77°F (25°C)	45-50 Minutes	45-50 Minutes
@ 97°F (36°C)	30-35 Minutes	30-35 Minutes
Dry to Handle		
@ 35°F (2°C)	72 Hours	48 Hours
@ 50°F (10°C)	36 Hours	28 Hours
@ 77°F (25°C)	10 Hours	10 Hours
@ 100°F (38°C)	6 Hours	6 Hours
Overcoating Time (Minimum)		
@ 35°F (2°C)	36 Hours	10 Hours
@ 50°F (10°C)	14 Hours	6 Hours
@ 77°F (25°C)	5 Hours	4 Hours
@ 100°F (38°C)	2 Hours	2 Hours
Thinner	Not Recommended	
Ratio by volume (A to B)	3:1 Ratio	
Color	Red Oxide	
VOC	1.50 lbs/gal (0.68 kg/L)	

STORAGE: Minimum 24 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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