

Archco 400HB™ Epoxy

High Build Two Part Phenalkamine Epoxy

Description

Archco 400HB Epoxy is a 85% solids two-part epoxy designed for internal tank and pipe linings. The coating has excellent low temperatures cure properties.

Uses

Corrosion protection for steel tanks and internal pipes in a variety of industries. The coating will protect tanks and piping against crude oil, seawater, wastewater, fuels, solvents, lubricants and acids. Archco 400HB Epoxy also has excellent resistance to ethanol.

Features

- High solids
- Very low permeability
- Cures at temperatures down to 35°F (2°C)
- Fast dry and set times
- High build up to 30 mils DFT (762 microns) in one coat
- Excellent adhesion
- Cures under cool and damp climates
- Good flexibility
- Good chemical resistance
- Excellent resistance to ethanol

Surface Prep

On the Archco 400 primer prior to coating, the surface should be dry and above 35°F (2°C). If the Archco 400 epoxy has cured more than 60 days; a light sweep blast must happen before applying another coat. After the surface is roughened, wipe the entire surface with MEK or approved solvent to remove the dust and other contamination. If applying within the 60 day recoat window, the surface shall have no condensation, precipitation or any other forms of contamination prior to coating.

Mixing

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 color is achieved. If a thinner viscosity is desired, add Archco 400 E Thinner to the mixture and continue to mix. It is recommended that no more than 20% by weight be added. Once mixed, the system is ready for spraying.



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TECHNICAL DATA SHEET

Application

The surface shall have no condensation, precipitation or any other forms of contamination on the blasted surface prior to coating.

The substrate temperature range for application of Archco 400HB is 35°F (2°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.

To spray the Archco 400HB Epoxy a single leg airless unit can be used. On the single leg airless unit, it shall be a minimum a 68:1 or greater airless pump. A wet-on-wet spray technique should be used to achieve a minimum of 20 mils (0.508 mm) DFT. The coating thickness should be measured using a wet-film thickness gauge. For smaller areas and repairs Archco 400HB Epoxy brush kits can be used.

Inspection

For most applications, tank filling can be accomplished when the coating reaches a Shore D of 70. The "thumb nail test" can also be used. The thumb nail test is defined by when one can no longer make a permanent indentation in the coating using one's thumb nail.

Spark testing shall be performed to ensure proper film thickness and for holiday inspection. Refer to NACE SP0188-2006 Standard for voltage.

Recoating: If a second coat is required and the first coat has reached a shore D of 70, the surfaces shall be roughened by sweep blasting. If the coating is soft, no surface preparation is required.

Repairs

Areas shall be roughened a minimum 1 in. (25mm) around holiday using Carborundum cloth or 80 grit sandpaper and wiped clean with a xylene-soaked cloth prior to patching. All holidays shall be repaired.

Storage

Minimum 24 months when stored in original containers @ 41°F (5°C) to 90°F (32°C). Do not store in direct sunlight.

Cleaning

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

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TECHNICAL DATA SHEET

Health & Safety

Refer to SDS before use. Always refer to project specifications as they may supersede Denso specifications. For lining recommendations contact a Denso Representative.

Packaging

4-gallon (15 liter) kits standard. Other kit sizes are available upon request.



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TECHNICAL DATA

PROPERTIES

VALUE

Solids Content	85%
Minimum Dew Point / Substrate Differential Dew Point	+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	20 mils to 30 mils (0.508 - 762 microns)
Theoretical Coverage	64 SF/Gal @ 25 mils (1.57 m ² /L @ 635 microns)
Spray Equipment Required	68:1 airless or better
Airless Spray Tip Size	0.017 – 0.027 in. (0.43 - 0.69 mm)
Shelf Life @ 41°F (5°C) to 110°F (43°C)	24 Months
Flash Point	28°F (-2°C)
Pot Life	
@ 77°F (25°C)	120-140 Minutes
@ 97°F (36°C)	60-70 Minutes
Dry to Touch	
@ 35°F (2°C)	72 Hours
@ 50°F (10°C)	36 Hours
@ 77°F (25°C)	10 Hours
@ 100°F (38°C)	6 Hours
Cure for Immersion (Crude Oil)	
@ 35°F (2°C)	7 Days
@ 50°F (10°C)	5 Days
@ 77°F (25°C)	3 Days
@ 100°F (38°C)	36 Hours
Thinner	Airless - no more than 20% with Archco Thinner 400E
Ratio by volume (A to B)	3:1 Ratio
Performance Data	Contact Denso Representative
Color	Grey, Red Oxide & Blue
Finish	Semi-gloss



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