

# ARCHCO 400HB™ PLURAL

## High-Solids, Chemical-Resistant Epoxy Topcoat

### Description

Archco 400HB Plural is a 100%-solids, two-part epoxy designed for internal tank linings. It has excellent chemical resistance and low-temperature cure properties. The coating will protect tanks and piping against crude oil, seawater, wastewater, fuels, solvents, lubricants, and acids. Archco 400HB Plural has excellent resistance to ethanol and methanol.

### Uses

- Storage tanks
- Terminal pipelines
- Structural steel

### Features

- Excellent adhesion
- Excellent chemical resistance
- Cures at temperatures down to 35°F (2°C)
- Fast dry and set times
- High build up to 40 mils DFT (1,016 microns) in one coat
- Good flexibility and impact resistance
- Excellent abrasion resistance
- 100% solids
- Very low permeability
- Cures under cool and damp conditions
- Excellent under-cutting resistance
- Excellent resistance to ethanol and methanol

### Surface Prep

Surface preparation is very important and will improve the adhesion and extend the life of the Archco 400HB Plural system. Surface preparation should include the following:

- Surface must be at least 35°F (2°C) prior to application.
- Surfaces must be dry, clean, free of oil, grease, and other contaminants and must be structurally sound in accordance with SSPC SP-1.
- Corrosive service: SSPC-SP10 near-white metal blast (3-5 mil anchor profile).
- Immersion service: SSPC-SP10 near-white metal blast (3-5 mil anchor profile).
- Prime with Archco 400. Recommended DFT - 4 to 8 mils.



# TECHNICAL DATA SHEET

## Mixing

Material is supplied in four containers as a unit. Always use a complete unit in the proportions supplied.

1. Agitate all three base containers (part A) and the catalyst container (part B) individually with a power agitator.
2. Once thoroughly mixed, transfer part A and part B material into the appropriate plural-spray unit feed hoppers and bring to designated temperature with mixing.
3. Part A should be heated to 100°F – 120°F (38°C – 49°C) and Part B should be heated to 90°F – 110°F (32°C – 43°C).

## Application

**Plural Spray Recommended:** Tip range 21-31 thou. Total output fluid pressure at spray tip not less than 5000 psi. A 70:1 pump is recommended. Ideally, fluid hoses should not be less than 3/8" ID and no longer than 50 feet to obtain optimum results. Hose bundle should be heated to 100°F – 120°F (38°C – 49°C). Clean equipment with Archco 400E Thinner or equivalent.

- Typical film thickness (total 18-22 dry, applied in 1 coat)

Wet: 18 to 22 mils (457 to 559 microns) per coat

Dry: 18 to 22 mils (457 to 559 microns) per coat

## Storage

Store in a dry, well-ventilated area between 40°F to 105°F (4°C to 41°C) in original, unopened containers. It is recommended that all components be stored between 68°F to 86°F (20°C to 30°C) for 24 hours prior to use for optimum pumping and productivity.

## Cleaning

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

## Health & Safety

Wear protective clothing and ensure adequate ventilation. Avoid contact with skin and eyes. See Safety Data Sheet for further information.

## Packaging

20 gallon kits (75 liters). Other kit sizes are available upon request.

# Archco 400HB™ Plural

## TECHNICAL DATA

### PROPERTIES

### VALUE

<b>Solids Content (By Volume)</b>	100%
<b>Mixed VOC</b>	<0.04 lb/gal (<5 g/l)
<b>Mix Ratio (By Volume)</b>	3 parts base to 1 part catalyst
<b>Base Component – Unmixed @ 77°F (25°C)</b>	
Viscosity	39,500 cP
Color	White
<b>Hardener Component – Unmixed @ 77°F (25°C)</b>	
Viscosity	19,600 cP
Color	Black
<b>Mixed @ 77°F (25°C)</b>	
Viscosity	34,500 cP
Color	Gray
<b>Cure Times @ 77°F (25°C) and 50% RH</b>	
Pot Life	120-140 minutes
Dry Time	60-70 minutes
Dry Time @ 50°F (10°C)	12-16 hours
<b>Cure for Immersion (Crude Oil)</b>	
@ 50°F (10°C)	3 to 5 days
@ 77°F (25°C)	1 to 2 days
<b>Theoretical Coverage</b>	80 ft <sup>2</sup> /20 mils/gallon (2.0 m <sup>2</sup> /0.50 mm/gallon)
<b>Holiday Detection Based on Min. Thickness</b>	100 V/mil (3,936 V/mm)
<b>Hardness (ASTM D2240-02)</b>	Shore D 85
<b>Adhesion to Steel</b>	3,500 psi (22 MPa)
<b>Application Temperature</b>	35°F to 100°F (2°C to 38°C)
<b>Service Temperature</b>	35°F to 185°F (2°C to 85°C)



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