# TECHNICAL DATA SHEET

# ARCHCO 381™

## High-Gloss Hybrid Exterior Topcoat

## Description

A high-solids, two-part, high-performance exterior coating designed to incorporate the characteristics of polyurethane coatings such as high gloss, exterior durability, chemical resistance, solvent resistance, mar resistance and flexibility, while being isocyanate-free and having excellent gloss retention.

## Uses

- Storage tanks
- Offshore / Marine structures
- Structural steel
- Railcar exteriors
- Pipeline aboveground topcoat
- Industrial maintenance
- Topcoat for Protal™ and Archco™ Coatings

## Features

- Isocyanate-free
- May be applied in one coat to previously painted, properly prepared surfaces
- May be applied direct-to-metal (DTM)
- Excellent gloss retention
- Excellent color retention
- Good corrosion and chemical resistance
- Excellent recoat properties

## Surface Prep

Surface preparation is very important and will improve the adhesion and extend the life of the Archco 381 System. Surface preparation should include the following:

- Surface must be at least 40°F (4°C) prior to application.
- A pressure wash is recommended prior to coating DTM or existing substrates.
- Surfaces must be dry, clean, free of oil, grease, and other contaminants and must be structurally sound. Check for soluble salts.
- Corrosive service: SSPC-SP6 commercial blast or SSPC-SP10 near-white metal blast.
- Prime with Archco 300™ Primer. Recommended DFT 4 to 8 mils.

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## Mixing

Material are supplied in two containers as a unit. Always mix a complete unit in the proportions supplied. Once the unit has been mixed it must be used within the working pot life specified.

1. Agitate base (Part A) and catalyst (Part B) with a power agitator.
2. Combine entire contents of catalyst (Part B) with base (Part A) and mix thoroughly with power agitator.

## Application

**Application by Roller Recommended:** Nap size 3/8" to 1/2". Surface must be at least 40°F (4°C), dry, clean, free of oil, grease, and other contaminants and must be structurally sound and must have a sweep blast, according to SSPC-SP7 Brush-off Blast Cleaning (NACE No.4) in preparation for the new coating. Product can also be hand brushed.

- Typical film thickness: 10 to 12 mils (250 to 300 microns) wet in one coat (6-8 mils DFT) *multiple passes may be needed to achieve mils.
- Corrosive service: SSPC-SP6 commercial blast or SSPCE-SP10 near-white metal blast.
- Prime with Archco 300 Primer. Recommended DFT - 4 to 8 mils.

**Airless Spray:** Tip range 17-21 thou. Total output fluid pressure at spray tip not less than 3,000 psi. A 45:1 pump or larger is recommended. Ideally, fluid hoses should not be less than 3'8" ID and no longer than 50 feet to obtain optimum results.

- Surface must be at least 40°F (4°C) prior to application.
- Surfaces must be dry, clean, free of oil, grease, and other contaminants and must be structurally sound.
- Corrosive service: SSPC-SP6 commercial blast or SSPC-SP10 near-white metal blast.
- Prime with Archco 300 Primer. Recommended DFT - 4 to 8 mils.
- If necessary, recommended thinning with Archco 400E™ Thinner not to exceed 10% by volume.

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## Storage

Store in a dry, well-ventilated area between 40°F and 90°F (4°C to 32°C) in original, unopened containers. Shelf life is at least 12 months under these conditions. 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 MIBK (methyl isobutyl ketone) or MEK (methyl ethyl ketone).

## HSE

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

## Packaging

Standard kit - 5-gallon (19 liter) kits - Color: White.
Contact Denso for kit sizes and colors that may be available.

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## Tech Data

| Properties | Imperial | LT Hardener Added |
|---|---|---|
| **Solids Content (by Volume)** | 70.00% | *70.00%* |
| **Mixed VOC** | 2.1 lb/gal (252 g/l) | *2.1 lb/gal (252 g/l)* |
| **Mix Ratio by Volume** | 4:1 | *4:1* |
| **Dry Time @ 77°F (25°C) / 50% RH** | | ***Dry Time @ 95°F (35°C) / 150% RH*** |
| Set time | 10 minutes | *4 hours* |
| Tack Free | 45 minutes | *6 hours* |
| Dry hard | 1.5 hours | *16 hours* |
| Full Cure | 7 days | *7 days* |
| **Gloss Level** | High | *High* |
| **Thickness** | | |
| Wet | 10 to 12 mils (250 to 300 microns) | *10 to 12 mils (250 to 300 microns)* |
| Dry | 6 to 8 mils (150 to 200 microns) | *6 to 8 mils (150 to 200 microns)* |
| **Theoretical Coverage** | 187 ft²/6 mils/gal | *187 ft²/6 mils/gal* |
| **Pot Life @ 77°F (25°C)** | 4 hours | *3 hours* |
| **Flash Point (Mixed System)** | 68°F (20°C) | *68°F (20°C)* |
| **Thinner** | Not normally required, but if needed, Archco 400E Thinner | *Not normally required, but if needed, Archco 400E Thinner* |
| **Color** | White | *White* |
| **Clean-Up** | MIBK or MEK | *MIBK or MEK* |


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