

ARCHCO™ 401 EPOXY

Penetrating Epoxy Sealer

Description

Archco 401 Penetrating Epoxy Sealer is a two-part, 100% solids epoxy system designed to be applied over heavily pitted tank floors requiring sealing prior to overcoating with Archco lining systems. Best applied using single-leg airless spray or roller.

Uses

Sealing of heavily pitted tank floors. Suggested top coats include Archco 400HB, Archco 476, and the Archco 453 series.

Features

- Excellent penetration properties
- Very low viscosity
- Contains no solvent – zero VOC

Application

All components 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) anchor profile.

To spray the Archco 401 Penetrating Sealer, a single-leg, airless spray unit shall be used. The unit shall have a minimum of 45:1 airless pump. No thinner should be used. A wet-on-wet spray technique should be used to achieve 5-6 mils (127-152 microns) DFT. The coating thickness should be measured using a wet-film thickness gauge.

Note: Not to be used as a holding primer

For complete application instructions, please refer to Archco 401 Penetrating Sealer Application Specifications.



Archco™ 401 Epoxy

TECHNICAL DATA

PROPERTIES	VALUE
Solids Content	100%
Mixed Viscosity @ 72°F (22°C)	60 - 120 CP
Minimum Dewpoint/Substrate Differential	Dewpoint +5°F (+3°C)
Minimum Substrate Temperature	50°F (10°C)
Operating Temperature	-4°F (-20°C) to 150°F (65°C)
Dry Film Thickness per coat	5 to 6 Mills (127 - 152 microns)
Theoretical Coverage	320 SF/Gal (7.9 m ² /L @ 5 Mills (127 microns)
Spray Equipment Required	45:1 Airless Unit
Airless Spray Tip Size	0.013 – 0.017 in. (0.33 - 43 mm)
Shelf Life @ 41°F (5°C) to 110°F (43°C)	24 Months
Flash Point	225°F (107°C)
Steel Temperature Application	40°F to 120°F (4°C to 49°C)
Pot Life	
@ 77°F (25°C)	60 Minutes
@ 90°F (32°C)	30 Minutes
Dry to Handle	
@ 50°F (10°C)	20 - 24 Hours
@ 77°F (25°C)	10 - 12 Hours
@ 90°F (32°C)	5 - 6 Hours
Ratio by volume (A to B)	2:1 Ratio
Performance Data	
Crude Oil	Excellent
Water	Excellent
Solvents	Very Good
Acids (inorganic)	Very Good
Salt	Excellent
Color	Clear

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 Safety Data Sheet (SDS) for further information.

PACKAGING: 5 gallon (19 L) kits standard. Other kit sizes are available upon request.



DENSO NORTH AMERICA

HOUSTON:

9710 Telge Road,
Houston, Texas,
U.S.A. 77095
Tel: 281-821-3355
Fax: 281-821-0304

TORONTO:

90 Ironside Crescent,
Unit 12, Toronto,
Ontario, Canada M1X1M3
Tel: 416-291-3435
Fax: 416-291-0898

www.densona.com

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