

# ARCHCO™ EPOXY TANK CAULK

## Two Part Epoxy for Storage Tanks

### Description

Archco Epoxy Tank Lining is a 100% solids, hand-applied epoxy caulk designed for sealing of rivets and smoothing of seams in storage tanks.

### Uses

Smoothing of seams in storage tanks prior to application of internal lining systems to seal the seams and allow for a smooth transition of the internal lining system between surfaces. The caulk will also prevent rusting in spot-welded areas, corners, and otherwise hard-to-coat areas.

### Features

- 100% solids – zero VOC
- Prevents rusting in hard-to-coat areas
- Good flexibility
- Good adhesion

### 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. Prepare surfaces by grit blasting to a clean, near-white finish, SSPC-SP 10, NACE No. 2 or Sa 2-1/2. Appropriate angular grit shall be used to achieve a 3 to 5 mil (76 - 127 microns) anchor profile. Blast no further distance than what can be coated with Archco Epoxy Tank Caulk by the end of each day's work.

No priming is required. Thoroughly mix 1 part by weight of Part A with 1 part by weight of Part B. Apply to clean surface to a thickness of at least 60 mils (1524 microns). Allow 5-7 days at 70°F (21°C) before returning the tank to service. The degree of cure can be checked with a Shore Durometer Hardness Tester (Model Type D). The cured coating should read greater than 30. The end-user should empty or lower the product level of the tank below the areas to be sealed to provide maximum sealing. For sealing rivets in the interior of the tank be sure to apply the primer and topcoat at least 2 inches (50 mm) on either side including the caulked area to a thickness consistent with the tank liner thickness requirements. Archco Epoxy Tank Caulk is not recommended for application to rivet and seams on converted, riveted tanks in which sheets have been added by welding. Rivets and seams should be completely caulked on the entire tank shell before painting. After sealing the tank with Archco Epoxy Tank Caulk, all seam-sealed areas should be brush blasted in order to receive the tank primer coat. Epoxy, polyurethane, etc. may be applied over the Archco Epoxy Tank Caulk in this way. Do not topcoat with any inorganic-type coating.



# Archco™ Epoxy Tank Caulk

## TECHNICAL DATA

PROPERTIES	VALUE
Solids Content	100%
Color	
Part A	White
Part B	Black
Mixed	Grey
Application Temperature	50°F - 105°F
Ratio by Volume	1:1
Ratio by Weight	1:1
Theoretical Coverage	26 ft <sup>2</sup> /gal @ 60 mils (0.6 m <sup>2</sup> /liter @ 1.5 mm)
Topcoats	Epoxies & Polyurethanes
Pot Life @ 73°F (23°C)	90 mins.
Temperature Limit	150°F (66°C)

**STORAGE:** Minimum 18 months when stored in original containers @ 41°F (5°C) to 110°F (43°C).

**CLEANING:** : Clean equipment with 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:** 1 gallon (3.8 liter) kit ( ½ gallon / 1.9 liter Part A & ½ gallon / 1.9 liter Part B yields 1 gallon / 3.8 liters). Other kit sizes available upon special request.



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