

ARCHCO 431™ EPOXY

100% Solids Epoxy Sprayable Rivet and Seam Caulk

Description

Archco 431 is a two-component, amidoamine-cured, 100% solids, epoxy caulking compound for complete tank repairs. It is designed to be applied by heated, plural-component, airless spray.

Uses

A sprayable caulk that stops leaking rivets and seams on/in bolted and riveted tanks. Also used to fill corners, chime angles, cracks, and corrosion pits prior to applying topcoats or to form a transitional surface between welded or riveted plates. Archco sprayable epoxy caulk is not just for spot repairs (two or three rivets), it is for complete tank repairs.

Features

- Excellent adhesion
- Resistant to sweet and sour crude, alkalis, gases, salt, and most solvents
- Self-priming

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. 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 an essentially 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. Remove any residual grit from blasted surface prior to application. If the rivet or bolt after blasting is still weeping, wipe area with MEK prior to applying the 431 to remove oil from the weeping area.

To spray the epoxy caulk, a heated plural-component, airless spray unit with a proportioning pump capable of a volume mixing ratio of 2:1 shall be used. Standard ancillary equipment should include minimum 10-gallon hoppers, 2 each static mixers, 25 ft. (7.5 m) max x ¼" (6.25 mm) whip hose, and mastic gun with a .027-thou tip. Part A should be heated to 140°F - 160°F (60°C - 71°C) and Part B should be heated to 100°F - 120°F (38°C - 49°C). Hose bundle shall be set at 120°F - 140°F (49°C - 60°C).



TECHNICAL DATA SHEET

Application

A wet-on-wet spray technique should be used to achieve a minimum thickness of 62 mils (1588 microns) DFT. Weeping and leaking rivets and seams must be wiped off with MEK and then sprayed with the epoxy caulk. The caulk cannot be applied over any hydrocarbon weeping from the rivet or seam. If the weeping cannot be stopped, then use Archco 131 Caulk. The coating thickness should be measured using a wet-film thickness gauge. The equipment settings are only guidelines and may vary based on equipment and specific application.

Storage

Minimum 24 months when stored in original containers @ 40°F (4°C) to 105°F (41°C). On job site where temperatures are below 50°F (10°C) product should be kept warm to allow for easy transfer into storage hoppers for warming to proper spraying temperatures.

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

15 gallon kits. Other sizes available upon request.

Archco 431™ Epoxy

TECHNICAL DATA

PROPERTIES	VALUE
Solids Content by Volume	100%
Mixing Ratio (A/B) by Volume	2:1
Pot Life	
Pot Life Accelerates Greatly at Elevated Temperatures	45 – 60 Minutes
Mixed	Grey
Application Conditions	Minimum 50°F (10°C)
Cure Times @ 77°F (25°C)	
Dry Hard	18 Hours
Minimum Recoat Time	24 Hours
Maximum Recoat Time	30 Days
Dry Temp. Resistance (Continuous)	250°F (121°C)
Theoretical Coverage	26 ft ² /gallon @ 62 mils
Thickness Per Coat	62 mils min. (1588 microns)
Holiday Detection – Based on min. mil.	100 volts/mil (3,936 V/mm)
Hardness (ASTM D2240-02)	Shore D 85
Adhesion to Steel	3,200 psi (22 MPa)



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