

PRODUCT DATA SHEET

ARCHCO™ 400HB EPOXY

High Build Two Part Phenalkamine Epoxy for Internal Tank Linings

Description

Archco 400HB Epoxy is a 85% solids two-part epoxy designed for internal tank linings. The coating has excellent low temperatures cure properties.

Uses

Corrosion protection for steel tanks and internal pipes in a variety of industries. The coating will protect tanks and piping against crude oil, seawater, wastewater, fuels, solvents, lubricants and acids. Archco 400HB Epoxy also has excellent resistance to ethanol.

Features

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

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 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 (0.08 - 0.13 mm) anchor profile. Vacuum tank floor to remove grit prior to coating.

For larger areas the Archco 400 Primer/Sealer can be applied at 3 to 5 mils in thickness. To spray the Archco 400HB Epoxy a single leg airless unit can be used. On the single leg airless unit it shall be a minimum a 68:1 airless pump. A wet-on-wet spray technique should be used to achieve a minimum of 20 mils (0.508 mm) DFT. The coating thickness should be measured using a wet-film thickness gauge. For smaller areas and repairs Archco 400HB Epoxy brush kits can be used.

For complete application instructions please refer to Archco 400HB Epoxy Lining Application Specifications.



Archco™ 400HB Epoxy

PROPERTY SPECIFICATIONS

| PROPERTIES | VALUE |
|---|--|
| Solids Content | 85% |
| Minimum Dewpoint / Substrate Differential | Dewpoint +5°F (+3°C) |
| Minimum Substrate Temperature | 35°F (2°C) |
| Operating Temperature | -4°F (20°C) to 150°F (65°C) |
| Dry Film Thickness per coat | 20 mils to 40 mils (0.508 - 1.016 mm) |
| Theoretical Coverage | 64 SF/Gal @ 25 mils (1.57 m ² /L @ 635 microns) |
| Spray Equipment Required | Heated Plural or 68:1 airless |
| Airless Spray Tip Size | 0.017 – 0.027 in. (0.43 - 0.69 mm) |
| Shelf Life @ 41°F (5°C) to 110°F (43°C) | 18 Months Minimum |
| Flash Point | 225°F (107°C) |
| Pot Life | |
| @ 77°F (25°C) | 120-140 Minutes |
| @ 97°F (36°C) | 60-70 Minutes |
| Dry to Handle | |
| @ 35°F (2°C) | 72 Hours |
| @ 50°F (10°C) | 36 Hours |
| @ 77°F (25°C) | 10 Hours |
| @ 100°F (38°C) | 6 Hours |
| Cure for Immersion (crude oil) | |
| @ 35°F (2°C) | 7 Days |
| @ 50°F (10°C) | 5 Days |
| @ 77°F (25°C) | 3 Days |
| @ 100°F (38°C) | 36 Hours |
| Thinner | Airless - no more than 2% with Archco Thinner 400E |
| Ratio by volume (A to B) | 3:1 Ratio |
| Performance Data | |
| Crude Oil | Excellent |
| Water | Excellent |
| Solvents | Very good |
| Acids (inorganic) | Very good |
| Salt | Excellent |
| Alkalies | Excellent |
| Ethanol | Excellent |
| Color | Grey, Red Oxide & Blue |
| Note: No Thinning Recommended | |

STORAGE: Minimum 18 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 material safety data sheet for further information.

PACKAGING: 4 gallon (15 liter) kits standard. Other kit sizes are available upon request.



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