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.

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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 m²/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
Colour	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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