

ARCHCO 400 EPOXY

Two Part Epoxy Phenalkamine for Internal Tank Linings

Description

Archco 400 Epoxy is a two-part epoxy-phenalkamine system designed as an internal tank lining and primer with superior wet-out properties. The system has excellent low-temperatures cure properties.

Uses

Designed to be used for internal steel tanks and pipes storing crude oil, seawater, wastewater, fuels, solvents and lubricants. Also, can be used as a primer / sealer for other Archco linings.

Features

- Excellent adhesion
- Excellent penetration properties
- 60 day re-coat window at 70°F (21°C) with 450, 460 and 470
- Cures at temperatures down to 35°F (2°C)
- Fast dry and set times
- Tough abrasion resistance
- Cures under cool and damp climates
- Good flexibility and impact resistance

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, per SSPC-SP 10, NACE No. 2 or Sa 2-1/2. Appropriate angular grit shall be used to achieve a 3 to 5 mil anchor profile.

To spray the Archco 400 Epoxy a single-leg airless unit shall be used. The unit shall have a minimum of 68:1 airless pump. No thinner should be used. A wet-on-wet spray technique should be used to achieve 5 to 8 mils DRT when used as a primer. If using as a lining, apply 2 layers at 10 mils DFT. The coating thickness should be measured using a wet-film thickness gauge.

For complete application instructions please refer to Archco 450 Epoxy Lining Application Specifications.



Archco 400 Epoxy

PROPERTY SPECIFICATIONS

PROPERTIES	VALUE
Solids by Weight	85-87%
Solids by Volume	77-79%
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	5 mils to 8 mils (primer) 10 mils (lining)
Theoretical Coverage	320 SF / Gal @ 5 mils
Spray Equipment Required	68:1 airless
Airless Spray Tip Size	0.017 – 0.027 in.
Shelf Life @ 41°F (5°C) to 110°F (43°C)	18 Months Minimum
Flash Point	28°F (-2°C)
Pot Life	
@ 77°F (25°C)	45-50 Minutes
@ 97°F (36°C)	30-35 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
Overcoating Time (Minimum)	
@ 35°F (2°C)	36 Hours
@ 50°F (10°C)	14 Hours
@ 77°F (25°C)	5 Hours
@ 100°F (38°C)	2 Hours
Thinner	Not Recommended
Ratio by volume (A to B)	3:1 Ratio
Color	Red Oxide
VOC	1.50 lbs/gal

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 kits standard. Other kit sizes are available upon request.



HOUSTON:
9747 Whithorn Drive,
Houston, Texas,
U.S.A. 77095
Tel: 1-281-821-3355
Fax: 1-281-821-0304

TORONTO:
90 Ironside Crescent,
Unit 12, Toronto,
Ontario, Canada M1X1M3
Tel: 1-416-291-3435
Fax: 1-416-291-0898

e-mail: info@premiercoatings.com

www.premiercoatings.com

A Member of Winn & Coales International

The information given on this sheet is intended as a general guide only and should not be used for specification purposes. We believe the information to be accurate and reliable but do not guarantee it. We assume no responsibility for the use of this information. Users must, by their own tests, determine the suitability of the products and information supplied by us for their own particular purposes. No patent liability can be assumed.