

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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