

400HS Polyurethane Enamel

Updated: January 2015

Specification Data

Generic Type: Aliphatic Acrylic Polyurethane

Description: APCO 400HS is a high solids, high gloss, two part acrylic polyurethane enamel. It has superior color and gloss retention properties, and also has very good splash and spill chemical resistance. 400HS is an excellent choice for oil and gas tanks, storage vessels, transports and a variety of other equipment where a highly durable finish is required.

Features:

- Very high gloss
- High solids, VOC compliant
- Good chemical resistance
- Excellent color and gloss retention
- Available in a full range of colors

Solids Content: 57% by Volume

Theoretical Coverage:

- 914 mil ft²
- 304 ft² @ 3 MILS

Allow for loss during mixing & application.

VOC Value:

- 3.1 lbs/gal per EPA Method 24

Color:

Substrate & Surface Preparation

Must be clean and dry. Any dirt, dust, oil, contaminants, loose rust or loose mil scale must be removed.

Immersion Carbon Steel: Not Recommended

Non-Immersion Carbon Steel: Minimum SSPC-SP3 Power tool Cleaning. For optimum performance SSPC- SP6 Commercial Blast, surface profile 1.5-3.0 Mil.

Galvanized Steel: Not recommended

Previously painted surfaces: Surface must be sufficiently roughened, either by abrasive blasting or mechanical abrasion. Surface must attain a minimum 3B rating in accordance with ASTM D3359 "X-Scribe" test. Apply a test patch to check compatibility, prior to primary application.

Primer: APCO 245FP, APCO 351

Application Equipment

Spray Application:

- **Conventional:** Pressure pot with dual regulators, 3/8" I.D. material hose, Binks 2001 Gun w/66 series nozzles and 565 needle.
- **Airless:** Graco 36:1 Min. 1/4" material line. Tip size .011-.013 Output PSI- 3000

Brush & Roller:

- **Brush:** Natural Bristle
- **Roller:** 1/4" Nap cover with Phenolic Core

Mixing & Thinning

Components: 2

Mix Ratio: 4 base Part A to 1 Activator Part B

Pot Life: 4 hours at 75°F

Mixing: Mix to uniform consistency and color. Frequent stirring is required to keep aluminum pigments suspended.

Thinning:

- **Spray:** Up to 12 oz/gal with S124 if necessary
- APCO S125 May be used in hot conditions

Application

Pre-application: Flush all equipment with thinner S124 or MEK

Temperature: Application range from 50°F-110°F surface temperature. Do not apply below 50°F.

Method: Apply one coat maintaining a wet edge to achieve a WFT of 4-6 MILS. Maximum performance will be achieved with two coats totaling 4-6 mils DFT.

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Application Continued

Inspection: Visually inspect film to ensure adequate coverage.

Clean up & disposal: After use immediately flush all equipment with thinner S108 or MEK. Dispose of all containers, solvents and unused materials in accordance with all local, state and federal regulations.

Curing schedule:

Times based upon 75°F

Dry to touch: 6 hours

Dry through: 18 hours

Dry to cure: 48 hours

Dry times are greatly affected by weather conditions and film thickness.

Packaging & Handling:

Unit sizes: One and Five gallon units

Shipping Weight: 11.5 lbs/gal Unit

UN Classification: UN1263, PAINT, CLASS 3, PGIII