



405HT BRUSH HEAT RESISTANT COATING



PRODUCT INFORMATION BULLETIN

DESCRIPTION Enviroline® 405HT Brush is an ultra high solids brush grade version of Enviroline 405HT and is specifically designed for stripe coat application over welds and seams in tanks that require excellent heat resistance with outstanding corrosion protection. Used in combination with 405HT to handling harsh environments in the petroleum industry, including crude oil, Free Water Knockouts, Treaters, and Separator vessels and tanks with high operating temperatures.

TYPICAL USE Use to stripe coat welds, seams, and rivet heads in steel tanks prior to application of Enviroline 405HT topcoat.

BENEFITS

- Good brush application
- Excellent adhesion
- Resists wide range of chemicals
- Excellent flexibility and impact resistance
- High temperature stability
- Thermal and mechanical shock resistance

LIMITATIONS OF USE Refer to Enviroline 405HT Chemical Immersion Resistance Guide or consult your Enviroline representative.

TECHNICAL DATA

Weight (lbs/gal): 12.9	Pot Life (@ 77° F): 40 minutes
Volume Solids: 90%	Pot Life (@ 100° F): 20 minutes
Color(s): Tan	VOC (mixed lbs/gal): 0.78
Flash Point: 80°F	VOC (mixed g/l): 93
Hardness (ASTM D3363): 3H	Recommended Thickness: 5-10 mils DFT

Temperature Resistance:
 Non-Immersion, Dry Heat: 350° F (177° C)
 Continuous immersion temperature resistance is dependant on particular reagent exposure.

COVERAGE

Theoretical Coverage*: 1507 ft per gallon @ 1 mil dry
@ 5 mils: 301 sq. ft. per gallon
@ 10 mils: 150 sq. ft. per gallon
**When ordering product, make allowances for any loss due to overspray, surface irregularities, etc. (approx. 15 – 20%).*

DRY & CURE SCHEDULE Dry Time, Recoat & Cure Schedule at 50% relative humidity:

	77°F	100°F
Touch Dry	3 hours	2 hours
Dry Hard	6 hours	4 hours
Minimum Recoat	4 hours	2 hours
Maximum Recoat	48 hours	24 hours
Cure*	24 hours	16 hours

* Final cure will also depend on 405HT topcoat application

SURFACE PREPARATION All surfaces must be clean, dry, and free of dust, dirt, oil, soluble salts, or other foreign matter. Steel surfaces shall be abrasive blasted to SSPC SP-5/Nace No. 1 White Metal finish with a minimum 3 – 5 mil angular profile for best results.

APPLICATION EQUIPMENT Apply by a stiff bristle brush only into welds and seams to provide good penetration.

MIX RATIO 2:1 by volume

APPLICATION CONDITIONS Apply at 5° F (3° C) above dew point. Use the following chart for preferred temperature and humidity conditions. These conditions plus adequate ventilation must be maintained throughout the curing cycle for optimum performance in high temperature service environments.

	Substrate	Ambient	Humidity
Preferred	70-120° F	70-100° F	N/A
Minimum	70° F	70° F	5° above dew point

HANDLING Store at moderate temperatures (65-85° F) prior to application for ease of handling and mixing.

THINNING	Additional thinning is not required nor recommended for elevated temperature service.
PRE-HEATING	No pre-heating is required.
MIXING	Mechanically pre-mix each component one minute and then mix combined compound with jiffy mixer for 3 to 4 minutes. Allow additional 10 minute induction time if applying at temperatures under 65° F.
CLEAN UP	Clean immediately with methyl ethyl ketone (MEK) or methyl isobutyl ketone (MIBK).
PACKAGING	One unit forms approximately 4 gallons consisting of two components: Resin: 1 Gallon Pail Hardener: 1/2 Gallon Pail
SHelf LIFE	2 years when stored at 75° F (24° C) unopened.
SHIPPING	F.O.B. Pompano Beach, Florida for domestic shipments, Ex-Works Pompano Beach for international shipments.
SAFETY	This product is for industrial use only and should be installed by qualified coating and lining specialists. Consult Material Safety Data Sheets for important health and safety information prior to use.

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**Enviroline continuously strives to improve its data sheets for the benefit of all users. The owner/applicator is responsible for obtaining the most recent Product Information Bulletin prior to the purchase or application of material.*