

## ARCHCO 452 EPOXY

### Multi-purpose Surface Tolerant Epoxy Primer / Finish

#### Description

Archco 452 Epoxy is a two component, high performance high solids, surface tolerant prime / finish.

#### Uses

Designed as an insitu coating for application by "pigging". Other applications shall include structural steel, tank farms, bridges, machinery, chemical, refinery and fertilizer plants and sewage treatment plants.

#### Features

- Low viscosity allows for superb penetration of substrate resulting in excellent adhesion
- Excellent corrosion protection
- Surface tolerant
- Good adhesion
- High solids
- Long pot life

#### Application

**Mixing:** Material is supplied in two containers as a unit. Always mix a complete unit in the proportions supplied. Once the unit has been mixed it must be used within the working pot life specified. Before mixing, agitate base (Part A) and catalyst (Part B) with a power agitator. Combine entire contents of catalyst with base and mix thoroughly with power agitator.

**Surface Preparation:** Surface preparation is very important and will improve the adhesion and extend the life of Archco 452. Surface preparation should include the following: Surface must be at least 40°F (4°C) prior to application. Surfaces must be dry, clean, free of oil, grease, and other contaminants and must be structurally sound. Remove all loose paint, mill scale and rust. All direct-to-metal coatings provide maximum performance over blasted surfaces. Archco 452 was designed to provide excellent protection over marginal surface preparations. The minimum standard for non-immersion service is SSPC-SP2 or ISO 8501-1:2007 Sa 2. For immersion service the minimum standard is SSPC-SP6 or ISO 8501-1:2007 Sa 2½. Where heavily pitted surfaces still remain after cleaning, use Archco 401 pre-prime penetrating epoxy as a sealer before application of Archco 452.

**Airless Spray Recommended:** Tip range 19-21 thou. Total output fluid pressure at spray tip not less than 3000 psi. For airless spray application: a 45:1 pump or larger is recommended. Ideally, fluid hoses should not be less than 3/8" (9.53 mm) id and not longer than 50 feet (15.2 m) to obtain optimum results. Typical film thickness: Wet - 5 to 8 mils (125 to 250 microns) Dry - 4 to 6 mils (100 to 150 microns).



# Archco 452 Epoxy

## TECHNICAL DATA

PROPERTIES	VALUE
Solids Content	80% ( ± 0.2%)
Mixed VOC	1.50 lbs/gal (180 grams/liter)
Mix ratio (A/B) by Volume:	1 part base (Part A) to 1 part catalyst (Part B)
Dry time @ 77°F (25°C) and 50% rh	
Set time	1 hour
Tack Free	6 hour
Through Cure	7 hours
Full Cure	7 days
Gloss level	Semi-Gloss
Thickness	
Wet	5 to 8 mils (125 to 250 microns)
Dry	4 to 8 mils (100 to 200 microns)
Pot life	
@ 77°F (25°C)	6+ hours
Product color	Red Oxide, Salmon and Gray
Flash Point	Mixed 68°F (20°C)
Thinner	Not normally required, but if needed, use MIBK or MAK. Use of faster evaporating solvent may adversely affect the working life if the product.
Clean up	MIBK or MAK

### Chemical resistance testing- film thickness (mils) 12 to 16, cure - 7 days @ 77°F (25°C)

REAGENTS	WEEKS TO FAILURE
Tap Water	>52
Deionized Water	>52
Sea Water	>52
NAOH 50%	>52
NH4OH 10%	>52
HCL 10%	>52
Unleaded Gasoline	>52
Diesel Fuel	>52
Skydrol 500b	>52
Xylene	>52
MEK	12
Isopropanol	>52
Butyl Acetate	2
50% Ethanol	>52

**STORAGE:** Store in a dry, well-ventilated area between 40°F to 105°F (4°C to 41°C) in original, unopened containers. Shelf life is at least 24 months under these conditions. It is recommended that all components be stored between 68°F to 86°F (20°C to 30°C) for 24 hours prior to use for optimum pumping and productivity.

**CLEANING:** Clean equipment with MIBK or MAK.

**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:** 55 gallon (208 Liters) and 5 gallon (19 Liters) kits.



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