

ARCHCO 476 EPOXY

**High Temperature Internal Epoxy Phenolic-Novolac Lining for Tanks and Pipes
85% Solids - Single-Leg Airless**

Description

Archco 476 Epoxy is a two-part, high-temperature resistant, epoxy phenolic-novolac system designed for internal tank linings requiring excellent chemical and temperature resistance over a wide range of temperatures and pressures. It is a 85% solids system for single-leg airless component spray applications.

Uses

Corrosion protection for steel tanks, vessels, internal and external pipes in a variety of industries. The coating will protect tanks, vessels and piping against crude oil, seawater, wastewater, fuels, solvents, and lubricants up to 275°F (135°C).

Features

- Excellent adhesion
- Excellent chemical resistance
- High temperature immersion resistance (up to 275°F / 135°C)
- Cathodic disbondment resistance
- Fast cure

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 (76 - 127 microns) anchor profile. Vacuum tank floor to remove grit prior to coating.

On the single leg airless unit, it shall be a minimum of 68:1 airless pump. When using an airless unit the Archco 476 should not be thinned more than 5% with Archco Thinner 400E (3 lbs. per 5 gal. kit / 1.4 kg per 19 L kit).

A wet-on-wet spray technique should be used to achieve a minimum thickness of 20 mils (508 microns) DFT. The coating thickness should be measured using a wet-film thickness gauge. The equipment settings are only guidelines and may vary based on equipment and specific application. Please refer to the spray application specifications for more complete information.



Archco 476 Epoxy

TECHNICAL DATA

PROPERTIES	AIRLESS - VALUE
Solids Content By Volume	85%
Base Component — unmixed @ 77°F (25°C)	
Specific Gravity	1.2
Viscosity	5,000 cP
Color	White
Hardener — unmixed @ 77°F (25°C)	
Specific Gravity	1.2
Viscosity	20,000 cP
Color	Blue
Mixed Material — mixed @ 77°F (25°C)	
Specific Gravity	1.2
Viscosity	10,000 cP
Color	Blue
Mixing Ratio (A/B) by Volume	2:1
by Weight	2:1
Cure Times	
Pot Life @ 77°F (25°C)	50 minutes
Pot Life @ 97°F (36°C)	10 minutes
Time to Dry @ 35°F (2°C)	16-20 hours
Time to Dry @ 50°F (10°C)	10-12 hours
Time to Dry @ 77°F (25°C)	3-4 hours
Cure for Immersion (crude oil)	
@ 35°F (2°C)	24 hours
@ 75°F (24°C)	12 hours
Theoretical Coverage	80 ft ² /20 mils/gallon (2.0 m ² /508 microns/L)
Thickness per coat	10-20 mils (254-508 microns)
Holiday Detection — based on min. mil.	125 volts/mil (4,920 V/mm)
Hardness (ASTM D2240-02)	Shore D 85
Adhesion to Steel	3,200 psi (22 MPa)
Application Temperature	40 to 130°F (4 to 54°C)
Service Temperature	35 to 275°F (2 to 135°C)

STORAGE: Minimum 24 months when stored in original containers @ 40°F (4°C) to 105°F (41°C). On job site where temperatures are below 50°F (10°C) product should be kept warm to allow for easy transfer into storage hoppers for warming to proper spraying temperatures.

CLEANING: Clean equipment with MEK or equivalent solvent cleaner, such as Archco 400E Thinner.

HEALTH AND SAFETY: Wear protective clothing and ensure adequate ventilation. Avoid contact with skin and eyes. See Safety Data Sheet for further information.

PACKAGING: 5 gallon (19 L), 15 gallon (57 L) kits. Other sizes available upon request.



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