

ARCHCO 476F EPOXY

Thick-Film Reinforced Epoxy Phenolic-Novolac Tank Lining

Description

Archco 476F Epoxy is a 100% solids, two-part, high-temperature resistant, epoxy phenolic-novolac system designed for internal tank linings and pipes. Archco 476F contains a proprietary mixture of flake and fiber reinforcement to meet API RP 652 (October 2006) guidelines as a thick-film reinforced lining.

Uses

Corrosion protection for steel tanks, vessels and internal & 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 300°F (149°C).

Features

- Excellent adhesion
- Excellent chemical resistance
- High temperature resistance (up to 300°F / 149°C)
- Cathodic disbondment resistance
- Fast cure
- Excellent abrasion and impact resistance

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 to 0.13 mm) anchor profile. Vacuum tank floor to remove grit prior to coating.

To spray the Archco 476F Epoxy, a plural-component, airless spray unit with a proportioning pump capable of a volume mixing ratio of 2:1 shall be used. Standard ancillary equipment should include minimum 10 gallon (38 L) hoppers, 2 each static mixers, 25 ft. (7.6 m) max x ¼" (6.4 mm) whip hose, and mastic gun with a 29 to 35 thou (0.74 - 0.89 mm) tip. Part A should be heated to 100°F-120°F (38°C - 49°C) and Part B should be heated to 90°F-110°F (32°C - 43°C). Hose bundle shall be set at 100°F-120°F (38°C - 49°C). A wet-on-wet spray technique should be used to achieve a minimum thickness of 60 to 80 mils (1524 - 2032 microns). 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 476F Epoxy

TECHNICAL DATA

PROPERTIES	AIRLESS - VALUE
Solids Content By Volume	75%
Base Component — unmixed @ 77°F (25°C)	
Specific Gravity	1.3
Viscosity	6,000 cP
Color	White
Hardener — unmixed @ 77°F (25°C)	
Specific Gravity	1.4
Viscosity	10,000 cP
Color	Blue
Mixed Material — mixed @ 77°F (25°C)	
Specific Gravity	1.3
Viscosity	7,000 cP
Color	Blue
Mixing Ratio (A/B) by Volume	2:1
 by Weight	2:1
Cure Times	
Pot Life @ 77°F (25°C)	60 minutes
Pot Life @ 97°F (36°C)	30 minutes
Time to Dry @ 35°F (2°C)	12-16 hours
Time to Dry @ 50°F (10°C)	8-10 hours
Time to Dry @ 77°F (25°C)	2-3 hours
Cure for Immersion (crude oil)	
@ 35°F (2°C)	20 hours
@ 75°F (24°C)	8 hours
Theoretical Coverage	32 ft ² /50 mils/gallon (0.8 m ² /1.3 mm/L)
Thickness per coat	60 to 80 mils (1,524 - 2,032 microns)
Holiday Detection – based on min. mil.	100 volts/mil (3,936 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 300°F (2 to 149°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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