

# ARCHCO 476 LT EPOXY

**A Low Temperature Cure Version of Archco 476**

## Description

Archco 476 LT 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 designed for plural-component spray applications at low ambient temperatures and / or where fast return to service is required.

## 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 return to service
- Application at temperature down to 20°F (-7°C)

## 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.

To spray the Archco 476 LT 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 hoppers, 2 each static mixers, 25 ft. (7.5 m) max x ¼" (6.25 mm) whip hose, and mastic gun with a 23 to 31 thou 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 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.



