

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.

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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 mls/gallon (2.0 m ² /508 microns/L)
Thickness per coat	10-20 mls (254-508 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 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).
Other sizes available upon request.



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