## PRODUCT DATA SHEET

# ARCHCO<sup>™</sup> 476F EPOXY

Thick-Film Reinforced Epoxy Phenolic-Novolac Tank Lining

### **Description**

Archco 476F Epoxy is an 85% 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 225°F (107°C).

#### **Features**

- · Excellent adhesion
- · Excellent chemical resistance
- High temperature resistance (up to 250°F / 121°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 single-leg, airless spray unit shall be used. Standard ancillary equipment should include a mastic gun with 29 to 35 thou tip. A wet-on-wet spray technique should be used to achieve a minimum thickness of 20 to 30 mils (508 - 762 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

TECHNICAL DATA	
Properties	Airless - Value
Solids Content By Volume Base Component — unmixed @ 77°F (25°C)	85%
Specific Gravity	1.2
Viscosity	8,000 cP
Color	White
Hardener — unmixed @ 77°F (25°C)	Willie
Specific Gravity	1.3
Viscosity	12,000 cP
Color	Blue
Mixed Material — mixed @ 77°F (25°C)	2.00
Specific Gravity	1.2
Viscosity	10.000 cP
Color	Blue
Mixing Ratio (A/B) by Volume	2:1
by Weight	1:8:1
Cure Times	1.0.1
Pot Life @ 77°F (25°C) Pot Life @ 97°F (36°C) Time to Dry @ 50°F (10°C) Time to Dry @ 77°F (25°C)  Cure for Immersion (crude oil)	30 minutes 5 minutes 12-16 hours 4 hours
@ 75°F (24°C)	14 hours
Theoretical Coverage	27 ft²/50 mils/gallon (0.65 m²/1.3 mm/L)
Thickness per coat Holiday Detection – based on min. mil. Hardness (ASTM D2240-02) Adhesion to Steel Application Temperature Service Temperature	20 to 30 mils (508 - 762 microns) 100 volts/mil (3,936 V/mm) Shore D 85 3,200 psi (22 MPa) 50°F to 130°F (10°C to 54°C) 35°F to 250°F (2°C to 121°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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