PRODUCT DATA SHEET

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.



Archco 476 LT Epoxy

TECHNICAL DATA

TECHNICAL DATA	
Plural - Value	
100%	
1.3	
80,000 cP	
White	
1.3	
2,000 cP	
Blue	
1.3	
60,000 cP	
Blue	
2:1	
2:1	
30 minutes	
5 minutes	
12-16 hours 8-10 hours	
2-3 hours	
2 0 110010	
20 hours	
8 hours	
80 ft²/20 mils/gallon (2.0 m²/0.50 mm)	
10-20 mils (254 - 508 microns)	
100 volts/mil (3,936 V/mm)	
Shore D 85	
3,200 psi (22 MPa)	
20°F to 100°F (-7°F to 38°C)	
35°F to 275°F (2°F 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 liter) & 15 gallon (57 liter) kits. Other sizes available upon request.



HOUSTON: 9710 Telge Road, Houston, Texas, U.S.A. 77095 Tel: 1-281-821-3355 Fax: 1-281-821-0304 TORONTO: 90 Ironside Crescent, Unit 12, Toronto, Ontario, Canada M1X1M3 Tel: 1-416-291-3435 Fax: 1-416-291-0898

e-mail: info@premiercoatings.com

www.premiercoatings.com

A Member of Winn & Coales International

The information given on this sheet is intended as a general guide only and should not be used for specification purposes. We believe the information to be accurate and reliable but do not guarantee it. We assume no responsibility for the use of this information. Users must, by their own tests, determine the suitability of the products and information supplied by us for their own particular purposes. No patent liability can be assumed.