

# ARCHCO™ 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 250°F (121°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 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 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

<b>PROPERTIES</b>	<b>AIRLESS - VALUE</b>
<b>Solids Content By Volume</b>	85%
<b>Base Component — unmixed @ 77°F (25°C)</b>	
Specific Gravity	1.2
Viscosity	8,000 cP
Color	White
<b>Hardener — unmixed @ 77°F (25°C)</b>	
Specific Gravity	1.3
Viscosity	12,000 cP
Color	Blue
<b>Mixed Material — mixed @ 77°F (25°C)</b>	
Specific Gravity	1.2
Viscosity	10,000 cP
Color	Blue
<b>Mixing Ratio (A/B) by Volume</b>	2:1
<b>    by Weight</b>	1:8:1
<b>Cure Times</b>	
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
<b>Cure for Immersion (crude oil)</b>	
@ 35°F (2°C)	20 hours
@ 75°F (24°C)	8 hours
<b>Theoretical Coverage</b>	27 ft <sup>2</sup> /50 mils/gallon (0.65 m <sup>2</sup> /1.3 mm/L)
<b>Thickness per coat</b>	60 to 80 mils (1,524 - 2,032 microns)
<b>Holiday Detection — based on min. mil.</b>	100 volts/mil (3,936 V/mm)
<b>Hardness (ASTM D2240-02)</b>	Shore D 85
<b>Adhesion to Steel</b>	3,200 psi (22 MPa)
<b>Application Temperature</b>	40 to 130°F (4 to 54°C)
<b>Service Temperature</b>	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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