

ARCHCO 476P EPOXY

High Temperature Internal Epoxy Phenolic-Novolac Lining for Tanks and Pipes 100% Solids - Plural Component

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 100% solids systems for plural 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.

To spray the 100% solids version of Archco 476 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 (38 L) hoppers, 2 each static mixers, 25 ft. max x 1/4" whip hose (7.5 m max. x 6.25 mm), and mastic gun with a 23 to 31 thou (0.58 - 0.79 mm) 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 476P Epoxy

TECHNICAL DATA

PROPERTIES	PLURAL - VALUE
Solids Content By Volume	100%
Base Component — unmixed @ 77°F (25°C)	
Specific Gravity	1.3
Viscosity	80,000 cP
Color	White
Hardener — unmixed @ 77°F (25°C)	
Specific Gravity	1.3
Viscosity	2,000 cP
Color	Blue
Mixed Material — mixed @ 77°F (25°C)	
Specific Gravity	1.3
Viscosity	60,000 cP
Color	Blue
Mixing Ratio (A/B) by Volume	2:1
by Weight	2:1
Cure Times	
Pot Life @ 77°F (25°C)	30 minutes
Pot Life @ 97°F (36°C)	5 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
Cure for Immersion (crude oil)	
@ 35°F (2°C)	20 hours
@ 75°F (24°C)	8 hours
Theoretical Coverage	80 ft ² /20 mils/gallon (2.0 m ² /508 microns/L)
Thickness per coat	10-40 mils (254-1016 microns)
Holiday Detection – based on min. mil.	100 volts/mil (3,936 V/mm)
Hardness (ASTM D2240-02)	Shore D 85
Recoat Window	36 to 48 hours @ 75°F (24°C)
Adhesion to Steel	3,200 psi (22 MPa)
Application Temperature	35 to 120°F (2 to 49°C)
Service Temperature	35 to 275°F (2 to 135°C)

NOTE: Need to scuff the surface before application of the touch up if it is past 48 hours.

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.



HOUSTON:
9747 Whithorn Drive,
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.