

# ARCHCO 476F EPOXY

## Thick-Film Reinforced Epoxy Phenolic-Novolac Tank Lining

### Description

Archco 476F Epoxy is a 100% 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 300°F (149°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 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. (7.6 m) max x ¼" (6.4 mm) whip hose, and mastic gun with a 29 to 35 thou (0.74 - 0.89 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 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.



