

# 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
<b>Solids Content By Volume</b>	100%
<b>Base Component — unmixed @ 77°F (25°C)</b>	
Specific Gravity	1.3
Viscosity	80,000 cP
Color	White
<b>Hardener — unmixed @ 77°F (25°C)</b>	
Specific Gravity	1.3
Viscosity	2,000 cP
Color	Blue
<b>Mixed Material — mixed @ 77°F (25°C)</b>	
Specific Gravity	1.3
Viscosity	60,000 cP
Color	Blue
<b>Mixing Ratio (A/B) by Volume</b>	2:1
<b>by Weight</b>	2:1
<b>Cure Times</b>	
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
<b>Cure for Immersion (crude oil)</b>	
@ 35°F (2°C)	20 hours
@ 75°F (24°C)	8 hours
<b>Theoretical Coverage</b>	80 ft <sup>2</sup> /20 mils/gallon (2.0 m <sup>2</sup> /508 microns/L)
<b>Thickness per coat</b>	10-40 mils (254-1016 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>Recoat Window</b>	36 to 48 hours @ 75°F (24°C)
<b>Adhesion to Steel</b>	3,200 psi (22 MPa)
<b>Application Temperature</b>	35 to 120°F (2 to 49°C)
<b>Service Temperature</b>	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.



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