

# PRODUCT DATA SHEET

## ARCHCO 436™ EPOXY

### Epoxy Lining for Pipes, Tanks, and Railcars in Water Service

#### Description

Archco 436 is a multi-purpose, surface-tolerant, 100% solids, two-part epoxy coating system designed for internal pipe, tank, and hopper car linings. Archco 436 is suitable for single-leg or plural-component spray application.

#### Uses

Corrosion protection for internal steel and steel pipes in a variety of industries. The lining will protect the steel against seawater, wastewater, and any other water service offering chemical, fuel and solvent resistance up to 160°F (65°C). Archco 436 is an FDA-Compliant coating system suitable for direct food contact. It is in accordance with CFR Title 21, Part 175.300, and 175.105 for direct and indirect food contact as a resinous adhesive or coating.

#### Features

- Excellent adhesion
- Cathodic disbondment resistance
- Excellent flexibility
- Excellent abrasion and impact resistance
- Suitable for salt and fresh water immersion
- Good adhesion to damp surfaces and tight rust
- Surface tolerant

#### 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, per SSOC-SO 10, NACE No. 2 or Sa 2-1/2. Appropriate angular grit shall be used to achieve a 3-5 mil (76 - 127 microns) anchor profile. Remove grit prior to coating. In-situ pipe lining normally uses a 1.5 mil (38 microns) anchor profile due to the small application thickness.

To apply Archco 436 using a plural unit, a plural-component, airless spray unit with a proportioning pump capable of a volume mixing ratio of 1:1 shall be used. Standard ancillary equipment should include minimum 10 gallon (38 L) hoppers, 2 each static mixers, 25 ft. max x ¼" (7.6 m x 6.3 mm) whip hose, and a mastic gun with 23-31 thou tip. Part A should be heated to 80°F-100°F (26°C-38°C) and Part B should be heated to 90°F-110°F (32°C-43°C). Hose bundle shall be set at 90°F-110°F (32°C-43°C). To apply Archco using a single-leg unit, a unit with a minimum of 68:1 airless pump shall be used. When using the airless unit, the Archco 436 should not be thinned more than 5% with Archco 400E (3 lbs per 5 gal kit (1.4 kg/19L kit).

A wet-on-wet spray technique should be used to achieve a thickness of 10 - 30 mils (254 - 762 microns) DFT. The coating thickness should be measured using a wet-film thickness gauge. Holiday testing shall be performed to ensure a pinhole free lining. The equipment settings are only guidelines and may vary based on equipment and specific application.



