

ARCHCO™ 467 EPOXY

**Dry Heat Resistant Glass Flake Coating for Interior Tubulars
High Temperature and Chemically Aggressive Environments**

Description

Archco 467 Epoxy is a multi-purpose, two-part, epoxy phenolic novolac coating system designed for applications requiring excellent chemical resistance to oil products, acids (sulfuric and hydrochloric), solvents, inorganic salts and water. Archco 467 Epoxy also provides excellent thermal resistance. Archco 467 is suitable for application via single-leg spray equipment.

Uses

Archco 467 Epoxy provides corrosion protection for internal steel in a variety of industries. The coating will protect vessels against crude oil, natural gas, seawater, wastewater, fuels, solvents, lubricants, acids, H₂S, and inorganic salts. Archco 467 Epoxy provides dry heat resistance up to 500°F (260°C) and up to 420°F (216°C) service depending on the fluids present.

Features

- Very low permeability
- Excellent adhesion
- Excellent chemical resistance
- Excellent resistance to H₂S gases
- Excellent temperature resistance (up to 500°F/260°C)
- Excellent abrasion resistance
- Post cure at 200°F (93°C) for 2 hours required
(Refer to spray application spec for complete cure schedule)

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, white finish, per SSPC-SP 5, NACE No. 1 or Sa 3. Appropriate angular grit shall be used to achieve a 2.5-5 mil (0.063 - 0.125 mm) anchor profile. Vacuum vessel floor to remove grit prior to coating.

A single-leg, airless spray unit may also be used. The unit shall have a minimum of 68:1 airless pump and mastic gun with a 28 to 35 (0.71 to 0.88 mm) thou tip. A minimum of 2800 psi (17.5 MPa) fluid pressure at the tip is required for proper atomization. When using the airless unit, the Archco 467 should not be thinned more than 5% with Archco 400E Thinner, 3 lbs per 5 gal kit (1.35 kg per 19 L kit). Material shall be between 70°F and 90°F (21°C-32°C).

A wet-on-wet spray technique should be used to achieve a thickness of 20-60 mils (0.5 - 1.5 mm) DFT in two coats of 15-20 mils (0.4 - 0.5 mm) DFT per coat. 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. The application information provided here is meant to provide preliminary information. Please refer to the spray application specification for more complete information.



Archco™ 467 Epoxy

TECHNICAL DATA

PROPERTIES	VALUE
Solids Content, by volume	86%
Base Component – unmixed @ 77°F (25°C)	
Specific Gravity	1.4
Viscosity	30,000 cP
Color	White
Hardener – unmixed @ 77°F (25°C)	
Specific Gravity	1.1
Viscosity	15,000 cP
Color	Amber
Hardener – unmixed @ 77°F (25°C)	
Specific Gravity	1.4
Viscosity	25,000 cP
Color	Off-white
Mixing Ratio (A/B) by Volume	4:1
By Weight	5.5:1
Cure Times	
Dry to Touch @ 90°F (32°C)	10-12 hours
Time to Cure @ 200°F (93°C)	2 hours min.
Recoat Window @ 90°F (32°C)	24 hours
Theoretical Coverage	90 ft ² /15 mils/gallon (2.2 m ² /381 microns/L)
Thickness per coat	15-20 mils DFT (381-508 microns)
Holiday Detection – based on minimum mils	100 V/mil (3,936 V/mm)
Hardness (ASTM D2240-02)	Shore D 80
Adhesion to Steel	3,200 psi (22 MPa)
Immersion Heat Resistance	420°F (216°C)
FBE	420°F (216°C)
Application Temperature	90°F-130°F (32°C-54°C)
Service Temperature	35°F-350°F (2°C-177°C)

STORAGE: Minimum 24 months when stored in original containers between 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 liter).



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