

ARCHCO 490™ EPOXY

A Multi-service, Multi-temperature Inorganic Coating

Description

Archco 490 inorganic copolymer is a two-component, high-solids, corrosion resistant lining.

Uses

Designed as a corrosion resistant lining for operation between -321°F (-196°C) to +1202°F (+650°C). Suitable for protecting above ground piping and equipment for cryogenic and high temperature service. Suitable for use on surfaces either uninsulated or under thermal insulation.

Features

- Low viscosity allows for superb penetration and adhesion to properly prepared surfaces.
- Excellent corrosion protection.
- Ambient cure.
- May be applied to properly prepared carbon steel, stainless steel, and inorganic zinc.
- Not suitable for buried service.

Application

Mixing: Material is supplied in two containers as a unit. Always mix a complete unit in the proportions supplied. Once the unit has been mixed it must be used within the working pot life specified.

1. Before mixing, agitate base (Part A) with a power agitator.
2. Combine entire contents of catalyst (Part B) with base and mix thoroughly with power agitator.

Surface Preparation: Surface preparation is very important and will improve the adhesion and extend the life of Archco 490. Surface preparation should include the following for carbon steel, stainless and inorganic zinc application:

- Surface must be at least 4°F (4°C) prior to application.
- Surfaces must be dry, clean, free of oil, grease, and other contaminants and must be structurally sound.
- Remove all loose paint, mill scale and rust.
- The minimum blast clean standard is SSPC-SP10 or ISO 8501-1:2007 Sa 2½. Blast profile is 2 mils. Surface defects revealed by the blast cleaning process, should be ground, filled, or treated in the appropriate manner.
- Airless spray recommended. Tip range 15-19 thou. Total output fluid pressure at spray tip not less than 2005 psi. For airless spray application: a 30:1 pump or larger is recommended. Ideally, fluid hoses should not be less than 3/8" id and not longer than 50 feet to obtain optimum results. May also be sprayed conventional.



PRODUCT DATA SHEET

Application

- Typical film thickness: (COLD SUBSTRATE) Below 50°F (10°C) substrate temperature
 - PRIMER (1st coat) ARCHCO 320 (INORGANIC ZINC)
 - Wet - 5 to 7 mils (127 to 178 microns)
 - Dry - 3 to 5 mils (76 to 127 microns)
 - TOPCOAT (2nd coat) ARCHCO 490 (High Build)
 - Wet - 5 to 8 mils (178 to 203 microns) / 1.3 to 2.7 mils (33 To 68 microns)
 - Dry - 3 to 5 mils (76 to 127 microns) / 1 to 1.7 mils (25 To 43 microns)
 - Total system DFT = 6 to 10 mils (152 to 254 microns)
- Typical film thickness: (HOT SUBSTRATE) Above 100°F (38°C) up to 750°F (399°) substrate temperature
 - PRIMER (1st coat) Archco 320 (INORGANIC ZINC)
 - Wet - 5 to 7 mils (127 to 178 microns)
 - Dry - 3 to 5 mils (76 to 127 microns)
 - TOPCOAT - (2nd coat) Archco 490 (Low Build)
 - Wet - 1.7 to 2.5 (43 to 67 microns) / 0.6 to 0.8 mils (15 To 20 microns)
 - Dry - 1.0 to 1.5 (25 to 38 microns) // 0.3 to 0.5 mils (8 To 12 microns)
 - Total system DFT = 4.0 to 6.5 mils (102 to 165 microns)

For temperatures above 750°F (399°C) up to 1202°F (650°C), use Archco 490 (Low Build) @ 1.5 mils total system DFT



Archco 490™ Epoxy

TECHNICAL DATA

PROPERTIES	VALUE
Solids Content	60% (± 0.2%)
Mixed VOC	3.00 lbs./gal. (360 grams/liter)
Mix Ratio	Mix pre-weighed base (Part A) to pre-weighed catalyst (Part B) Always mix full containers.
Dry time @ 77°F (25°C) and 50% rh	
Set to Touch	30 minutes
Dry Hard	3 hours
Minimum Recoat	6 hours
Maximum Recoat	14 days
Gloss Level	Low Gloss
Pot life @77°F (25°C)	6 hours
	*** Archco 490 reacts with atmospheric moisture and needs to be covered at all times. Failure to keep Archco 490 covered will result in skinning of unused material and loss of pot life.
Product Color	Zinc gray (primer) Archco 320, light gray (topcoat) Archco 490
Flash Point	Mixed 80°F (27°C)
Thinner	Not normally required, but if needed, use 400X. Use of faster evaporating solvent may adversely affect the working of the product.
Clean Up	400X

STORAGE: Store in a dry, well-ventilated area between 40°F to 105°F (4°C to 41°C) in original, unopened containers. Shelf life is at least 12 months under these conditions. It is recommended that all components be stored between 68°F to 86°F (20°C to 30°C) for 24 hours prior to use for optimum pumping and productivity.

CLEANING: Clean equipment with 400X or equivalent solvent cleaner.

HEALTH AND SAFETY: Wear protective clothing and ensure adequate ventilation. Avoid contact with skin and eyes. See Safety Data Sheet for further information.

PACKAGING: 1 Gallon (3.8 liters) and 5 Gallon (19 liters kits). Other sizes available upon request.



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