

ARCHCO 426™ EPOXY

Ultra-High Solids Lining for Potable Water Pipes and Tanks

Description

Archco 426 Epoxy is a two-part, ultra-high solids, low-VOC, drinking water safe epoxy lining for immersion service in potable water pipes and storage tanks. It does not require induction and may be applied in one or two coats.

Uses

- Potable water fittings, valves, meters, and pumps (6" diameter and greater)
- Potable water storage tanks (>10,000 gallons)
- Potable water pipes (36" diameter and greater)
- Immersion service in fresh and salt water

Features

- Meets or exceeds AWWA C210
- Approved to standard NSF/ANSI/CAN-61 & 372 for potable water
- No induction time required
- No primer required, apply direct to surface
- One or two coat protection
- High solids (>98 vol% solids)
- Low VOC/HAPS (<0.1 lbs/gal / 15 g/L)
- Suitable for use in SCAQMB restricted area

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. Agitate base (Part A) and catalyst (Part B) with a power agitator.
2. Combine entire contents of catalyst (Part B) with base (Part A) and mix thoroughly with power agitator.

Surface Prep

Surface preparation is very important and will improve the adhesion and extend the life of the Archco 426 Epoxy. Surface preparation should include the following:

- Surface must be at least 50°F (10°C) prior to application.
- Surfaces must be dry, clean, free of oil, grease, and other contaminants, and must be structurally sound.
- SSPC-SP10 / NACE 2 / ISO SA 2 ½ near-white metal blast. Appropriate angular grit shall be used to achieve a 2 to 3 mil (50 to 75 microns) anchor profile.



Certified to
NSF/ANSI/CAN 61
& 372

TECHNICAL DATA SHEET

Application

Airless Spray: Tip range 19-23 thou. Total output fluid pressure at spray tip not less than 3,000 psi. A 56:1 pump or larger is recommended. Ideally, fluid hoses should not be less than 3/8" ID and no longer than 50 feet to obtain optimum results.

- Reduction/Thinning – Isopropyl alcohol – 5 wt% maximum.
- One Coat Application – 24 to 28 mils (600 to 700 microns) WFT.
- Two Coat Application – 12 to 14 mils (300 to 350 microns) WFT per coat.

Plural Spray: Tip range 19 to 23 thou. Total output fluid pressure at spray tip not less than 3,000 psi. A 56:1 pump or larger is recommended. Ideally, fluid hoses should not be less than 3/8" ID and no longer than 50 feet to obtain optimum results.

- Mix Ratio – 1:1 by volume.

Application By Roller: Nap size 3/16" to 3/8". The product can also be hand brushed.

- Typical film thickness: 12 to 14 mils (300 to 350 microns) WFT per coat.
- One coat application: 24 to 28 mils (600 to 700 microns) WFT.

Note: Brush or roll application may require additional thinning, and multiple coats to achieve maximum film thickness, and uniformity of appearance. Brush or roll application is recommended for stripe lining, and repair only.

Storage

Store in a dry, well-ventilated area between 40°F to 90°F (4°C to 32°C) in original, unopened containers. Shelf life is at least 24 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 MAK (methyl amyl ketone), Isopropyl alcohol, or xylene.

HSE

Wear protective clothing and ensure adequate ventilation. Avoid contact with skin and eyes. See Safety Data Sheet (SDS) for further information.

Color

White or Gray – Contact Denso for other color alternatives.

Packaging

Kit Sizes	Part A	Part B
5 gals (19 liters) kit	1 ea. 2.5 gals (9.46 liters) pails	1 ea. 2.5 gal (9.46 liters) pails
Contact Denso for other kit size alternatives.		

TECHNICAL DATA SHEET

Tech Data

Properties	Imperial	Metric
Solids Content by Volume	98.0% ± 0.2	98.0% ± 0.2
Mixed VOC	0.09 lbs./gal	11 g/L
Base Component (Unmixed) @ 77°F (25°C)		
Viscosity	20,000 cps	20,000 cps
Color	White	White
Hardener (Unmixed) @ 77°F (25°C)		
Viscosity	20,000 cps	20,000 cps
Color	Gray or neutral	Gray or neutral
Mixed Viscosity @ 77°F (25°C)	20,000 cps	20,000 cps
Mixing Ratio (A/B) by Volume	1 Parts Base (Part A) to 1 Part Catalyst (Part B)	1 Parts Base (Part A) to 1 Part Catalyst (Part B)
Color	White or Gray	White or Gray
Gloss Level	65% at 60°	65% at 60°
Cure Times		
Pot Life @ 77°F (25°C)	2 hour	2 hour
Set Time @ 77°F (25°C)	2 ½ hours	2 ½ hours
Tack Free Time @ 77°F (25°C)	7 hours	7 hours
Through Cure	24 hours	24 hours
Full Cure	7 days	7 days
Recoat @ 77°F (25°C)	8 hours (min.), 14 days (max)	8 hours (min.), 14 days (max)
Cure for Immersion (Water)	Shore D 75-80 Hardness	Shore D 75-80 Hardness
Theoretical Coverage	121 ft ² /gal @ 13 mils DFT	36.88 m ² /gal @ 13 mils DFT
Thickness Per Coat (Two Coats Recommended)	12-14 mils DFT per coat	300-350 microns DFT per coat
Holiday Detection - based on min. mil.	100 volts/mil	3,936 V/mm
Hardness (ASTM D2240-02)	Shore D 85	Shore D 85
Adhesion to Steel	2,200 psi	(15 MPa)



DENSO, INC.

HOUSTON:
9710 Telge Road,
Houston, Texas,
U.S.A. 77095
Tel: 281-821-3355
Fax: 281-821-0304

TORONTO:
90 Ironside Crescent,
Unit 12, Toronto,
Ontario, Canada M1X1M3
Tel: 416-291-3435
Fax: 416-291-0898

www.densona.com

info@densona.com

**A Member of Winn
& Coales International**

The information given on this sheet is intended as a general guide only and should not be used for specification purposes. We believe the information to be accurate and reliable but do not guarantee it. We assume no responsibility for the use of this information. Users must, by their own tests, determine the suitability of the products and information supplied by us for their own particular purposes. No patent liability can be assumed.