

ARCHCO 453JF EPOXY

Internal Lining for Jet Fuel Service

Description

Archco 453JF Epoxy is a two-part, high-temperature resistant, epoxy novolac system designed for internal tank linings requiring excellent chemical and temperature resistance over a wide range of temperatures and pressures. It conforms to MIL-P-23236D, and is recommended for industrial and marine exposures on steel. It provides excellent surface wetting and adhesion properties.

Uses

- Corrosion protection for steel tanks, ballast tanks, vessels, internal and external pipes in a variety of industries.

Features

- Excellent solvent/fuel resistance
- High temperature stability
- High solids, low odor, low VOC
- High temperature water resistance
- Conforms to MIL-P-23236D Type VI, Class 5, Grade C
- Resists a wide range of chemicals, produced water, seawater, and fuels
- Protect tanks, vessels and piping against crude oil, seawater, wastewater, fuels, solvents, and lubricants up to 180°F (82°C).

Surface Prep

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.

Application

A wet-on-wet spray technique should be used to achieve a minimum thickness of 12 to 16 mils (305 to 406 microns) DFT. Total thickness should not exceed 25 mils (635 microns). 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.



TECHNICAL DATA SHEET

Storage

Minimum 24 months when stored in original containers @ 40°F (4°C) to 105°F (41°C).

Cleaning

Clean equipment with MEK or equivalent solvent cleaner, such as Archco 400E Thinner.

HSE

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

Packaging

Kit Sizes	Part A	Part B
gals	ea.	ea.
5 gals (19 liters) kit*	1 ea. - 4 gals (15.12 liters) pail	1 ea. - 1 gal (3.78 liters) pail

*Note - Other sizes available upon request.

TECHNICAL DATA SHEET

Tech Data

Properties	Imperial	Metric
Solids Content	75%	75%
Base Component – (Unmixed) @ 77°F (25°C)		
Viscosity	16,000 cps	16,000 cps
Color	White	White
Hardener – (Unmixed) @ 77°F (25°C)		
Viscosity	25 cps	25 cps
Color	Black	Blue
Mixed Material @ 77°F (25°C)		
Viscosity	12,000 cps	12,000 cps
Mixing Ratio (A/B) by Volume	4 parts Base:1 part Hardener	4 parts Base:1 part Hardener
Cure Times		
Pot Life @77°F (25°C)	2 hour	2 hour
Set Time @77°F (25°C)	3 hour	3 hours
Tack Free Time @77°F (25°C)	7 hours	7 hours
Cure for Immersion (crude oil) @77°F (25°C)		
	Shore D 75-80 Hardness	Shore D 75-80 Hardness
Theoretical Coverage	75 ft ² /16 mils/liter	22.86 m ² /406.4 microns/liter
Thickness per coat (Two coats recommended)		
Minimum/Maximum	6 to 8 mils	152 to 203 microns
Holiday Detection - based on min. mil.	100 Volts/mil	3,9366 V/mm
Hardness (ASTM D2240-02)	85 +/-	85 +/-
Adhesion to Steel	2,750 psi	19 MPa



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