

ARCHCO™ 460 EPOXY

Two Part Phenolic for Internal Tank Linings

Description

Archco™ 460 Epoxy is a two-part high solids epoxy phenolic designed for internal tank and pipe linings. An option with glass flake is available.

Uses

Corrosion protection for steel tanks and internal pipes in a variety of industries. The coating will protect tanks and piping against crude oil, seawater, wastewater, fuels, solvents, lubricants and acids.

Features

- 80% solids
- Very low permeability
- Cures at temperatures down to 40°F (5°C)
- Excellent adhesion and abrasion
- Excellent undercutting resistance
- Good flexibility
- Can be sprayed using single component airless equipment

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, SSPC-SP 10, NACE No. 2 or Sa 2-1/2. Appropriate angular shall be used to achieve a 3 to 5 mil (76 - 127 microns) anchor profile.

For larger areas, the Archco™ 400 Primer/Sealer can be applied at 5 to 6 mils (127 - 152 microns) in thickness. When using a single-leg airless unit the temperature of the Archco™ 460 should not be less than 70°F (21°C). The unit should shall be a minimum of 68:1 airless spray pump and a 27 to 31 thousands tip (686 - 787 microns) shall be used. Initially stir Part A & Part B separately prior to adding Part B. The Part B shall then be added and mixed thoroughly using a mechanical whip. The mixed Archco™ 460 shall be sprayed immediately after mixing. The coating thickness should be measured using a wet film thickness gauge. A wet on wet spray technique should be used to achieve a minimum of 20 to 25 mils (508 - 635 microns).

For complete application instructions please refer to Archco™ 460 Epoxy Lining Application Specifications.



Archco™ 460 Epoxy

TECHNICAL DATA

PROPERTIES	VALUE
Solids Content	80%
VOC Content	0.96 lbs/gal (0.44 kg/liters)
Minimum Dewpoint/Substrate Differential	Dewpoint +3°C
Minimum Substrate Temperature	40°F (5°C)
Operating Temperature	-4°F (-20°C) to 200°F (93°C)
Dry Film Thickness per coat	20 Mils to 40 Mils (508 - 1016 microns)
Theoretical Coverage	1.6 m ² /L @ 635 microns
Spray Equipment Required	68:1 Airless Unit
Airless Spray Tip Size	0.027 – 0.031 in. (0.68 - 0.78 mm)
Shelf Life @ 41°F (5°C) to 110°F (43°C)	18 Months Minimum
Flash Point	225°F (107°C)
Pot Life	
@ 77°F (25°C)	160-170 Minutes
@ 97°F (36°C)	80-90 Minutes
Dry to Handle	
@ 40°F (5°C)	48 - 72 Hours
@ 50°F (10°C)	36 - 40 Hours
@ 77°F (25°C)	8 - 10 Hours
@ 100°F (38°C)	5 - 6 Hours
Cure for Immersion (Crude Oil)	
@ 40°F (5°C)	14 Days
@ 50°F (10°C)	5 Days
@ 77°F (25°C)	3 Days
@ 100°F (38°C)	36 Hours
Thinner	Not recommended
Ratio by volume (A to B)	3:1 Ratio
Performance Data	
Crude Oil	Excellent
Water	Excellent
Solvents	Very Good
Acids (inorganic)	Very Good
Salt	Excellent
Alkalies	Excellent
Colour	Buff

STORAGE: Minimum 18 months when stored in original containers between 41°F (5°C) to 110°F (43°C). On job-site where temperatures are below 70°F (21°C), product must be kept warm to mix properly.

CLEANING: Clean equipment with MEK or equivalent solvent cleaner.

HEALTH AND SAFETY: Wear protective clothing and ensure adequate ventilation. Avoid contact with skin and eyes. See safety data sheets (SDS) for further information.

PACKAGING: 4 gallon (15 liters) kits standard.



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