



# ARCOR®

EPOXY TECHNOLOGIES®

## PRODUCT DATA SHEET

**ARCOR™ Arcthane**

REVISED 09/18/01

**GENERIC TYPE:** AMINE CURED 100% SOLIDS EPOXY/URETHANE CAULK.

**DESCRIPTION AND RECOMMENDED USES:** ARCOR™ ARCTHANE is a high elongation, elastomeric, hybridized epoxy/urethane. It is ideally suited for expansion joint sealing and crack repair, and it is completely compatible with epoxy coatings. The urethane aspect delivers a tough, flexible resilience while the epoxy aspect provides improved water and chemical resistance and shelf stability. ARCOR™ ARCTHANE's epoxy reactivity eliminates the moisture sensitivity and toxicity associated with traditional urethanes. ARCOR™ ARCTHANE is a light paste and is easily applied by squeegee or caulk gun up to 500 mils without slump.

### FOR INDUSTRIAL USE ONLY

### **SPECIFICATION DATA**

**TEMPERATURE:** Immersion service  
Max. 180°F(82°C); Spike to 200°F(93°C) 3 Hrs  
Min. 0°F(-18°C). Dry Max. 200°F, Spike 225°F.

**CHEMICAL RESISTANCE:**

Water:	Excellent
Alkalies:	Good
Inorganic Acids:	Fair
Organic Acids:	Fair
Organic Solvents:	Poor

**ABRASION:** Good

**FLEXIBILITY:** Excellent  
Elongation 500%

**FILM THICKNESS:** Up to 500 mils/coat

**APPLICATIONS:** Water Box /Tube Sheet  
Expansion Joints, Crack Repair, Abrasion  
Protection, Cavitation Protection, Concrete.

**SOLIDS BY VOLUME:** 100%

**VISCOSITY:** Light Paste

**POT LIFE:** 55 MIN/Gal @ 72°F

**MIX RATIO:** 2:1 by Volume (Base:Activator)  
50 gm:100 gm by weight

**COLOR:** Teal Blue

**SHELF LIFE:** 5 Years at 55-95°F (13-35°C)

**COVERAGE:** Varies with thickness applied

**WEIGHT PER GALLON:** 11.2 lb (5.1 KG)  
1 KG = 45 cu. in

**ORDER INFORMATION:** To place orders  
and/or obtain pricing information contact:

ARCOR Epoxy Inc.  
PO Box 273  
South Dennis, MA 02660  
TEL: 800-878-9593; FAX: 888-878-9593

Manufacturer makes no warranty either expressed or implied including warranties of merchantability or fitness for a particular purpose for this product. Under no circumstances will the manufacturer be liable for incidental, consequential or other damages, breach of warranty, strict liability, or any other theory arising out of use of this product.



# ARCOR®

EPOXY TECHNOLOGIES®

## APPLICATION SHEET

**ARCOR™ Arctthane**

REVISED 09/18/01

**SEE MATERIAL SAFETY DATA SHEET BEFORE HANDLING THIS PRODUCT**

### **SURFACE PREPARATION:**

Steel surfaces are to be abrasive blasted with chloride free abrasive. Exterior applications to SSPC SP-6 commercial gray metal finish. Immersion applications to SSPC SP-6 white metal 3 to 5 mil profile. Grind all burrs, weld seems, radius sharp edges. Fresh blasted surfaces to be primed immediately with ARCOR™ S-30 Prime to prevent oxidation of surface.

Concrete surfaces should be degreased if oil and grease contamination is present. Degreased surface shall be high pressure washed, acid etched and high pressure washed again so surface is clean and free of all grease and oils and surface laitance. Existing coatings should be abrasive blasted to clean concrete. Prime with ARCOR™ ARCRETE(unfilled), ARCOR™ EE-70, EE-79 or ARCOR™ EE-10.

### **MIXING:**

Thoroughly mix Activator into Base with mixing stick or drill with low speed mixing blade scraping sides and bottom of container or mixing board. Mix by Volume 2 part Base to 1 part Activator or by weight 100 gm Base to 50 gm Activator. Mix thoroughly to produce an even colored and streak-free material.

**THINNING:** Never thin.

### **APPLICATION:**

Use heavy plastic squeegee, putty knife or caulk gun.

### **APPLICATION TEMPERATURE:**

Material: Keep between 55 to 95°F(17 to 35°C). Substrate: Keep between 45 to 105°F(7 to 40°C). The difference in temperature of the substrate and the material should never exceed 10°F(5°C). Substrate shall be a minimum of 5°F(3°C) above dew point. Do not apply if relative humidity exceeds 90%. If necessary heat metal prior to surface preparation using electric heater or heat lamp. Never use gas, oil or kerosene heaters as they will leave a greasy residue on metal surface. For best results keep all material in warm area overnight(75°F+, 24°C) for ease of mixing. If necessary base component of material can be heated by microwave for 30-45 seconds for a 1 KG Base unit or by warm water bath. Heat activator by warm water bath only. If necessary let material cool before application.

### **OVERCOAT / CURE TIME:**

Recoat between 6 and 12 hours at 77°F (25°C). Add 1 day additional cure time for each 10°F below 77°F. Subtract 15 hours of cure time for each 10°F above 77°F. Full cure before immersion 72 hours at 77°F. Force Cure: 12 hours at 120°F (49°C).

**CLEAN UP:** Clean tools immediately after use with M.E.K. or similar. Isopropyl Alcohol can be used in solvent restricted areas.

**WARNING:** Base contains epoxy resin. Activator contains alkaline amines, a strong sensitizer. May cause skin irritation, sensitization or other allergic responses. Use with good ventilation, particularly if heated or sprayed. Prevent all contact with skin or eyes. Wear protective clothing, goggles, gloves or barrier creams. Keep containers closed when not in use. Wash thoroughly after handling. In case of skin contact immediately wash with soap and water. In case of eye contact, flush with water for 15 minutes. If irritation persists seek medical attention.