



ARCOR®

EPOXY TECHNOLOGIES™

PRODUCT DATA SHEET

ARCOR® EE-121 Prime

REVISED 11/03

GENERIC TYPE: AMINE CURED 100% SOLIDS 3.6 NOVOLAC, PRIMER

DESCRIPTION AND RECOMMENDED USES: ARCOR™ EE-121 Prime is a solvent free, high 3.6 functionality epoxy Novolac coating suitable for immersion and non-immersion service. Designed specifically for as an aggressive chemical and high temperature resistant coating. Produces a tough, chemical resistant coating on ferrous and non-ferrous metals for full immersion and concrete for secondary containment.

FOR INDUSTRIAL USE ONLY

SPECIFICATION DATA

TEMPERATURE: Immersion service
Max. 350°F (177°C); Spike to 450°F (3 Hrs)
Recommended force cure at 250°F @ 2 hrs.
Dry to 500°F; Spike to 580°F (3 Hrs)

SOLIDS BY VOLUME: 100%

VISCOSITY: 60,000-85,000 cps

CHEMICAL RESISTANCE:

Water: Excellent
Alkalies: Excellent
Inorganic Acids: Excellent
Organic Acids: Excellent
Organic Solvents: Excellent

POT LIFE: 45 MIN/100gr @ 72°F

MIX RATIO: 3:1 by Volume (Base:Activator) 100 gm: 38 gm by weight

COLOR: Gray

ABRASION: Very Good

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

FLEXIBILITY: Good

COVERAGE: 80 ft² (7.5 M²)/gal/coat

WEIGHT PER GALLON: 10.8 lbs (5.3 KG)

FILM THICKNESS: 20 mils (.51 mm)/coat

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

APPLICATIONS: Methanol Pumps, Tanks, Pipes, FGD Duct. Exterior: 2 coats, Immersion: 2-3 Coats. Aggressive Chemical Tank Linings and Secondary Containment Areas, Industrial Floorings. Recommended Force Cure at 250°F @ 2 hrs for most aggressive applications.

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® EE-121 Prime

REVISED 11/03

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-10 Near White metal finish. Immersion applications to SSPC SP-5 White metal 3 to 5 mil profile. Grind flat all burrs, weld seams, radius sharp edges. Fresh blasted ferrous surfaces to be primed immediately 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, oils and surface laitance. Existing coatings should be abrasive blasted to clean concrete.

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 3 parts Base to 1 part Activator or by weight 100 grams base to 38 grams activator. Mix thoroughly to produce an even colored and streak-free material.

THINNING: Never thin.

APPLICATION:

Brush: medium to stiff bristle of sufficient quality that bristles do not pull out and stick in coating. Trim or tape to <1" nap.

Roller: good quality 1/8" nap.

Plural Spray: .027-.031 tip, 2,500-3,500 PSI, Heat to 130°F Base, 110°F Activator.

Airless Spray: Not Recommended

Conventional Spray: Not Recommended

All spray equipment should employ traps to prevent water and oil from contaminating coating and screens to prevent particulate contamination.

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:

By brush, roller or squeegee recoat while material is still soft, but tack-free, between 1-8 hours at 77°F(25°C). If overcoat window is exceeded abrade surface with course sandpaper, grinder or brush blast and wipe with MEK or Acetone. By spray application recoat between 1-4 hours at 77°F. Full cure before immersion 72 hours at 77°F. Add 1 1/2 hours additional cure time for each 10°F below 77°F. Force Cure with heat for best performance for 1 1/2 hours at 250°F(121°C).

CLEAN UP: Clean tools immediately after use with M.E.K., Acetone or similar. ARCLEAN or 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.