



# ARCOR™

EPOXY TECHNOLOGIES™

## PRODUCT DATA SHEET

**ARCOR™ EE-80**

REVISED 11/03

**GENERIC TYPE:** AMINE CURED 100% SOLIDS EPOXY PRE-PRIME, PRIME

**DESCRIPTION AND RECOMMENDED USES:** ARCOR™ EE-80 is a solvent free, very low viscosity epoxy designed as a penetrating pre-primer. It is ideally suited for use on large metal surface areas that hold the blast until an ARCOR™ coating system is applied, or to increase adhesion of a coating system to metal surfaces, in immersion service, that cannot be blasted to an SSPC-SP5 cleanliness. For external metal structures ARCOR™ EE-80 will penetrate through rusty surface and cure to a tough, water resistant coating. Excellent as a sealer on aged "white rusted" zinc surfaces. Applies in one, thin, 1.5 mil coat. Also ideal for a primer on concrete surface especially if hydrostatic pressure can be a problem.

### FOR INDUSTRIAL USE ONLY

### SPECIFICATION DATA

**TEMPERATURE:** Immersion service  
Max. 120°F (49°); Spike to 140°F (60°C) 3 Hrs  
Dry to 250°F (121°C): Spike to 300°F (149°C) 3 Hrs

**CHEMICAL RESISTANCE:**

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

**ABRASION:** Good

**FLEXIBILITY:** Very Good  
Excellent with fiberglass Mat; 1 oz/ft<sup>2</sup> (.33 KG/M<sup>2</sup>)

**Film Thickness:** 1.5 mils/coat (.04mm; 38 microns)  
Immersion/Dry: 1 coat, 2 coats if very porous especially on concrete.

**APPLICATIONS:** Tanks, Pipe, Flooring, Structural Steel, Petrochemical Tanks, Waste water tanks, Sewer Pipes, Portable water, Salt Water, Waste Water, Service/Cooling Water Systems.

**SOLIDS BY VOLUME:** 100%

**VISCOSITY:** 300-500 cps

**POT LIFE:** 4 hrs/Gal @ 77°F (25°C)

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

**COLOR:** Clear/slight amber.

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

**COVERAGE:** 1070 ft<sup>2</sup> (100 M<sup>2</sup>)/gal (theoretical)

**WEIGHT PER GALLON:** 8.4 lbs (3.8 KG)  
1 kg = 60 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.



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## APPLICATION SHEET

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

#### **SURFACE PREPARATION:**

Immersion: remove all oil, grease, surface contamination, loose rust, scale and any old coating. Although designed for use in less than ideal surface preparation it is preferred that one strive to attain as close to an SSPC SP-5, in as many areas as possible, to achieve the best long term performance of the overall coating system. At a minimum an SP-6 is required. In all cases a 3-5 mil profile is required dry: Remove all oil, grease, surface contamination, loose rust, scale, and any old coating. Although designed for use in less than ideal surface preparation the best long term performance is attained with SP\_6 cleanliness at 2-3 mil profile.

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. Sandblasting and /or scarification may be recommended depending on surface. 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. Mix by Volume 2 parts Base to 1 part Activator or by weight; 110 grams Base to 50 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

Roller: use good quality 1/8"-1/4" nap.

Plural Spray: 2,000 psi, .015-.017 tip.

Airless Spray: Low air pressure 25-40 psi, .015-.017 tip.

Conventional Spray: Graco #700 or #800 spray gun with suitable needle/nozzle and air cap combinations. ARCOR™ EE-80 applies best at low air and pot pressure, 5-10 PSI.

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 20-35 seconds for 1 KG 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 2hrs-7 days at 77°F (25°C). If over coat window is exceeded wipe entire coated area with MEK or Acetone. By spray application recoat between 1 hour - 7 days at 77°F. Full cure before immersion refer to top coat data sheet. Add 2 days additional overcoat time for each 10°F below 77°F. Subtract 18 hours of overcoat time for each 10°F above 77°F.

**CLEAN UP:** Clean tools immediately after use with M.E.K., Acetone or other Ketone blend. ACRLEAN or Isopropyl Alcohol can be used in a solvent restricted area

**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.