



# ARCOR®

EPOXY TECHNOLOGIES™

## APPLICATION SHEET

**ARCOR™ EE-91**

REVISED 11/01

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

### **SURFACE PREPARATION:**

Metal surfaces are to be cleaned and degreased then abrasive blasted with chloride free abrasive. Exterior applications to SSPC SP-10 near white metal finish minimum 3 mil profile. Immersion applications to SSPC SP-5 White Metal, 3-5 mil profile. Grind flat all burrs, weld seams, radius sharp edges. Fresh blasted surfaces to be rebuilt as quickly as possible to prevent oxidation of the surface. For larger surface areas with ferrous metals apply a primer layer of ARCOR™ EE-31 or EE-31.1 to prevent oxidation of the surface and allow time for proper rebuilding of the damaged area.

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. Prime with ARCOR™ EE-70, EE-79, 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 3 parts Base to 1 part Activator or by weight 100 grams base to 138 grams activator. Mix thoroughly to produce an even colored, streak-free material.

**THINNING:** Never thin.

### **APPLICATION:**

Use heavy plastic squeegee or putty knife. Work material into profile of substrate to achieve maximum adhesion and to remove any entrapped air. Contour to correct form with putty knife or plastic applicator. If mold or form is used, coat its surface with a release agent to prevent adhesion of the material. Machining is possible using carbide tipped tools. Grinding is possible if done within 14 hours of application at 77°F, 25°C (add 1-1/2 hour for each 10°F below 77°, subtract 1 hour for each 10° above 77°F). Large holes and cracks can be bridged with glass or metal cloth.

### **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 the 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+) 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 activated by warm water bath only. If necessary let material cool before application.

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

Recoat while material is still soft, between 6 to 14 hours at 77°F, 25°C. If overcoat window is exceeded abrade surface with course sandpaper, grinder or brush blast. Full cure before immersion 72 hours at 77°F. Add 1 day additional cure time for every 10°F below 77°F. Subtract 15 hours of cure time for each 10°F above 77°F. Force cure with heat for best performance for 1 hour at 200°F, 93°C, 12 hours at 120°F at 120°F, 49°C.

**CLEAN UP:** Clean tools immediately after use with M.E.K. or similar

**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.



# ARCOR®

EPOXY TECHNOLOGIES™

## PRODUCT DATA SHEET

**ARCOR™ EE-91**

REVISED 11/01

**GENERIC TYPE:** AMINE CURED 100% SOLIDS EPOXY REBUILD

**DESCRIPTION AND RECOMMENDED USES:** ARCOR™ EE-91 is a solvent free epoxy rebuilding compound designed for corrosion and abrasion protection of condensers and heat exchangers. The creamy smooth texture and 1:1 mix ratio makes this a versatile easy to mix and apply rebuilding compound. ARCOR™ EE-91 can be applied up to 500 mils without slump. EE-91 is; NSF certified for portable water; USDA for incidental Food Contact in Meat & Poultry Production; FDA Guideline CFR 21 Section 175.300 listed for repeated food contact use.

### FOR INDUSTRIAL USE ONLY

### SPECIFICATION DATA

**TEMPERATURE:** Immersion service Max. 120°F ; Dry to 200°F

**SOLIDS BY VOLUME:** 100%

**CHEMICAL RESISTANCE:**

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

**VISCOSITY:** Putty

**POT LIFE:** 35 MIN / KG @ 72°F

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

**COLOR:** Red

**ABRASION:** Very Good

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

**FILM THICKNESS:** up to 500 mils vertical

**COVERAGE:** varies with thickness applied

**FLEXIBILITY:** Good  
Fair Flexural Strength 10,000 psi

**WEIGHT PER GALLON:** 12.20 lbs (5.55 KG) (42 cu.in. / KG)

**APPLICATIONS:** Condensers, Heat Exchangers, Circ. Pipe, Water Screens, Pumps, Impellers, Filters, Valves, Hydro Wheels, Tank Linings, Ion Exchange Filters.

**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.