



ARCOR™

EPOXY TECHNOLOGIES™

APPLICATION SHEET

ARCOR EE-95

REVISED 1/2006

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. 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.



PRODUCT DATA SHEET

ARCOR EE-95

REVISED 01/2006

GENERIC TYPE: AMINE CURED 100% SOLIDS EPOXY REBUILD

DESCRIPTION AND RECOMMENDED USES: EE-95 is a solvent free epoxy Novolac designed particularly as a rebuilding material for metals in immersion service. It is Ideally suited for restoration or cladding material for corrosion and abrasion protection of condensers, heat exchangers and FGD units. EE-95 can be applied up to 500 mils without slump.

FOR INDUSTRIAL USE ONLY

SPECIFICATION DATA

TEMPERATURE: Immersion service Max. 265°F ;
Spike to 350°F
Recommended force cure 200°F 6 hrs

CHEMICAL RESISTANCE:

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

ABRASION: Excellent

FILM THICKNESS: up to 500 mils vertical

FLEXIBILITY: Good
Fair Flexural Strength 12,000 psi

APPLICATIONS: Condensers, Heat Exchangers,
Circ. Pipe, Water Screens, Pumps, Impellers, Filters,
Valves, Hydro Wheels, Tank Linings, Ion Exchange
Filters, FGD, Ducts, Mix Zones, I.D. Fans, Scrubbers.

SOLIDS BY VOLUME: 100%

VISCOSITY: Putty

POT LIFE: 25 MIN / KG @ 72°F

DENSITY: 1.48

MIX RATIO: 3:1 by Volume (Base:Activator)
100 gm: 25 gm by Weight

COLOR: Gray

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

COVERAGE: varies with thickness applied

WEIGHT PER GALLON: 12.4 lbs (5.6 KG)

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

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