



ARCOR™

EPOXY TECHNOLOGIES™

APPLICATION SHEET

ARCOR™ 2213 Epoxy Sticks

REVISED 06/03

SEE MATERIAL SAFETY DATA SHEET BEFORE HANDLING THIS PRODUCT

SURFACE PREPARATION:

for best results clean area to be repaired to remove loose dirt, scale and oils. Use MEK or a similar solvent and a degreaser if oils are present. If possible sand or grind the area with course paper or disk.

MIXING:

Break off the required amount from the tube. Knead by hand thoroughly to produce an even colored, streak-free material. Recommended use of lightweight rubber or latex gloves to prevent any skin irritation.

THINNING: If desired, thin with Kelone blend from 5% to 7.5% by volume

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 diamond tipped tools only. Sanding Grinding is possible if done within 1 hour of application at 77°F, 25°C. Caution: Material cures rapidly. Use only the quantity of material which can be easily applied within 4 to 5 minutes. Spreading mixed material on a mixing board or other flat surface will extend the working life. 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.

Caution: Material cures rapidly. Use only the quantity of material which can be easily applied within 4 to 5 minutes. Heating will accelerate cure time.

OVERCOAT / CURE TIME:

Recoat as soon as possible while material is still soft, within 1 hour at 77°F, 25°C. If overcoat window is exceeded abrade surface with course sandpaper, grinder or brush blast. Full cure before immersion 45 minutes at 77°F. Add 10 minutes additional cure time for each 10°F below 77°F. Subtract 15 minutes of cure time for each 10°F above 77°F.

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



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GENERIC TYPE: AMINE CURED 100% SOLIDS EPOXY REBUILDING COMPOUND.

DESCRIPTION AND RECOMMENDED USES: ARCOR™ EE-99 Stick is a solvent free two-component, moisture insensitive epoxy adhesive designed as an emergency repair or bonding material for metals, glass, concrete, or wood. It is corrosion resistant, steel reinforced and can be sanded & tooled. In Single Stick form it is easily carried and can be kneaded by hand. EE-99 sets in 5 minutes and can get put in service within 1 hour regardless of temperature. NSF Standard 61 Potable Water; USDA incidental meat & poultry contact.

FOR INDUSTRIAL USE ONLY

SPECIFICATION DATA

TEMPERATURE: Immersion service Max. 130°F (54°C) ; Dry continuous to 250°F (121°C)

CHEMICAL RESISTANCE:

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

ABRASION: Excellent

FLEXIBILITY: Fair

BOND STRENGTH: 3,000 psi @ 2 hours
4,200 psi @ 24 hours

COMPRESSIVE STRENGTH: 12,000 psi

HARDNESS: 80 shore D (full cure @ 1 hr)

DIELECTRIC: 300 volts/mil

FILM THICKNESS: up to 1000 mils/coat

APPLICATIONS: Repair burst pipes, tanks, pumps and the like which contain liquids or gases. Use for bonding Dissimilar Metals. Use for Concrete, Metal, Glass, Wood.

SOLIDS BY VOLUME: 100%

VISCOSITY: Putty

POT LIFE: 3-5 MIN @ 72°F

DENSITY: 2.18

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

COLOR: Gray

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

COVERAGE: varies with thickness applied

WEIGHT PER GALLON: 18.2 lbs (8.3 KG)
114 gr Stick = 3.2 cu.in.; 57 gr Stick = 1.6 cu.in.

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

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