

PRODUCT DATA SHEET

ARCOR® S-20 HT

REVISED 8/2016

GENERIC TYPE: AMINE CURED 100% SOLIDS EPOXY NOVOLAC TOPCOAT

DESCRIPTION AND RECOMMENDED USES: ARCOR™ S-20 HT is a modified ARCOR™ S-20 designed to increase temperature performance by up to 100F (depending on application). The increased temperature resistance will have some reduction in performance in highly aggressive acids relative to ARCOR™ S-20 HT. As with ARCOR™ S-20, ARCOR™ S-20 HT is designed specifically for use in tough chemical environments especially caustics, acids, ethanol and organic solvents. The integration of Kevlar® fibers produces a tough, highly cross-linked chemical resistant coating with high flexural, thermal, and impact strength as well as excellent high level wear resistance. Suitable for ferrous, nonferrous metals and concrete. Elevated Temperature Cure is required.

FOR INDUSTRIAL USE ONLY

SPECIFICATION DATA

TEMPERATURE: Immersion service
Max. 335°F (168°C); Spike to 475°F (246°C) (3 Hrs)
Dry 425°F (218°C); Spike to 525°F (274°C) (3 Hrs)

CHEMICAL RESISTANCE:

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

ABRASION: Excellent

FLEXIBILITY: Very Good. Excellent with Polyester or Fiberglass Mat; 1.5 oz/ft² (.5 KG/M²)

FILM THICKNESS: Hand application 15-30 mils/
coat, (.375-.750 mm)
Spray Application 15-60 mils/coat (.375-1.5 mm)

APPLICATIONS: Chemical Barge Tanks, Chemical Tanker Trucks, Neutralization Tanks, Caustic Tanks, Clarifiers, Demin Tanks, Chemical Drain Troughs, Secondary Containment, Pumps. FGD; Outlet Ducts, Absorbers, I.D. Fans, Scrubbers.

SOLIDS BY VOLUME: 100%

VISCOSITY: 70,000-98,000 cps

POT LIFE: 22 MIN/Gal @ 72°F

MIX RATIO:

3:1 by Volume (Base:Activator)
3:1 by weight

COLOR: Blue, Gray.

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

COVERAGE: @ 20 mils: 80 sf/gal (add 20% waste)

WEIGHT PER GALLON: 12.8 lbs (5.8 KG)

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

ARCOR Epoxy Inc.
PO Box 273
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TEL: 800-878-9593; Sales@ArcorEpoxy.com

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.

APPLICATION SHEET

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SEE SDS (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 with 4-5 mil profile. Grind flat all burrs, weld seams, radius sharp edges. Fresh blasted surfaces to be primed with ARCOR® S-20 HT or EE-11 Prime depending upon substrate and service.

Concrete surfaces : 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® S-20 , EE-11 Prime, EE-79, EE-10 depending upon substrate and service.

MIXING:

Thoroughly mix Activator into Base with mixing stick or drill with low speed mixing blade. Mix by Volume 3 parts Base to 1 part Activator. Or by weight 3 parts Base to 1 part Activator.

THINNING: Never thin.

APPLICATION:

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

Roller: use good quality 1/4" - 3/8" nap.

Plural Spray: .029-.039 RAC tip, 2,500 - 3,500 PSI, Heat to 160°F Base, 110°F Activator.

Airless Spray use .033-.041 RAC tip, 4,500-5,500 PSI(65:1+). Heat Base to 85F and Act to 75F minimum.

(Caution: Short Pot-Life)

Conventional Spray: Not Recommended

All spray equipment should employ traps to prevent water and oil from contaminating coating and 30 mesh screens prevent particulate contamination. Use Spray Gun such as Graco XTR-7.

APPLICATION TEMPERATURE:

Material: Keep between 55 to 95°F (13 to 35°C). Substrate : Keep between 45 to 105°F (7 to 40°C). The difference in temperature of the substrate and the coating 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 80%. 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 over night(75°F+, 24°C) for ease of mixing. If necessary Base component of material can be heated by microwave for 30 seconds for a 1 KG Base. If necessary let material cool before application. Full cure before immersion 72 hours at 72°F(25°C). Add 1 hours additional cure time for each 10°F(-12.2°C) below 77°F(25°C). Required Force Cure for 2 hours at 175°F(121°C) then 300°F(149°C) for 3 hours.

OVERCOAT / CURE TIME:

By Brush or Roller recoat between 3 and 12 hours at 72°F (22°C).

When spraying a single coat is best at 15-60 mils depending on service. If doing multiple spray coats, recoat between 2 and 12 hours. Full cure before immersion 24 Hours at 72°F. Without dehumidification keep recoat times as short as possible or wipe with Acetone immediately prior to recoat especially if humidity exceeds 60%.

CLEAN UP: M.E.K., Acetone or other Ketone blend. For solvent controlled areas use isopropyl alcohol.

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.