ARCOR
EPOXY TECHNOLOGIES

Product Data Sheet

ARCOR® 1325.2

REVISED 11/18/24

GENERIC TYPE: AMINE CURED 100% SOLIDS EPOXY PRIMER, TOPCOAT, FLOORING

DESCRIPTION AND RECOMMENDED USES: ARCOR® 1325.2 is a solvent free, moisture insensitive epoxy coating, suitable as a self-leveling flooring, particularly in aggressive environments. **ARCOR®** 1325.2 is self-priming and produces a tough, chemical resistant coating on concrete, wood, ferrous & non-ferrous metals. Use of Reactive Flexibilizing agents gives excellent flexibility without sacrificing chemical resistance, making **ARCOR®** 1325.2 ideal for concrete or metal floors with thermal, design or structural stress, without the need for fiberglass mat reinforcement. High abrasion resistance in an easy to clean surface. **ARCOR®** 1325.2 is especially suitable for external applications with aggressive exposures. Suitable for hand or spray application on metals or concrete. The long pot-life and overcoat window make this ideal for larger surface area application by airless or plural component spray. Excellent UV stability to resist yellowing and discoloration.

FOR INDUSTRIAL USE ONLY

SPECIFICATION DATA

TEMPERATURE: Immersion service
Max.145ºF (49ºC); Spike to 200ºF (79ºC)(3 Hrs).
Dry to 325ºF (149ºC)

CHEMICAL RESISTANCE:

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

ABRASION: Good

FILM THICKNESS: Can be applied up to 20 mils in a single coat. Single coat spray application. Hand application may require a 2nd coat.

FLEXIBILITY: Very Good
Excellent with Polyester Cloth; 1.5 oz/ft^2 (.5KG/M^2)

APPLICATIONS: Flooring on Concrete, Wood, Steel; Ideal for exterior applications. Resists Salt Water; Caustics, Alcohols, Light Acids.
Excellent for Secondary Containment's.

SOLIDS BY VOLUME: 100%

VISCOSITY: 2,000-8,000 cps

POT LIFE: 35 MIN/KG @ 72ºF

MIX RATIO: 2:1 by Volume (Base:Activator) 100 gm: 38 gm by weight

COLOR: Gray, Light Gray, Black, White; Yellow; Blue

SHELF LIFE: 5 Years at 55-95ºF (13-35ºC)

COVERAGE: 80 ft^2(7.5M^2)/ gal / coat @ 20mils

WEIGHT PER GALLON: 11.6 lbs (5.27 KG), 231 cu.in.)

ORDER INFORMATION: To place orders and/or obtain pricing information contact:
Novolac Epoxy Technologies Inc.
28 Jonathan Bourne Drive
Pocasset, MA 02559

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Application Sheet

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REVISED 3/2014

SEE MATERIAL 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 3 to 5 mil profile. Grind flat all burrs, weld seams, radius sharp edges. Fresh blasted ferrous surfaces should be coated immediately with **ARCOR™ 1325.2** to prevent oxidation of surface. For very large areas **ARCOR® EE-80** can be used as a pre-prime to improve adhesion to poorly prepared areas.

Concrete surfaces should be degreased if oil and grease contamination is present. Degreased surfaces 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. Clean & grind all cracks & expansion joints. Thoroughly sweep & vacuum. Prime with **ARCOR® 1325.2. ARCOR® EE-80** can be used as a pre-prime to improve adhesion to poorly prepared areas.

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 2 parts Base to 1 part Activator. Or by weight 100 grams base to 35 grams activator. Mix thoroughly to pro- duce an even colored and streak-free material.

THINNING: Not Advised; but if necessary, add 5% by volume(6oz/gal.) Acetone or MEK to extend pot-life and/or thin for cold weather application.

APPLICATION:
Brush: medium to stiff bristle of sufficient quality that bristles do not pull out and stick in coating. Trim or tape to <1" nap.
Roller: good quality 3/8" nap.
Plural Spray: .027-.035 tip, 2,000-3,500 PSI, Heat to 110ºF Base, 90ºF Activator. 30 mesh screens. Heated hose @ 120ºF
Airless Spray: .027-.035 tip, 4,000-4,500 PSI(45:1). Add 6-oz/gal of MEK or Acetone.(Caution: Short Pot-Life)
Conventional Spray: Not Recommended.
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 95ºF(17 to 35ºC). Substrate: Keep between 45 to 105ºF(7 to 40ºC). The difference in temperature of the substrate and the material should never exceed 10ºF(5ºC). Substrate shall be a minimum of 5ºF(3ºC) 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(75ºF+, 24ºC) for ease of mixing. If necessary, Base component of material can be heated by microwave for 30 seconds for a 1 MK Base 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 1-12 hours at 77ºF(25ºC). If overcoat window is exceeded abrade surface with course sandpaper, grinder or brush blast. By spray application a single coat to 20 milsis recommended. For multiple coats, recoat between 1-12 hours at 72ºF. Full cure before chemical immersion 72 hours at 72ºF. Add 12 hours additional cure time for each 10ºF below 72ºF. Subtract 12 hours of cure time for each 10ºF above 72ºF. Force Cure with heat for best performance for 4 hours at 150ºF(66ºC), 12 hours at 100ºF(38ºC).

CLEAN UP: Clean tools immediately after use with M.E.K. or similar. Isopropyl Alcohol can be used in solvent restricted areas.

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. Consult the Product Safety Data Sheets (SDS) BEFORE USE!.
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