

## PRODUCT DATASHEET

**ARCOR™ Arcrete**

REVISED 5/2013

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

**DESCRIPTION AND RECOMMENDED USES:** ARCOR™ ARCRETE is a solvent free epoxy “concrete” designed for use in repair of concrete in areas exposed to aggressive chemicals. ARCRETE produces a tough, chemical resistant coating which reaches full cure within 72 hours, unlike regular concrete, which allows for rapid turnaround of the process environment. ARCRETE can be top-coated with any ARCOR™ or ARCOR™ coating to provide for protection in the most aggressive acid or caustic environments. Low viscosity makes ARCRETE suitable as a primer when unfilled.

### FOR INDUSTRIAL USE ONLY

### SPECIFICATION DATA

**TEMPERATURE:** Immersion service  
Max. 100°F (38°C); Spike to 120°F (49°C) 3 Hrs  
Dry to 120°F (49°C); spike to 140°F (60°C) 3 Hrs

**CHEMICAL RESISTANCE:**

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

**ABRASION:** Very Good

**FLEXIBILITY:** Fair

Very Good with Fiberglass Mat; 1.5 oz/ft<sup>2</sup> (.5 KG/M<sup>2</sup>)

**FILM THICKNESS:** 10 mils unfilled, as needed filled

**APPLICATIONS:** Secondary containment, Industrial flooring, Concrete tank supports, Chemical drain troughs, Sump Basins, Rebuilding of concrete in any aggressive chemical area.

**SOLIDS BY VOLUME:** 100%

**VISCOSITY:** 700-900 cps unfilled

**POT LIFE:** 30 MIN/GAL @ 75°F

**MIX RATIO:** 3.2 by Volume (Base:Activator)  
100 gm: 62 gm by Weight

**COLOR:** Clear Amber

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

**COVERAGE:** 160 ft<sup>2</sup>(14.8 M<sup>2</sup>)/gal/coat @ 10 mils

**WEIGHT PER GALLON:** 9.3 lbs (4.21 KG)

**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

## APPLICATION SHEET

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**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 to 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 surface. Prime surface with ARCOR™ ARCRETE (unfilled) or ARCOR™ EE-31 or EE-031.1

Concrete surfaces should be degreased. 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.

#### **MIXING:**

Thoroughly mix Activator into Base with mixing stick or drill with low speed mixing blade scraping sides and bottom of containers or mixing board. Mix by Volume 3 parts Base to 2 part Activator or by weight, 100 grams base to 62 grams activator. Mix thoroughly to produce an even colored and streak-free material. Add concrete mortar at 32 lbs. (14.5) per gallon of mixed resin. Increase or decreased amount of mortar as conditions require.

**THINNING:** Never thin.

#### **APPLICATION:**

Use towel, heavy squeegee, caulking gun 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. Large holes can be bridged with glass cloth or metal. Material can be shaped by sanding/grinding before full cure.

#### **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 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 to 24°C) for easy 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 activator by warm water bath only. If necessary let material cool before application.

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

Recoat between 6 to 12 hours at 77°F (35°C). If overcoat window is exceeded abrade surface with course sandpaper, grinder or brush blast. Full cure before immersion seven days at 77°F. Add 1 day additional cure time for each 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: 12 hours at 120°F (49°C). Do not use gas or kerosene heaters.

**CLEAN UP:** Clean up 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.