

## PRODUCT DATA SHEET

### ARCOR® 2213 Epoxy Stick

REVISED 2/2014

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

**DESCRIPTION AND RECOMMENDED USES:** 2213 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. 2213 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

**FILM THICKNESS:** up to 1000 mils/coat

**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:** 7"; 4 oz stick.

**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

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 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. 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. 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.