ARCOR
EPOXY TECHNOLOGIES

PRODUCT DATA SHEET

REVISED 12/2017

ARCOR® 8506

GENERIC TYPE: EPOXY REBUILDING COMPOUND; AMINE CURED 100% SOLIDS; 0% VOC's.

DESCRIPTION AND RECOMMENDED USES: ARCOR® 8506 is an Epoxy Rebuild and is comparable to our 8505 in resin and amine design. With the addition of small mesh Ceramic Beads and specific high-strength fibers, 8506 has an extremely high level of impact, abrasion and compressive strenghts. This self-wetting formulation can be applied without a primer, can be applied at +1/2" (500 mils, 12.5mm) on verticals and overheads and can be leveled to a smooth finish requiring no topcoat dramatically minimizing application & turn-around time. ARCOR 8506 is a very convienient **1:1** Mix Ratio, by Weight or Volume, ideal for easy breakdown in-field. Similar to our EE-92 in application, look and feel, but with lower temperature limits and chemical resistances.

FOR INDUSTRIAL USE ONLY

SPECIFICATION DATA

TEMPERATURE: General Immersion service (chemistry dependant);Max. 140ºF (60C) (Spike to 200F, 3hrs (93C); Dry to 325ºF (163C) (Spike to 450F).

CHEMICAL RESISTANCE:

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

ABRASION: Excellent

FLEXIBILITY: Fair

FLEXURAL STRENGTH: 16,100 psi
(ASTM D790/7 days)
COMPRESSIVE STRENGTH: 18,900 psi
(ASTM D695/7 days)
TENSILE SHEAR: 2,590 psi
(ASTM D1002/steel:steel)

APPLICATIONS: Ore & Coal Handling Equipment, Chutes, Pumps, Impellers, Propellers, Valves, Hydro-Wheels, Pipe Elbows.
Any high wear immersion or non-immersion application.

SOLIDS BY VOLUME: 100%

VISCOSITY: Paste

POT LIFE: 23 Min/KG @ 75ºF

MIX RATIO: 1:1 by volume (Base:Activator)
100 gm: 100 gm by weight

COLOR: Blue

SHELF LIFE: 5 years at 55-95ºF, 13-35ºC

COVERAGE: Varies with thickness applied

WEIGHT PER GALLON: 15.1 lbs(6.9 KG)

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

ARCOR Epoxy Inc.
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South Dennis, MA 02660
Email: Arcor@ArcorEpoxy.com ; Tel: 508.385.5598

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.

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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-6 Commercial Finish minimum 4 mil profile. Immersion applications to SSPC SP-10 Near White metal, 4 to 6 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 the surface and allow time for proper rebuilding of the damaged area. Ca be used to rebuild damaged concrete. Concrete should be degreased, neutralized, and dry.

MIXING:
Thoroughly mix Activator into Base with mixing stick scraping sides and bottom of container or mixing board. Mix by volume 1 parts Base to 1 part Activator. Or by weight 1 parts Base to 1 part Activator (100:100). Mix thoroughly to produce and even colored , streak-free material.

THINNING: Never Thin

APPLICATION:
Use heavy plastic squeege or putty knife. Work material into profile of substrate to achieve maximum adhesive and to remove any entrapped air. Contour to correct form with putty knife or plastic applicator. If mold or form is used be sure to coat its surface with a release agent to prevent adhesion of the material. Machining is possible using diomand tipped tools only. Grinding is possible only if done within 2 hours of application at 77ºF (add 1 hour for each 10ºF below 77ºF, subtract 1/2 hour for each 10ºF above 77ºF).

APPLICATION TEMPERATURE:
Material: keep between 55 and 95ºF (17-35ºC). Substrate: keep between 45-105ºF (7-40ºC). 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 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 (75ºF+) for ease of mixing. If necessary Base component of material can be heated by microwave for 30 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 as soon as possible while material is still soft, within 2-4 hours at 77ºF. 25ºC. Max overcoat is 12 hours at 77F(25C). If overcoat window is exceeded abrade surface with course sandpaper, grinder or brush blast. Full cure before immersion 36 hours at 77ºF. Force Cure with heat for best performance for 1 hour at 200ºF, 93ºC, 12 hours at 120ºF, 49ºC.

CLEAN UP: Clean tools immediately after use with Acetone or MethylEthylKetone (M.E.K.). Use 98%+ Isopropyl Alcohol in solvent controlled environments.

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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