

Product Technical Data Sheet

ARCOR™ EE-97

REVISED 2/2019.1

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

DESCRIPTION AND RECOMMENDED USES: ARCOR™ EE-97 is a machinable, solvent free, two-component, rebuilding compound which can be used to repair any metal surface that has been damaged, cracked or worn.

ARCOR™ EE-97 is non-sagging up to 200 mils, will not shrink when curing, has excellent adhesion to all metal surfaces, is machinable with carbide or high-speed cutting tools and can be drilled, tapped or sanded. ARCOR™ EE-97 has excellent Wear, abrasion and impact resistance, and as a Novolac Epoxy, it has superior resistance in a wide variety of chemical environments and has heat resistance to 450°F.

FOR INDUSTRIAL USE ONLY SPECIFICATION DATA

TEMPERATURE: Immersion service Max.265°F;
Dry to 450°F; Temperature resistance will vary depending on chemical exposure.

CHEMICAL RESISTANCE:

Water:	Excellent
Alkalis:	Very Good
Inorganic Acids:	Very Good
Organic Acids:	Fair
Organic Solvents:	Good

ABRASION: Excellent

FLEXIBILITY: Fair

FLEXURAL STRENGTH: 13,500 psi
(ASTM D790/7 days)

COMPRESSIVE STRENGTH: 17,200 psi
(ASTM D695/7 days)

TENSILE SHEAR: 2,400 psi
(ASTM D1002/steel: steel)

APPLICATIONS: Any metal repair including;
Worn Shafts, Hydraulic Rams, Keyways, Pumps,
Valves, Impellers, Propellers, Stripped Threads,
Cracked Engine Blocks.

SOLIDS BY VOLUME: 100%

VISCOSITY: Paste

DENSITY: 1.55

POT LIFE: 20 Min/KG @ 75°F

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 PER GALLON: 12.9 lbs. (5.85 KG);
3.4 lbs. (1.55 KG)/Liter

FILM THICKNESS: 100-200 mils/coat

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

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Application Sheet

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SEE MATERIAL SAFETY DATA SHEET (SDS) BEFORE HANDLING THIS PRODUCT;

download @ www.ArcorEpoxy.com; ChemTel ERS / MOD Tel US: 800-255-3924; Outside US: +001-813-248-0585

SURFACE PREPARATION:

Metal surfaces are to be cleaned and degreased then abrasive blasted (or Bristle Blast) 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, 4+ 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. For larger surface areas with ferrous metals if need prime with EE-10, EE-11 Prime or S-30 Prime.

MIXING:

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

THINNING: Never thin.

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 a 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 quality diamond tipped tools only and is best done as soon as product is stable and before full cure. Sanding or Grinding is possible only if done within 6 hours of application at 77°F (add 1 hour for each 10°F below 77°, subtract 1/2 hour for each 10°F above 77°F). Large holes and cracks can be bridged with fiberglass, polyester 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 activator by warm water bath only. If necessary let material cool before application. Note that heated product will have less working time and faster cure.

OVERCOAT / CURE TIME:

Recoat as soon as possible while material is still soft, within 2 to 6 hours at 77°F, 25°C. If overcoat window is exceeded abrade surface with course sandpaper, grinder or brush blast. Wipe with Acetone or similar. Full cure before immersion 36 hours at 77°F. Add 1-day additional cure time for each 10°F below 77°F. Subtract 6 hours of cure time for each 10°F above 77°F. Force Cure with heat for best performance for 1 hour at 200°F, 93°C, 12 hours at 120°F, 49°C.

CLEAN UP: Clean tools immediately after use with M.E.K., Acetone, 98+% Isopropyl Alcohol 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. Consult the Product Safety Data Sheets (SDS) BEFORE USE!

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