ARCOR
EPOXY TECHNOLOGIES

Product Technical Data Sheet

ARCOR™ 2213

REVISED 9/2020.1

GENERIC TYPE: AMINE CURED 100% SOLIDS EPOXY RAPID CURE REBUILDING COMPOUND

DESCRIPTION AND RECOMMENDED USES: ARCOR® 2213 Stick is a solvent free, two-component epoxy paste provided in an easy to use stick form which contains both the Activator and Base components. Simply cut or twist off a desired amount and knead with your gloved fingers. Rapid cure makes 2213 ideal for emergency repairs. It is corrosion resistant, steel reinforced for excellent wear. It can be sanded, drilled, tapped, filed, machined. Can be painted with epoxy, urethane or acrylics. ARCOR® 2213 sets in 5 minutes and can be put into full service within 1 hour.

FOR INDUSTRIAL USE ONLY

SPECIFICATION DATA

TEMPERATURE:
Max.250ºF(121ºC); Spike to 300ºF(149C)
Recommended force cure at 250ºF@ 2 hrs.
Dry to 400ºF (190C); Spike to 500ºF (246C)(3 hrs)
Temperature resistance will vary depending on chemical exposure. Consult ARCOR.

CHEMICAL RESISTANCE:

Water:	Excellent
Alkalis:	Excellent
Dilute Acids:	Good
Hydrocarbons:	Excellent
Alcohols, Ketones:	Excellent

ABRASION: Excellent

FLEXIBILITY: Fair. Excellent with Polyester or Fiberglass Cloth

APPLICATIONS:
Fill Cracks & Voids
Rebuild Rust/Corrosion Damage
Repair Stripped Threads
Repair Leaking Pipe & Duct
Anchor Equipment
Rebuild Small Parts

SOLIDS BY VOLUME: 100%

VISCOSITY: 150,000+ cps

POT LIFE: 5 MIN/100gr @ 72ºF(22.2ºC)

MIX RATIO: 1:1 by Volume (Base: Activator)

COLOR: Gray (when mixed)

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

COVERAGE: 1604/#mils = ft²/gal/coat;
149/#mils = M^2/Gal; 3,785/#microns = M2/Gal
1mil = 25 micron; 1 Gal = 3.785 L; 10.77ft^2 = M^2

WEIGHT PER GALLON: 18.5 lbs. (8.4 KG)
4.9 lbs. (2.2 KG)/Liter

FILM THICKNESS:
Final DFT Specified by Need; fill voids as needed

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

Novolac Epoxy Technologies Inc.
28 Jonathan Bourne Drive
Pocasset, MA 02559
Tel: 508-385-5598
Email:Sales@NovolacEpoxy.com

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Application Sheet
ARCOR™ 2213

REVISED 3/2019.1

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:

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 4+ mil profile. Grind flat all burrs, weld seams, radius sharp edges. Fresh blasted ferrous surfaces to be primed with S-20 immediately to prevent oxidation of surface.

Concrete surfaces should be degreased if oil and grease contamination is present. 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. Prime with EE-80 or EE-10.

MIXING:

Cut or twist off required amount. Mix by kneading with gloved fingers to a uniform color.
If mixing is difficult, warm to room temperature or slightly above.

THINNING: Never thin.

APPLICATION:

Apply to surface to be repaired within 2 minutes of mixing. Force into any cracks or holes and strike off excess material, preferably with a tool moistened with clean water. When applying to a damp, wet or slowly leaking area, work the mixed material forcefully into the surface and apply pressure until adhesion begins to take effect.

For best results: Use damp nitrile gloved fingers for easier mixing, application, and a smooth appearance of the cured compound. Remove excess material before hardening begins. 2213 has a work life of 3 to 5 minutes.

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 10-15 seconds for a 7" stick unit. If necessary, let material cool before application to allow for more pot life during application.

OVERCOAT / CURE TIME:

By brush, roller or squeegee recoat while material is still soft, but tack-free, between 1-2 hours at 77ºF(25ºC). **IMPORTANT**: If overcoat window is exceeded abrade surface with course sandpaper, grinder or brush blast and wipe with MEK or Acetone. By spray application recoat between 2-12 hours at 77ºF(25ºC).

Full cure before immersion recommended 72 hours at 77ºF(25ºC). Add 1 hour's additional cure time for each 10ºF(-12.2ºC) below 77ºF(25ºC). For highly aggressive environments Force Cure with heat for best performance for 8 hours at 150ºF (66ºC), 2 hours at 250ºF (121ºC).

CLEAN UP: Clean tools immediately with M.E.K., Acetone or similar. Isopropyl Alcohol(98+%) 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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