ARCOR
EPOXY TECHNOLOGIES

Product Technical Data Sheet

ARCOR™ 2214

REVISED 07/2025.1

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

DESCRIPTION AND RECOMMENDED USES: ARCOR® 2214 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 hand. Rapid cure makes 2214 ideal for emergency repairs. It is corrosion resistant, mineral reinforced for excellent wear. It can be sanded, drilled, tapped, filed, machined. 2214 can be painted with epoxy, urethane or acrylics. ARCOR® 2214 sets in 5 minutes and can be put into full service within 1 hour. Can be applied and cure underwater.

Bonds to all Metals, Concrete, Wood, Ceramics, Glass and many Plastics

Certified to Standard 61 by The National Sanitation Foundation for use in contact with drinking water.

FOR INDUSTRIAL USE ONLY

SPECIFICATION DATA

TEMPERATURE:
Dry Max.250ºF(121ºC); Spike to 450ºF(232C)
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: Putty

POT LIFE: 5 MIN/100gr @ 72ºF(22.2ºC)

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

COLOR: White (when mixed)

SHELF LIFE: 2 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: 13.3 lbs. (6.0 KG)
3.5 lbs. (1.6 KG)/Liter; **7" Stick = 4oz (120gr)**

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

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

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Email:Sales@NovolacEpoxy.com

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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:

Ideally 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 of oil and grease if contamination is present. Ideally 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 as beeded with EE-80 or EE-10/10.5.

MIXING:

Cut or twist off required amount. Mix by kneading with gloved hand to a uniform color.
If mixing is difficult, warm to room temperature (72F) 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 (or Acetone). 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. 2214 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 the 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!

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. ARCOR® epoxy products do not provide structural integrity or improvement. They are only used to provide protection from corrosion, wear, abrasion and chemical attack on a given substrate and only to the extent provided for in the Data Sheets, Technical Data Sheets, Safety Data Sheets and any other information as supplied in writing directly from manufacturers technical support.

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