ARCOR
EPOXY TECHNOLOGIES

ProductDataSheet

ARCOR™ BHC-72

REVISED 5/2024

GENERIC TYPE: AMINE CURED 100% SOLIDS EPOXY TOPCOAT

DESCRIPTION AND RECOMMENDED USES: ARCOR™ BHC-72 is a solvent free, high functionality epoxy Novolac coating suitable as a self-leveling chemical containment flooring, particularly in aggressive Impact environments with exposure to acids and alkalis. **ARCOR™ BHC-72** produces a tough, chemical resistant coating on concrete, ferrous and non-ferrous metals, even wood. Use of Reactive Flexibilizing agents gives excellent flexibility without sacrificing chemical resistance making **BHC-72** ideal for any containment floors with thermal, design or structural stress, without the need for fiberglass mat reinforcement. High Impact & abrasion resistance in an easy to clean surface. **ARCOR™ BHC-72** is suitable for hand or spray application at up to 100 mils per coat.

FOR INDUSTRIAL USE ONLY

SPECIFICATION DATA

TEMPERATURE: Immersion service Max.245ºF (118ºC); Dry to 400ºF (3 Hrs).

CHEMICAL RESISTANCE:

Water:	Excellent
Alkalis:	Excellent
Inorganic Acids:	Excellent
Organic Acids:	Excellent
Organic Solvents:	Excellent

ABRASION: Very Good

FILM THICKNESS: 20 to100 mils (.51-2.55 mm)/coat
Splash: 1 coat, Immersion: 2 coats

FLEXIBILITY: Very Good
Excellent with Cloth Mat; 1.5 oz/ft^2 (.5 KG/M^2)

APPLICATIONS: Aggressive Chemical Secondary Containment Areas, Aggressive Industrial Floors, High Wear Flooring.

SOLIDS BY VOLUME: 100% **VISCOSITY:**2,000-3,000 cps **POT LIFE:** 35 MIN/KG @ 72ºF
MIX RATIO: 2:1 by Volume (Base:Activator) 100 gm: 34 gm by weight

COLOR: Gray (special order colors available)

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

COVERAGE: 80 ft^2(7.5 M^2)/ gal @ 20mils

WEIGHT PER GALLON: 10.8 lbs (4.89 KG)

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 BEFORE HANDLING THIS PRODUCT

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 3 to 5 mil profile. Grind flat all burrs, weld seams, radius sharp edges. Fresh blasted ferrous surfaces to be primed immediately with **ARCOR™ S-30 Prime or ARCOR™ BHC-72** to prevent oxidation of surface.
Concrete surfaces should be degreased if oil and grease contamination is present. Degreased surface shall be high pressure washed. Loose existing coatings should be chipped & ground to remove then entire floor is to be abrasive blasted to remove all existing coating, mastics and laitenance. Clean & grind all cracks & expansion joints. Thoroughly sweep & vacuum.
If needed, Prime entire floor with **ARCOR™ EE-80**, **EE-10, BHC-72.**

MIXING:

Thoroughly mix Activator into Base with mixing stick or drill with low-speed mixing blade scraping sides and bottom of container or mixing board. Mix by Volume 2 parts Base to 1 part Activator. Or by weight 100 grams base to 34 grams activator. Mix thoroughly to produce an even colored and streak-free material.

THINNING: Never thin.

APPLICATION:

Squeegee: heavy duty rubber 'notched' squeegee
Roller: good quality 3/4" nap.
ARCOR Cartridge Sprayer: Heat to 115F(48C). Piston '3'; Tip Air '3'.
Plural Spray: .017-.025 tip, 3,000-3,500 PSI, Heat to 110ºF Base, 100ºF Activator.
Airless Spray: .019-.027 tip, 3,000-3,500 PSI(45:1). (Caution: Short Pot-Life)
Conventional Spray: Not Recommended.
All spray equipment should employ traps to prevent water and oil from contaminating coating and screens to prevent contamination.

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 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.

OVERCOAT/CURE TIME: By brush, roller or squeegee recoat while material is still soft, but tack-free, between 6-14 hours at 77ºF(25ºC). If overcoat window is exceeded abrade surface with course sandpaper, grinder or brush blast. By spray application recoat between 2-14 hours at 77ºF. Full cure before immersion 72 hours at 77ºF. Add 30 hours additional cure time for each 10ºF below 77ºF. Subtract 12 hours of cure time for each 10ºF above 77ºF. Force Cure with heat for best performance for 4 hours at 200ºF(93ºC), 12 hours at 150ºF(66ºC).

Clean tools immediately after use with M.E.K., Acetone or similar. 98% Isopropyl Alcohol 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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