ARCOR
EPOXY TECHNOLOGIES

PRODUCT DATA SHEET

Revision April 2025

ARCOR® EE-80

GENERIC TYPE: AMINE CURED 100% SOLIDS EPOXY PRE-PRIME, PRIME

DESCRIPTION AND RECOMMENDED USES: ARCOR™ EE-80 is a solvent free, very low viscosity epoxy designed as a wicking, penetrating pre-primer. It is ideally suited for use on large metal surface areas to hold the blast until an ARCOR™ coating system is applied, or to increase adhesion of a coating system to metal surfaces, in immersion service, that cannot be blasted to an SSPC-SP5 cleanliness. For external metal structures ARCOR™ EE-80 will penetrate through poorly prepared surfaces and cure to a tough, water-resistant coating. Excellent as a sealer on aged "white rusted" zinc surfaces. Applies in one, thin, 1.5 mil coat. Also ideal for a primer on concrete surfaces especially if hydrostatic pressure can be a problem. EE-80 will wick into concrete cracks to help seal and provide superior adhesion for topcoats.

FOR INDUSTRIAL USE ONLY

SPECIFICATION DATA

TEMPERATURE: Immersion service
Max. 150ºF (65º); Spike to 200ºF (93ºC) 3 Hrs
Dry to 250ºF (121ºC): Spike to 300ºF (149ºC) 3 Hrs

CHEMICAL RESISTANCE:

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

ABRASION: Good

FLEXIBILITY: Very Good
Excellent with fiberglass Mat; 1+ oz/ft2 (.33 KG/M2)

Film Thickness: 1.5 mils/coat (.04mm; 38 microns) Immersion/Dry: 1 coat, 2 coats if very porous especially on concrete.

APPLICATIONS: Tanks, Pipe, Concrete Containments & Flooring, Structural Steel, Petrochemical Tanks, Waste-water tanks, Sewer Pipes, Portable water, Salt Water, Waste Water, Service/Cooling Water Systems.

SOLIDS BY VOLUME: 100%

VISCOSITY: 300-500 cps

POT LIFE: 30min./Gal @ 72ºF (22ºC)

MIX RATIO: 2:1 by volume (Base:Activator) 100 gm: 43 gm by weight

COLOR: Clear/slight amber.

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

COVERAGE: 1070 ft² (100 M²)/gal (theoretical)

WEIGHT PER GALLON: 8.74 lbs (3.97KG)

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

ARCOR® by Novolac Epoxy Technologies Inc.
28 Jonathan Bourne Drive
Pocasset, MA 02559

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PRODUCT APPLICATION DATA
ARCOR® EE-80

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-

SURFACE PREPARATION:

Immerson: remove all oil, grease, surface contamination, loose rust, scale and any old coating. Although designed for use in less than ideal surface preparation it is preferred that one strive to attain as close to an SSPC SP-5, in as many areas as possible, to achieve the best long-term performance of the overall coating system. At a minimum an SP-6 is required. In all cases a 3-5 mil profile is required

Dry: Remove all oil, grease, surface contamination, loose rust, scale, and any old coating. Although designed for use in less than ideal surface preparation the best long-term performance is attained with SP-6 cleanliness at 2-3 mil profile.

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 the surface is clean and free of all grease, oils and surface laitance. Sandblasting and /or scarification may be recommended depending on surface. Existing coatings should be abrasive blasted to clean concrete.

MIXING:

Thoroughly mix Activator into Base with mixing stick or drill with low speed mixing blade. Mix by Volume 2 parts Base to 1 part Activator. Or by weight 100 grams base to 43 grams activator.

THINNING: Never thin.

APPLICATION:

Brush: medium to stiff bristle of sufficient quality that bristles do not pull out and stick in coating (epoxy glued bristles are best). Trim or tape to <1" nap.

Roller: use good quality 1/4"- 3/8" nap.

Cartridge Sprayer: Heat to 100F by water bath or microwave. Set Air to 1 and piston to 1. Adjust as needed.

Spray: .015-.017 RAC tip, 2,000-2,500 PSI, Heat to 100ºF Base, 80ºF Activator.

Airless Spray: Low air pressure 25-40 psi, .015-.017 tip.

Conventional Spray: Graco #700 or #800 spray gun with suitable needle/nozzle and air cap combinations. ARCOR™ EE-80 applies best at low air and pot pressure, 5-10 PSI.

All spray equipment should employ traps to prevent water and oil from contaminating coating and 30 mesh screens prevent particulate 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 20-35 seconds for 1 KG unit or by warm water bath. Heat activator by warn water bath only. If necessary let material cool before application.

OVERCOAT / CURE TIME:

Overcoat windows are affected by temperature and humidity. The following are general guidelines.

By Brush or Roller recoat between 8 and 72 hours at 72ºF (25ºC).

When spraying recoat between 2 and 12 hours. Full cure before immersion 72 Hours at 72ºF without topcoat. With Topcoat follow the product instructions.

CLEAN UP: M.E.K., Acetone or another Ketone blend. For solvent controlled areas use 98+% isopropyl alcohol

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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