ARCOR
EPOXY TECHNOLOGIES

Product Data Sheet

REVISED 12/2024

ARCOR® EE-121

GENERIC TYPE: AMINE CURED 100% SOLIDS 3.6 NOVOLAC, TOP COAT

DESCRIPTION AND RECOMMENDED USES: ARCOR® EE-121 is a solvent free, high 3.6 functionality epoxy Novolac coating suitable for immersion and non-immersion service. Designed specifically for aggressive chemical and elevated temperature resistance. Produces a tough, chemical resistant coating on ferrous and non-ferrous metals for full immersion and concrete for secondary containment.
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FOR INDUSTRIAL USE ONLY

SPECIFICATION DATA

TEMPERATURE: Immersion service
Max.350ºF(177ºC); Spike to 450ºF(3 Hrs)
Recommended force cure at 250ºF@ 4 hrs.
Dry to 450ºF; Spike to 525ºF(3 Hrs)

CHEMICAL RESISTANCE:

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

ABRASION: Very Good

FLEXIBILITY: Good

FILM THICKNESS:20-60 mils(.51- 1.53 mm)/coat

APPLICATIONS: Methanol Pumps, Tanks, Pipes, FGD Duct. Exterior: 2 coats, Immersion: 2-3 Coats. Aggressive Chemical Tank Linings and Secondary Containment Areas, Excellent in DEA, MDEA, MEA. Agressive Industrial Containment. Recommended Force Cure at 250ºF@ 4 hrs. for most aggressive applications.

SOLIDS BY VOLUME: 100%

VISCOSITY: 80,000-105,000 cps

POT LIFE: 25 MIN/100gr @ 72ºF

MIX RATIO: 2:1 by Volume (Base: Activator)
100 gm: 50 gm by weight

COLOR: Blue

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

COVERAGE: 26-80 ft²(7.5 M²)/gal/coat

WEIGHT PER GALLON: 10.7 lbs (4.76 KG)

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

ARCOR Epoxy Inc.
28 Jonathan Bourne Drive
Pocasset, MA 02559
TEL: 508-385-5598, Sales@NovolacEpoxy.com

The 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.

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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 to prevent oxidation of surface. Prime with EE-121 Prime.

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-121 Prime.

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 51 grams activator. Mix thoroughly to produce an even colored and streak-free material.

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 3/8" nap.
Cartridge Sprayer: Heat to 155-165F. Shake vigorously before inserting into sprayer. Heat by microwave or Sous-Vide Water Bath.
Plural Spray: .031-.039 RAC tip, 3,000-4,000 PSI, Heat to 210ºF Base, 140ºF Activator.
Airless Spray: use .031-.039 RAC tip, 5,500-6,500 PSI (55:1+). Recommended only with in-line heater at 150º to 175ºF. (Caution: Short Pot-Life). *Consult ARCOR.*
Conventional Spray: Not Recommended
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 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 45min-3 hours at 77ºF(25ºC). **IMPORTANT**: It is highly recommended that prior to overcoat that the prior coat be fully wiped with MEK or Acetone. 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 1/2-1 hours at 77ºF. Full cure before immersion 72 hours at 77ºF. Add 1 hours additional cure time for each 10ºF below 77ºF. Force Cure with heat for best performance for 4 hours at 250ºF(121ºC).

CLEAN UP: Clean tools immediately after use with M.E.K., Acetone or similar. ARCLEAN or 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.