ARCOR
EPOXY TECHNOLOGIES

Product Data Sheet

REVISED 1/2023.1

ARCOR® EE-80HT

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

DESCRIPTION AND RECOMMENDED USES: ARCOR™ EE-80HT is a high temperature version of our EE-80. It is a solvent free, very low viscosity epoxy designed as a penetrating pre-primer. It is ideally suited to increase adhesion of a coating system on hot metal surfaces, in immersion service, that cannot be blasted to an SSPC-SP5 cleanliness. For external metal structures ARCOR™ EE-80HT will penetrate through rusty surface 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 (37.5 micron) coat.
Ideal as a primer on concrete surfaces. EE-80HT penetrates the concrete for an exceptional bond on new or older damaged concrete. The concrete is fully sealed preventing chemicals and contaminants from leaching into, or out of, the concrete.
EE-80 is especially resistance to hydrostatic pressures. Mix with Garnet for a high compressive strength concrete hole repair.
Use under asphalt to protect, and seal, concrete. Easily Brushed, rolled or sprayed by airless, plural or cartridge.
As a Novolac Epoxy, EE-80HT offers excellent chemical resistance to caustics, acids, and solvents.

FOR INDUSTRIAL USE ONLY
SPECIFICATION DATA

TEMPERATURE: Immersion service
Max. 275ºF (135º); Spike to 325ºF (165ºC) 3 Hrs
Dry to 375ºF (191ºC): Spike to 475ºF (246ºC) 3 Hrs

CHEMICAL RESISTANCE:

Water:	Excellent
Alkalis:	Excellent
Inorganic Acids:	Very 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 Flooring, Structural Steel, Petrochemical Tanks, Wastewater tanks, Sewer Pipes, Portable water, Salt Water, Waste Water, Service/Cooling Water Systems.

SOLIDS BY VOLUME: 100%

VISCOSITY: 300-500 cps

POT LIFE: 20min/Gal @ 72ºF (22ºC)

MIX RATIO: 3:1 by volume (Base:Activator) 100 gm: 30 gm by weight

COLOR: Clear/slight amber.

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

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

DENSITY: 1.06 g/cm3

WEIGHT PER GALLON: 8.8 lbs (4.0 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 (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 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 as needed..

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 as needed.

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 1-part Base to 1-part Activator. Or by weight 100 grams Base to 100 grams Activator. Mix thoroughly to produce an even colored and streak-free material.

THINNING: Never thin.

APPLICATION:
Use heavy plastic squeegee or putty knife. Work material into profile of substrate to achieve maximum adhesion and to remove any entrapped air. Contour to correct form with plastic applicator or putty knife. If mold or form is used, coat its surface with a release agent to prevent adhesion of the material. Machining is possible using carbide tipped tools. Machining & Grinding is best done within 8 hours of application at 77ºF, 25ºC (add 1-1/2 hour for each 10ºF below 77º, subtract 1 hour for each 10º above 77ºF). Machining & Grinding can be done after this time, but the material does become very hard and will rapidly wear bits and discs. Large holes and cracks can be bridged with glass or metal cloth.

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 the metal prior to surface preparation using an 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+) for ease of mixing. If necessary, Base component of material can be heated by microwave for 30 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. Application onto surfaces above 77F (25C) may cause the material to sag/slump. This will increase as temperatures increase, so single coat thickness must be reduced.

OVERCOAT/CURE TIME:
Recoat while material is still soft (fingernail indent), between 2 to 8 hours at 77ºF, 25ºC. If the overcoat window is exceeded abrade surface with course sandpaper, grinder, or brush blast. Full cure before immersion 72 hours at 77ºF (25C). Add 1-day additional cure time for every 10ºF below 77ºF. Subtract 15 hours of cure time for each 10ºF above 77ºF. Force cure with heat for best performance for 1 hour at 200ºF (93ºC), 12 hours at 120ºF (49ºC).

CLEAN UP: 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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