

Product Technical Data Sheet

ARCOR™ EE-92

REVISED 3/2019.1

GENERIC TYPE: AMINE CURED 100% SOLIDS NOVOLAC, REBUILDING PASTE

DESCRIPTION AND RECOMMENDED USES: ARCOR™ EE-92 is a solvent free, two-component rebuilding compound designed particularly as a rebuilding/repair material for metals damaged by wear, corrosion, erosion, abrasion or cavitation. ARCOR™ EE-92 is non-sagging up to 250 mils, will not shrink when curing, and has excellent adhesion to all metal surfaces. As a Novolac Epoxy EE-92 has excellent resistance in a wide variety of chemical environments.

FOR INDUSTRIAL USE ONLY

SPECIFICATION DATA

TEMPERATURE: Immersion service
Max.250°F(177°C); Spike to 350°F(3 hrs)
Recommended force cure at 250°F@ 2 hrs.
Dry to 400°F (190C); Spike to 500°F
(246C)(3 hrs)
Temperature resistance will vary depending on
chemical exposure. Consult ARCOR.

CHEMICAL RESISTANCE:

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

ABRASION: Excellent

FLEXIBILITY: Very Good. Excellent with
Polyester or Fiberglass Mat; 1.5 oz/ft² (.5 KG/M²)

APPLICATIONS: Heat Exchangers, Divider
Plates, Wicket Gates, Pump Housings &
Impellers,. FGD; Outlet Ducts, Absorbers, I.D.
Fans, Scrubbers. Barge Tanks. Separators. Pumps.
For the most aggressive applications we
recommend Force Cure at 250°F(121.1°C)
@ 2 hrs.. Product can be force cured in
service, consult ARCOR.

SOLIDS BY VOLUME: 100%

VISCOSITY: 65,000-85,000 cps

POT LIFE: 20 MIN/100gr @ 72°F(22.2°C)

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

COLOR: Gray

SHELF LIFE: 5 Years at 55-95°F (13-35°C)

COVERAGE: 1604/#mils = ft²/gal/coat;
149/#mils = M²/Gal; 3,785/#microns = M²/Gal
1mil = 25 micron; 1 Gal = 3.785 L; 10.77ft² = M²

WEIGHT PER GALLON: 14.9 lbs./Gal (6.8
KG); 3.9 lbs. (1.8 KG)/Liter

FILM THICKNESS:

Final DFT Specified by Need; Consult ARCOR

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 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 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-10.

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 50 grams Activator. Mix thoroughly to produce an even colored and streak-free material.

THINNING: Never thin.

APPLICATION:

Use heavy plastic squeegee (supplied) or putty knife. Work material into profile of substrate to achieve maximum adhesive and to remove any entrapped air. Contour to correct form with putty knife or plastic applicator. If mold or form is used be sure to coat its surface with a release agent to prevent adhesion of the material. Machining is possible using diamond tipped tools only. Grinding is possible only if done within 2 hours of application at 77°F (add 1 hour for each 10°F below 77°F, subtract 1/2 hour for each 10°F above 77°F).

APPLICATION TEMPERATURE:

Material: Keep between 55 to 95°F (17 to 35°C). Substrate: Keep between 45 to 105°F (7 to 40°C). The difference in temperature of the substrate and the material should never exceed 10°F (5°C). Substrate shall be a minimum of 5°F (3°C) 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 (75°F+, 24°C) 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.. 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 3-12 hours at 77°F (25°C).

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 77°F (25°C). Full cure before immersion recommended 72 hours at 77°F (25°C). Add 1 hour's additional cure time for each 10°F (-12.2°C) below 77°F (25°C). For highly aggressive environments Force Cure with heat for best performance for 8 hours at 150°F (66°C), 2 hours at 250°F (121°C).

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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ARCOR® EE-92 Physical Test Data

TEST	Tensile Strength Adhesion PSI (MPa)	Hardness Shore D	Compressive Strength PSI (MPa)	Tensile Shear PSI (MPa)	Tensile Elongation (%)	Salt Fog 10,000 hrs	Dielectric Strength (Volts/Mi)
Test Method	ASTM D-1002 (steel: steel)	ASTM D-2240	ASTM D-695	ASTM D-638	ASTM D-638	ASTM B-117	ARCOR
ARCOR EE-92 RESULTS	Without Primer 2,407 (16.6)	87	18,600 (128.22)	3,670 (25.3)	0.60	No rust	318
	With Primer 3,328 (22.95)						
TEST	Flexural Strength PSI (MPa)	Tabor Abrasion Resistance 1000 g load 1000 cycles	Cathodic Disbondment 90 days; 2000mv	Impact Resistance Inch-lbs (kgf-m)	Permeability 23C 100%RH/ 50%RH	Vertical Sag Resistance 21C @ 4mm	Thermal Conductivity (W/mK)
TEST Method	ASTM D-790 (7 days)	ASTM D-4060	ASTM G-8	ASTM G-14	ASTM E-96	ARCOR	ASTM D-4060
ARCOR EE-92 RESULTS	15,000 (103.5)	44 mg Avg. loss 1.0mil; (25 microns)	No Disbondment No Blisters No Holiday Enlargement	75 (.87)	.07 Perm	No Sag	.61

1MPa = 145 psi