

PRODUCT DATA SHEET

ARCOR® EE-951-HT

REVISED 1/2015

GENERIC TYPE: AMINE CURED 100% SOLIDS EPOXY REBUILD

DESCRIPTION AND RECOMMENDED USES: ARCOR® EE-951-HT is a solvent free epoxy 3.6 functionality Novolac designed particularly as a rebuilding material for metals in highly aggressive chemical and temperature immersion service. It is ideally suited for restoration or cladding material for corrosion and abrasion protection. ARCOR® EE-951-HT can be applied up to 500 mils without slump.

FOR INDUSTRIAL USE ONLY

SPECIFICATION DATA

TEMPERATURE: Immersion service
 Max. 375°F (190.5°C); Spike to 475°F (246.1°C) (3 Hrs)
 Recommended Force Cure at 175°F (79.4°C) @ 2 hrs;
 300°F (148.9°C) @ 3 hrs;
 Dry to 500°F; Spike to 580°F (3 Hrs)

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

ABRASION: Excellent

FILM THICKNESS: Good
 Fair Flexural Strength 12,000 psi

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

APPLICATIONS: Tank Linings, Ion Exchange Filters,
 FGD, Ducts, Mix Zones, I.D. Fans, Scrubbers,
 Concrete Secondary Containments

SOLIDS BY VOLUME: 100%

VISCOSITY: Putty

POT LIFE: 25 MIN / KG @ 72°F

MIX RATIO: 3:1 by Volume (Base:Activator)
 100 gm: 33 gm by Weight

COLOR: Gray

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

COVERAGE: Varies with thickness applied

WEIGHT PER GALLON: 12.1 lbs (5.6 KG)

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

ARCOR Epoxy Inc.
 PO Box 273
 South Dennis, MA 02660
 TEL: 800-878-9593; FAX: 888-878-9593

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.

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™ EE-101 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 ARCOR™ EE-101, EE-111.

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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 3 parts Base to 1 part Activator. Mix thoroughly to produce an even colored, 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 putty knife or plastic applicator. 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. Grinding is possible if done within 14 hours of application at 77°F, 25°C (add 1-1/2 hour for each 10°F below 77°, subtract 1 hour for each 10° above 77°F). Large holes and cracks can be bridged with glass or metal cloth.

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 the 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+) 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 activated by warm water bath only. If necessary let material cool before application.

OVERCOAT / CURE TIME:

Recoat while material is still soft, between 1 to 2 hours at 77°F, 25°C. If overcoat window is exceeded abrade surface with course sandpaper, grinder or brush blast. Full cure before immersion 36 hours at 77°F. Force cure with heat for best performance for 8 hours at 120°F (49°C); 2 hours at 250°F (121°C)

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

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.