

## PRODUCT DATA SHEET

**ARCOR® 1321**

REVISED 3/2014

**GENERIC TYPE:** AMINE CURED 100% SOLIDS EPOXY PRIMER, TOPCOAT

**DESCRIPTION AND RECOMMENDED USES:** ARCOR® 1321 is a solvent free bisphenol F coating suitable for immersion and non-immersion service, particularly in aggressive environments. ARCOR® 1321 is self-priming and produces a tough, chemical resistant coating on ferrous & non-ferrous metals and concrete. As a low viscosity epoxy with excellent flexibility ARCOR® 1321 is especially suitable for external applications with aggressive exposures. Suitable for hand or spray application on metals or concrete. The long pot-life and over coat window make this ideal for larger surface area application by airless or plural component spray. Excellent UV stability.

### FOR INDUSTRIAL USE ONLY

#### SPECIFICATION DATA

**TEMPERATURE:** Immersion service  
Max. 145°F (49°C); Spike to 200°F (79°C)(3 Hrs).  
Dry to 325°F (149°C)

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

**ABRASION:** Good

**FILM THICKNESS:** Can be applied up to 20 mils in a single coat. Single coat spray application. Hand application may require a 2nd coat.

**FLEXIBILITY:** Very Good  
Very good with Polyester Cloth; 1.5 oz/ft<sup>2</sup>  
(.5 KG/M<sup>2</sup>)

**APPLICATIONS:** Ideal for exterior applications to resist exposure to Salt Water; Caustics, Alcohols, Acids. Also suitable for immersion service in water (brakish, salt) and Caustics.  
Excellent for Secondary Containment's.

**SOLIDS BY VOLUME:** 100%

**VISCOSITY:** 5,000-15,000 cps

**POT LIFE:** 35 MIN/KG @ 72°F

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

**COLOR:** Gray, Light Gray, Black, White; Yellow; Blue

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

**COVERAGE:** 80 ft<sup>2</sup>(7.5M<sup>2</sup>)/ gal / coat @ 20mils

**WEIGHT PER GALLON:** 11.6 lbs (5.27 KG), 231 cu.in.)

**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  
Sales@ArcorEpoxy.com

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 should be coated immediately with **ARCOR™ 1321** to prevent oxidation of surface. For very large areas **ARCOR™ EE-80** can be used as a pre-prime to help hold the blast.

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™ 1321**.

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

**THINNING:** Not Advised; but if necessary add 5% by volume(6oz/gal.) Acetone or MEK to extend pot-life and/or thin for cold weather application.

**APPLICATION:**

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

Roller: good quality 3/8" nap.

Plural Spray: .027-.035 tip, 2,000-3,500 PSI, Heat to 110°F Base, 90°F Activator. 30 mesh screens. Heated hose @ 120°F

Airless Spray: .027-.035 tip, 4,000-4,500 PSI(45:1). Add 6-oz/gal of MEK or Acetone.(Caution: Short Pot-Life)

Conventional Spray: Not Recommended.

All spray equipment should employ traps to prevent water and oil from contaminating coating and screens to prevent particulate contamination.

**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 seconds for a 1 MK 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 1-12 hours at 77°F(25°C). If overcoat window is exceeded abrade surface with course sandpaper, grinder or brush blast. By spray application a single coat to 20 mils recommended. For multiple coats, recoat between 1-12 hours at 72°F. Full cure before chemical immersion 72 hours at 72°F. Add 12 hours additional cure time for each 10°F below 72°F. Subtract 12 hours of cure time for each 10°F above 72°F. Force Cure with heat for best performance for 4 hours at 150°F(66°C), 12 hours at 100°F(38°C).

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