

## APPLICATION SHEET

**ARCOR™ EE-99**

REVISED 5/2013

**SEE MATERIAL SAFETY DATA SHEET BEFORE HANDLING THIS PRODUCT****SURFACE PREPARATION:**

for best results clean area to be repaired to remove loose dirt, scale and oils. Use MEK or a similar solvent and a degreaser if oils are present. If possible sand or grind the area with course paper or disk.

**MIXING:**

Thoroughly mix Activator into Base with mixing stick scraping sides and bottom of container or mixing board. Mix by Volume 1 parts Base to 1 part Activator. Or by weight 100 grams Base to 119 grams Activator. Mix thoroughly to produce an even colored, streak-free material.

**THINNING:** If desired, thin with Kelone blend from 5% to 7.5% by volume

**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 diamond tipped tools only. Sanding/Grinding is possible if done within 1 hour of application at 77°F, 25°C. Caution: Material cures rapidly. Use only the quantity of material which can be easily applied within 4 to 5 minutes. Spreading mixed material on a mixing board or other flat surface will extend the working life. 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. Caution: Material cures rapidly. Use only the quantity of material which can be easily applied within 4 to 5 minutes. Heating will accelerate cure time.

**OVERCOAT / CURE TIME:**

Recoat as soon as possible while material is still soft, within 1 hour at 77°F, 25°C. If overcoat window is exceeded abrade surface with course sandpaper, grinder or brush blast. Full cure before immersion 45 minutes at 77°F. Add 10 minutes additional cure time for each 10°F below 77°F. Subtract 15 minutes of cure time for each 10°F above 77°F.

**CLEAN UP:** Clean tools immediately after use with M.E.K., Acetone 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.

## PRODUCT DATA SHEET

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**GENERIC TYPE:** AMINE CURED 100% SOLIDS EPOXY REBUILDING COMPOUND

**DESCRIPTION AND RECOMMENDED USES:** ARCOR™ EE-99 is a solvent free two-component, moisture insensitive epoxy rebuild designed as an emergency repair or bonding material for metals, glass, concrete, or wood. ARCOR™ EE-99 sets in 5 minutes and can get put in service within 1 hour regardless of temperature. ARCOR™ EE-99 has good resistance in a wide variety of chemical environments and has heat resistance to 450°F. ARCOR™ EE-99 has an easy to use 1:1 mix ratio and can be applied overhead or vertically.

### FOR INDUSTRIAL USE ONLY

### SPECIFICATION DATA

**TEMPERATURE:** Immersion service Max. 200°F (93°C) ;  
Dry to 450°F (232°C)

**CHEMICAL RESISTANCE:**

Water: Excellent  
Alkalies: Very Good  
Inorganic Acids: Good  
Organic Acids: Fair  
Organic Solvents: Good

**ABRASION:** Excellent

**FLEXIBILITY:** Fair

**BOND STRENGTH:** 3,000 psi @ 2 hours  
3,600 psi @ 24 hours

**FILM THICKNESS:** up to 1000 mils/coat

**APPLICATIONS:** Repair burst pipes, tanks, pumps and the like which contain liquids or gases. Use for bonding Dissimilar Metals. Use for Concrete, Metal, Glass, Wood.

**SOLIDS BY VOLUME:** 100%

**VISCOSITY:** Paste

**POT LIFE:** 3-5 MIN @ 72°F

**DENSITY:** 1.48

**MIX RATIO:** 1:1 by Volume (Base:Activator)  
100 gm: 119 gm by Weight

**COLOR:** Gray

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

**COVERAGE:** varies with thickness applied

**WEIGHT PER GALLON:** 12.4 lbs (6.53 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

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