

## PRODUCT DATA SHEET

### ARCOR 2211

REVISED 2/2014

**GENERIC TYPE:** AMINE CURED 100% SOLIDS EPOXY REBUILD

**DESCRIPTION AND RECOMMENDED USES:** 2211 is the most unique repair composite material on the market today. It was formulated with a combination of different multifunctional resin groups, coupled with fine ceramic powders and enhanced with 23 different additives to create our ultimate weapon in the fight against erosion / corrosion. Holds 3/4" on a vertical surface, yet is so creamy you can smooth out like glass. Three times the bonding strength of our closest competitor. Three times the chemical resistance. Outwears other ceramic filled rebuilding compounds Fully machinable. Non-slumping characteristics makes 2211 perfect for molding worn parts in place to eliminate the need to machine. Everyday uses for a wide array of mechanical repairs, especially damage caused by the combined forces of erosion / corrosion.

### FOR INDUSTRIAL USE ONLY

#### SPECIFICATION DATA

**TEMPERATURE:** Immersion service Max. 200°F (3 hours) ; Spike to 230°F (3 hours). Dry 400°F. Spike 500° (3 hours).

**CHEMICAL RESISTANCE:**

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

**ABRASION:** Excellent

**FILM THICKNESS:** up to 500 mils vertical

**FLEXIBILITY:** Good  
 Fair Flexural Strength 10,900 psi

**APPLICATIONS:** Condensers, Heat Exchangers, Circ. Pipe, Water Screens, Pumps, Impellers, Filters, Valves, Hydro Wheels, Tank Linings, Ion Exchange Filters, FGD, Ducts, Mix Zones, I.D. Fans, Scrubbers.

**SOLIDS BY VOLUME:** 100%

**VISCOSITY:** Putty

**POT LIFE:** 25 MIN / KG @ 72°F

**DENSITY:** 1.48

**MIX RATIO:** 2:1 by Volume (Base:Activator)  
 100 gm: 55 gm by Weight

**COLOR:** Blue

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

**COVERAGE:** varies with thickness applied

**WEIGHT PER GALLON:** 15 lbs (6.80 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

ARCOR 2211

REVISED 4/2013

**SEE MATERIAL SAFETY DATA SHEET BEFORE HANDLING THIS PRODUCT**

### **SURFACE PREPARATION:**

Metal surfaces are to be cleaned and degreased then abrasive blasted with chloride free abrasive. Exterior applications to SSPC SP-10 near white metal finish minimum 3 mil profile. Immersion applications to SSPC SP-5 White Metal, 3-5 mil profile. Grind flat all burrs, weld seams, radius sharp edges. Fresh blasted surfaces to be rebuilt as quickly as possible to prevent oxidation of the surface. For larger surface areas with ferrous metals apply a primer layer of ARCOR™ EE-11 Prime to prevent oxidation of the surface and allow time for proper rebuilding of the damaged area.

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-70, EE-79, 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 55 grams 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 6 to 14 hours at 77°F, 25°C. If overcoat window is exceeded abrade surface with course sandpaper, grinder or brush blast. Full cure before immersion 72 hours at 77°F. Add 1 day additional cure time for every 10°F below 77°F. Subtract 15 hours of cure time for each 10°F above 77°F. Force cure with heat for best performance for 1 hour at 200°F, 93°C, 12 hours at 120°F at 120°F, 49°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.