ARCOR®

EPOXY TECHNOLOGIES ®

PRODUCT DATA SHEET

ARCOR™ S-30 Prime

REVISED 09/18/01

GENERIC TYPE: AMINE CURED 100% SOLIDS EPOXY PRIMER

DESCRIPTION AND RECOMMENDED USES: ARCOR™ S-30 Prime is a solvent free, high functionality epoxy Novolac designed as a corrosion inhibiting primer for steel and metal alloys in immersion service. ARCOR™ S-30 Prime contains Zinc Phosphate which inhibits corrosion of the metal substrate due to diffusion of water and/or salts or mechanical damage to the coating. This effectively eliminates corrosion undercutting of the coating making ARCOR™ S-30 Prime ideally suited for aggressive water service (salt, brackish). The ARCOR™ S-30 Prime multi functional chemistry produces a fine multipurpose coating suited for moderate acid and caustic service, and elevated service temperatures. ARCOR™ S-30 Prime can be applied up to 70 mils without slump. Fluorescent pigment makes QC effective with use of a standard Ultraviolet light, even on Tubesheets.

FOR INDUSTRIAL USE ONLY

SPECIFICATION DATA

TEMPERATURE: Immersion service
Max.250ºF(121ºC); Spike to 300ºF(149ºC) 3 Hrs

CHEMICAL RESISTANCE:

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

ABRASION: Good

FILM THICKNESS: 20-70 mils/coat,
(.51-1.78 mm) Immersion:1 coat as prime.

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

APPLICATIONS: Condensers, Heat Exchangers, Circ. Pipe, Water Screens, Pumps, Impellers, Filters, Valves, Hydro Wheels, Tank Linings, Ion Exchange Filters.

SOLIDS BY VOLUME: 100%

VISCOSITY: 60,000 - 90,000 cps

POT LIFE: 40 Min/Gal @ 72ºF

MIX RATIO: 2:1 by Volume (Base:Activator)
100 gm :50 gm by Weight

COLOR: Light Blue

SHELF LIFE: 5 Years at 55-95ºF (13-35ºC)

COVERAGE: 23-80 ft2(2.1-7.5 M2) /gal(theoretical)

WEIGHT PER GALLON: 12.6 lbs (5.7 KG)
1 KG = 41 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

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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 surfaces to be primed immediately with ARCOR S-30 Prime to prevent oxidation of surface.

Concrete surfaces : Not Recommended for hand or roller application. Apply by heated plural or airless spray only. 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™ S-30 Prime.

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:
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 1/8" nap.
Plural Spray: .021-.035 tip, 3,000-3,500 PSI, Heat to 130ºF Base, 110ºF Activator.
Airless Spray: .021-.035 tip, 3,000-3,500 PSI(45:1). Use only with in-line heater at 120º to 135ºF.(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 95ºF(17 to 35ºC). Substrate: Keep between 45 to 105ºF(7 to 40ºC). The difference in temperature of the substrate and the material should never exceed 10ºF(5ºC). Substrate shall be a minimum of 5ºF(3ºC) 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(75ºF+, 24ºC) 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 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 6-12 hours at 77ºF(25ºC). If overcoat window is exceeded abrade surface with course sandpaper, grinder or brush blast. By spray application recoat between 2-12 hours at 77ºF. Full cure before immersion 72 hours at 77ºF. Add 30 hours additional cure time for each 10ºF below 77ºF. Subtract 12 hours of cure time for each 10ºF above 77ºF. Force Cure with heat for best performance for 4 hours at 200ºF(93ºC), 12 hours at 150ºF(66ºC).

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.

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