

## Surface Preparation

Proper surface preparation is critical to the long term performance of ARC HT-S(E). The exact requirements vary with the severity of the application, expected service life, and initial substrate conditions.

Optimum preparation will provide a surface thoroughly cleaned of all contaminants and roughened to an angular profile between 75-125 µm (3-5 mil). This is normally achieved by initial cleaning and degreasing and then abrasive blasting to a cleanliness of *White Metal (Sa 3/SP5)* or *Near-White Metal (Sa 2.5/SP10)* followed by removal of all abrasive residues.

## Mixing

To facilitate mixing and application, material temperature should be between 20°-35°C (68°-95°F). Each kit contains two pre-measured components in proportion as per the correct product mix ratio. If further proportioning is required, they should be divided according to the mix ratios:

Mix Ratio	By Weight	By Volume
A : B	8.4 : 1	4.7 : 1

Add Part B to Part A and mix thoroughly. Continue until the material is completely mixed, indicated by a homogeneous color with no streaks.

## Working Time – Minutes

	10°C	16°C	25°C	32°C	This chart defines the practical working time of ARC HT-S(E), starting from when mixing begins.
	50°F	60°F	77°F	90°F	
5 liter	140 min.	120 min.	90 min.	60 min.	
16 liter	120 min.	100 min.	70 min.	45 min.	

## Application

ARC HT-S(E) is normally applied as a two coat system with a total dry film thickness of 750-1,000 µm (30-40 mil). The recommended application temperature is 20°C-35°C (68°F-95°F). ARC HT-S(E) may be applied by brush or roller using a lint free short nap roller, as well as airless spray. For spray application please consult ARC Technical Bulletin #6 (Spray Equipment Guidelines) and spray equipment and set up guidelines. Prior to its light load cure state, ARC HT-S(E) may be overcoated with any of the ARC epoxy materials with the exception of ARC vinyl ester based coatings.

## Coverage

Thickness	Unit size	Coverage
750 µm (30 mil)	5 liter	6.67 m <sup>2</sup> (71.76 ft <sup>2</sup> )
	16 liter	21.33 m <sup>2</sup> (229.63 ft <sup>2</sup> )

## Curing Schedule

	10°C	16°C	25°C	32°C	<p>Note:</p> <p>Full service properties can be achieved rapidly by force curing. To force cure, first allow the material to become tack free, and then heat to 70°C (158°F) for 4 hours. In dynamic flow and abrasion conditions (wet or dry), ARC HT-S(E) must be post cured at 95°C (203°F) for 12 hours prior to use.</p>
	50°F	60°F	77°F	90°F	
Tack Free	10 hrs.	8 hrs.	6 hrs.	4 hrs.	
Overcoat Begin	8 hrs.	6 hrs.	4 hrs.	3 hrs.	
Overcoat End	20 hrs.	16 hrs.	12 hrs.	8 hrs.	
Full Service	5 days	4 days	3 days	2 days	

## Clean Up

Use commercial solvents (Acetone, Xylene, Alcohol, and Methyl Ethyl Ketone) to clean tools immediately after use. Once cured, the material would have to be abraded off.

## Safety

Before using any products, review the appropriate Safety Data Sheet (SDS) or Safety Sheet for your area. Follow standard confined space entry and work procedures, if appropriate.

**Shelf life (in unopened containers): 2 years [when stored between 10°C (50°F) and 32°C (90°F) in dry, cool, covered facility]**