



12/1/93

MASTER BUILDERS TECHNOLOGIES

1.3SS

CEILCOTE COROLINE SERIES *

For Steel Substrates

NOTES TO THE SPECIFIER

- 1. This document has been prepared to assist specifiers in the preparation of specifications for **CEILCOTE COROLINE SERIES**, a Master Builders Inc., CEILCOTE Corrosion Control Product.
 - 2. This document was prepared as part of a complete specification for new construction or the renovation and upgrading of existing structures.
 - 3. This specification defines the necessary practices for surface preparation and application of COROLINE Series along with tolerances where applicable.
 - 4. Application under this specification must be done in accordance with the standard installation procedures and related documents.
 - 5. Questions regarding the selection, installation or intended end use of Master Builders Inc., CEILCOTE CORROSION CONTROL PRODUCTS should be directed to Master Builders, Inc.
- * This specification may be used for all CEILCOTE COROLINE types including 505, 510, 538 and 800.

GUIDELINE SPECIFICATION

CEILCOTE COROLINE SERIES

(Steel)

The specification information below is intended for use by architects, engineers or other specifiers in defining the criteria needed to specify these modified epoxy lining systems.

1.0 GENERAL

1.1 SCOPE

This specification covers the surface preparation and application of CEILCOTE COROLINE as normally encountered in field installations.

Deviations from this specification due to unforeseen or unknown field conditions, must be authorized by Master Builders.

The contractor shall furnish all materials, tools, equipment, appliances, transportation, labor and supervision required during the preparation and installation process.

1.2 PRE-QUALIFICATION

Applicator of material must be approved by material manufacturer and have at least (5) years experience in the application of this or similar systems. Previous experience must be verified by (3) references having similar applications.

Contractor(s) seeking approval of substitute materials shall submit their request in writing to the specifier at least 7 days before closing of bids. Include samples; complete performance data; certification from independent testing laboratory regarding conformity with specifications and list of completed successful installations, with phone number of responsible person to contact, to enable accurate appraisal of the system. Bidders shall be notified of acceptable substitute lining by written addendum or amendment.

CEILCOTE COROLINE SERIES

(Steel)

1.3 APPLICABLE STANDARDS AND TEST METHODS

Physical properties and test methods for CEILCOTE COROLINE SERIES are listed in CEILCOTE COROLINE SERIES TECHNICAL DATA SHEET and INSTALLATION PROCEDURES.

- .1 Other reference documents include: CEILCOTE 680 TECHNICAL DATA SHEET and CEILCOTE Standard Specification for Steel Substrates to Receive Monolithic Linings - CPT-2.

1.4 PROJECT/SITE CONDITIONS

- .1 For all application steps, the surface temperature, air temperature and material temperature should be between 50°F (10°C) and 110°F (43°C).

Do not apply if the relative humidity is more than 90% or the surface temperature is less than 5% above the dew point of the air in the working area.

- .2 Adequate ventilation and clean water supply required during installation.

2.0 PRODUCTS

2.1 ACCEPTABLE MANUFACTURER

- .1 Master Builders, Inc., 23700 Chagrin Boulevard, Cleveland, Ohio 44122-5554, 216/831-5500 or 1-800-628-9990.
- .2 Master Builders Technologies Ltd. 3637 Weston Road, Toronto, Ontario, Canada, M9L1W1, 416-741-3830.
- .3 Tecnocreto, S.A. de C.V., Blvd. M. Avila, Camacho #80, 3er Piso, 53390 Naucalpan, Mexico Mexico 1-905-557-5544.

CEILCOTE COROLINE SERIES

(Steel)

2.2 MATERIALS

- .1 Materials for CEILCOTE COROLINE Series include:
 - CEILCOTE 680 Primer and Hardener
 - CEILCOTE COROLINE Resin and Hardener
 - Appropriate Filler (S-1, B-4, S-9(AR))
 - Cloth Reinforcement
 - T-420 Smoothing Liquid

3.0 EXECUTION

3.1 INSPECTION

- .1 Before starting work, ensure environmental and site conditions are suitable for application and curing.
- .2 Inspect surface for acceptability.
- .3 Any and all deficiencies shall be reported in writing.

3.2 PREPARATION

- .1 Surface conditions to apply the CEILCOTE COROLINE system requires the steel surface to be sandblasted to "White Metal" in accordance with SSPC SP5-63 or NACE No.1 using a clean, dry blasting media and a 3.0 mil anchor pattern. Blasted surfaces must be primed immediately after blasting, or within an 8 hour shift.

3.3 PROTECTION

- .1 Traffic Control - no individuals permitted in areas during application and until surface has cured, including protection after cure, against damage by others working in or over the area.
- .2 Compliance with OSHA, EPA, State and Local regulations or applicable agencies is mandatory when using these products.

CEILCOTE COROLINE SERIES

(Steel)

3.4 INSTALLATION/APPLICATION

- .1 Primer shall be CEILCOTE 680 primer, epoxy primer and saturant. It shall be applied by brush or roller to a film thickness of 1-4 mils.

Ingredients are to be mixed thoroughly and applied to steel. Working time at 73°F (23°C) is approximately 45 minutes.

- .2 Basecoat shall be a mixture of CEILCOTE COROLINE liquid, hardener and appropriate powder. It shall be trowel applied at a thickness of 40-80 mils.

Ingredients are to be mixed thoroughly and in sequence. Stir hardener into Coroline liquid then add powder and continue mixing. Apply immediately, working time at 73°F (23°C) is 40 minutes.

- .3 Glass cloth shall be CEILCOTE Type "H" or other cloth reinforcement as recommended due to chemical environment. It is to be immediately pressed into the trowel applied basecoat by rolling with a paint roller.

After being totally pressed into the basecoat it is then saturated with catalyzed CEILCOTE COROLINE liquid using a paint roller and allowed to cure.

- .4 Topcoat shall be a mixture of CEILCOTE COROLINE liquid, Hardener and appropriate powder. It shall be trowel applied at a thickness of 40-80 mils.

Ingredients are to be mixed thoroughly and in sequence. Stir hardener into Coroline liquid then add powder and continue mixing. Apply immediately, working time at 73°F (23°C) is 40 minutes. The lining shall be finished by brushing or rolling with T-420 Smoothing Liquid.

- .5 CEILCOTE COROLINE Installation PROCEDURE provides further details on procedures listed previously.

CEILCOTE COROLINE SERIES

(Steel)

3.5 TESTING

- .1 During application random wet film thickness reading shall be taken. Target thickness shall be 60 mils for both basecoat and topcoat yielding a total target thickness of 155 mils including the glass cloth reinforcement.
- .2 After topcoat is hard, spark test at 15,000-20,000 volts to insure pinhole free lining.
- .3 Dry film thickness can be measured by use of Dry Film Thickness Gauge (i.e. Elcometer or equivalent).

* This specification may be used for all CEILCOTE COROLINE types.

For abrasion resistant systems use "AR" designation and substitute S-9(AR) Powder in place of S-1 in Topcoat, i.e. CEILCOTE 505AR COROLINE (Abrasion Resistant).

For CEILCOTE 510 COROLINE substitute B-4 Powder instead of S-1.

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