

CEILCOTE® 630 FLAKELINE®

Self-priming epoxy-phenolic lining

DESCRIPTION:

CEILCOTE® 630 FLAKELINE® lining is a two component flake-reinforced epoxy phenolic lining system designed for severe chemical exposures and tank lining service. Suitable for petroleum products such as unleaded gasoline, jet fuel, aviation gasoline and solvents. The flake fillers provide an effective barrier against permeation and extend the service life of CEILCOTE 630 FLAKELINE lining.

TYPICAL USES:

- Tank lining for fuel & solvents.
- Surfaces exposed to fuel/solvents.

ADVANTAGE:

- Excellent chemical resistance.
- Resistant to Skydrol.
- Low permeability.

COLORS:

Available in Light Gray.

PHYSICAL PROPERTIES:

Generic Type: Epoxy-phenolic

Solids Content: 62% by volume

Volatile Organic Compounds:
(V.O.C.) Lab 23 Method of Reg. 8-4-111
of California Code 2.7 lbs/gal

Flash Point: 61°F [(16°C) mixed])
(Tag Closed Cup)

Temperature Resistance: (continuous)

- Immersion/ Condensing Fumes: 130°F (54°C)
- Atmospheric/Non-Condensing Fumes: 300°F (149°C)

Shelf Life: 18 months at 70°F (25°C), if kept tightly sealed

MIXING RATIO:

24:1- liquid to hardener by volume

Thinning: [between 50°F to 75°F (10°C to 24°C)
May use MEK - up to 4 oz/gal

COVERAGE:

Theoretical: 70 TO 80 ft²/gal (1.71 TO 2 m²/litre)
@ 12 mils DFT

HANDLING PROPERTIES:

(Approximate Time)

	50°F (10 °C)	73°F (23 °C)	90°F (32°C)
Working Time	5 to 6 hrs	3 to 4 hrs	1 hr
Recoat Time-min	24 hrs	8 hrs	6 hrs
Recoat Time-max	72 hrs	48 hrs	30 hrs
Cure Time	5 to 6 day	3 to 4 days	1.5 days

PACKAGING:

5 gallon (U.S.) units

LIMITATIONS:

Do not apply CEILCOTE 630 FLAKELINE lining when the surface temperature is below 50°F (10°C).

CEILCOTE 630 FLAKELINE lining should be recoated within one (1) week to assure proper adhesion between coats. For longer exposures, confirm recoatability by wiping the coating with toluene. If surface becomes "tacky", adhesion is acceptable. If not softened by toluene, surface must be gritblasted or mechanically abraded to provide a non-glossy, rough surface.

NOTE: Force curing at 120°F to 180°F (49°C to 83°C) for 48 to 72 hours will increase resistance to certain exposures.

APPLICATION: (abbreviated)

Primer:

Not normally required. Consult Master Builders, Inc.

Surface Preparation:

Steel - For immersion or high temperature service a "White Metal" abrasive blast (SSPC #5 or NACE #1) is required with an anchor pattern profile of 2 to 3 mils. For atmospheric service use a "Near White" abrasive blast (SSPC #10 or NACE #2).

Concrete - Abrasive blasting or scarification to remove laitance and surface contaminants is recommended. Concrete must be thoroughly cured, free of oils, curing solutions or mold release agents, dust and must be dry at time of application. Refer to ASTM D-4263.

PLACEMENT:

Mechanically premix each component (i.e., CEILCOTE 630 FLAKELINE liquid and hardener) individually prior to blending together. After initial mixing, add hardener to liquid. OBSERVE POT LIFE LIMITATIONS and mix for two more minutes to ensure that the hardener is well dispersed (For less than full units, mix A and B at 24:1 by volume). CEILCOTE 630 FLAKELINE lining may be applied by airless or conventional spray.

PLACEMENT, *continued*:

Number of Coats and Thickness:

Apply 10 to 12 wet mils (6 to 7 dry) in one multi-pass spray coat. Apply two coats for a total DFT of 12 to 15 mils.

Airless Spray - Minimum 30:1 ratio pump with a 40 mesh filter is recommended. A contractor Silver Gun with Reverse-A-Tip and .019 to .027 inch orifice is recommended. Adjust material pressure between 2600 to 3000 psi as required.

Conventional Spray - Use Devilbliss MBC-510 gun or equivalent with E tip and 704 Air Cap, 1/2 inch I.D. fluid line, .086 inch Fluid Tip, and 5/16 inch Air Hose. Adjust fluid pressure to provide adequate material to spray gun and use minimum atomization pressure - 70 to 100 psi, to break up and flow out with minimum overspray.

CLEAN UP:

Use Ceilcote T-410 MEK or lacquer thinner.

SAFETY:

Store in cool, dry area [50°F to 90°F (10°C to 32°C)] away from direct sunlight, flame or other hazards.

CEILCOTE 630 FLAKELINE lining contains epoxy and phenolic resins and alkaline curing agents, solvents and pigments. The product's components have been formulated to optimize physical characteristics such as filling capacity, abrasion, moisture and chemical resistance while minimizing hazardous physical and health factors encountered during application. A concerted effort is made to be aware of the latest chemical toxicological information and to apply this knowledge in a responsible manner to insure product safety.

During application of CEILCOTE 630 FLAKELINE materials, always wear gloves and appropriate work clothing to minimize contact. Ventilation is required with special consideration for enclosed or confined areas. Approved respirator may be required if "TLV's" are exceeded. Air movement must be designed to insure turnover at all locations in work area and adjacent areas to avoid buildup of heavy vapors. Use caution when handling flammable liquids, eliminate sources of ignition from work area, and containers with residues.

Observe safe storage practices by separating resins from hardeners, by keeping solvents in a cool area free of sources of ignitions.

Avoid prolonged contact with skin and breathing of vapor or spray mist.

Product Material Safety Data Sheets (MSDS) are available and should be consulted when handling products. These products are for industrial and professional use only; application directions must be followed.

MAINTENANCE:

Periodically inspect the applied material and repair localized areas needed. Consult your Master Builders representative for additional information.

For more information, contact your local Master Builders Representative.

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