

# CEILCOTE® 615 CEILGARD®

*High build flake filled maintenance coating*

## DESCRIPTION:

CEILCOTE® 615 CEILGARD® coating is a two component (A & B), high solids, flake filled surface tolerant, high build epoxy. The system provides total protection in one coat for application to rusty or galvanized steel surface and aged coatings. Proven as maintenance coating, the system can be applied to most tightly adhering coating systems, such as alkyds, epoxies, and polyurethanes. The CEILCOTE 615 CEILGARD coating system offers economical protection with long service life and low total applied costs.

## TYPICAL USES:

- Structural steel.
- Tank exteriors.
- Galvanized steel.
- Chemical plants.
- Water tower exteriors.
- Floating roofs & crude oil tanks.

## ADVANTAGES:

- Direct to metal surfaces where it is not practical to abrasive blast.
- Surface tolerant.
- High build epoxy.
- Bonds to most tightly adhered coatings.
- Economical protection.

## COLORS:

CEILCOTE 615 CEILGARD coating is available in Light, Medium and Dark Gray, Beige, Tile Red, Safety Colors and White. Special colors are available. Consult Master Builders.

## PHYSICAL PROPERTIES:

Used in conjunction with coating may be topcoated with CEILGARD polyurethane or epoxy, if desired.

<b>Generic Type</b>	High build epoxy (special product)
<b>Surface</b>	Over primed or aged coatings, steel, galvanized and concrete.
<b>Resistance</b>	Chemical fumes, spillage, marine and industrial environments.
<b>Density</b>	11.0 +/- 0.2 lb/gal (1.32 kg/L)
<b>Solids Content</b>	86% +/- 2% by volume
<b>Viscosity</b>	95 to 105 KU mixed at 77 °F (25 °C)
<b>Flash Point</b>	
<i>Pensky-Martens Closed Cup</i>	62 °F (17 °C)
<b>Volatile Organic Compounds (VOC)</b>	
<i>Lab 23 Method of Reg.8-4-111 of California Code</i>	
0.12 lb per gal (14 gm/L)	
<b>Shelf Life</b>	One year at 85 °F (29 °C) or below

## Temperature Resistance

*Continuous Dry* 250 °F (121 °C)

## COVERAGE (THEORETICAL):

170 to 275 ft<sup>2</sup>/gal @ 5 to 8 mils DFT  
(4.04 m<sup>2</sup>/L to 4.28 m<sup>2</sup>/L @ .13 to .2 mm)

## MIXING RATIO:

CEILCOTE 615 CEILGARD coating is a two component epoxy with a mix ratio of 1:1 by volume. Use mechanical stirrer to mix Part A (resin) and Part B (catalyst) separately. Then add Part B to Part A while continuously stirring.

## HANDLING PROPERTIES:

(Approximate Time)	55 °F (13 °C)	77 °F (25 °C)	90 °F (32 °C)
Working Time	8 h	4 h	4 h
Recoat Time (minimum)	30 h	6 h	12 h
Recoat Time (maximum)	Indefinite	90 days	60 days
Handling Time (dry to touch)	32 h	16 h	12 h
Cure Time	7 days	3 days	30 h

## PACKAGING:

Available in 2 gal (7.57 L) units.

## LIMITATIONS:

**CAUTION: POT LIFE IS GREATLY REDUCED AT ELEVATED TEMPERATURES**

Store in a cool, dry place that is away from fire hazards.

## APPLICATION: (ABBREVIATED)

### Surface Preparation:

#### Bare Steel:

Remove all oil, grease and other contaminants. If steel is rusted, only a wire brush is required to remove loose rust. Surface should be cleaned to an SSPC-SP-2 or SP-3 standard.

#### Concrete:

Brush blast or mechanically abrade. Concrete must be thoroughly cured, and free of oils, curing solutions, mold release agents or dust. Use plastic sheet test method to ensure concrete is moisture free (ASTM D 4263). If moisture is detected, retest until dry.

**Aged Coatings:**

Suitable for overcoating most tightly adhering aged coating systems, except chlorinated rubber and vinyls. Areas of breakdown should be hand or power tool prepared.

**Application:**

Airless spray preferred. Conventional spray or brush are acceptable.

**Recommended Thickness:**

6 to 10 wet mils (.15 to .26 mm) to achieve 5 to 8 mils (.13 to .2 mm) DFT per coat.

**Thinning:**

Normally not required. At low temperatures, up to 5%. Methyl ethyl ketone can be used.

**Recommended Application Equipment:**

Airless: 0.019 to 0.026 in. Tip Size (.48 to .66 mm)  
2,400 to 3,000 Atomization psi (17 MPa to 21 MPa)  
30:1 Pump Ratio

**Brush/Roller:**

May be used but film build may not be achieved.

**CLEAN UP:**

Use CEILCOTE T-410 Solvent, methyl ethyl ketone, or laquer thinner. DO NOT USE ACETONE SOLVENT.

**SAFETY:**

CEILCOTE 615 CEILGARD coating contains epoxy resin, polyamide catalyst and aromatic solvent. The product components have been formulated to optimize physical characteristics such as 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 ensure product safety.

During application of CEILCOTE 615 CEILGARD materials, always wear gloves and appropriate protective work clothing to minimize contact. Ventilation is required with special consideration for enclosed or confined areas. Air movement must be designed to ensure turnover at all locations in the 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 catalysts and by keeping solvents in a cool area, free from sources of ignition.

**MAINTENANCE:**

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

For additional information, contact your local Master Builders representative.

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