

CEILCOTE® 370 PRIMER

Polyester Steel Primer

DESCRIPTION:

Primer CEILCOTE 370 PRIMER is a catalyzed polyester resin metal primer for protecting abrasive blasted steel surfaces prior to applying a polyester or vinyl ester resin protective coating or lining material. It is not designed for long term corrosion protection, but will "hold" abrasive blasted surfaces to prevent rusting for several weeks until protective materials are applied.

COLOR:

Translucent orange.

PHYSICAL PROPERTIES:

Solids Content: 100% Reactive

Volatile Organic Compounds:
(V.O.C.) 1.35 lbs/gal (161.6 g/liter)
Lab 23 method of Reg. 8-4-111 of California Code

Flash Point:
(Pensky-Martens Closed Cup) 70°F (21°C)

Viscosity: 225 ± 25 cps

Density: (wt. per gal.) 8.1 lbs. ± 0.2 lbs.

Shelf Life:
6 months @ 40°F - 60°F (4°C - 16°C)
3 months @ 65°F - 80°F (18°C - 27°C)
1 month @ 80°F (27°C)

Mixing Ratio:
2 oz. of #3C Hardener for each gallon of material

Thinner: None required. DO NOT THIN.

Coverage:
Averages 275 to 300 ft²/gal (6.7 to 7.3 m²/litre) @ 2.0 dry mils

Handling Properties:
(Approximate Time)

	50°F (10°C)	73°F (23°C)	90°F (32°C)
Working Time	1-1/2hrs.	1 hr.	30 min.
Recoat Time	8 hrs.	2 hrs.	1 hr.

PACKAGING:

Available in 1 gal. and 5 gal. units

LIMITATIONS:

Surfaces should be topcoated within two weeks when exposed to direct sunlight; otherwise it must be topcoated within eight weeks to assure proper adhesion of topcoat to primer. For longer exposures confirm recoatability by wiping with styrene solvent. If surface becomes "tacky" adhesion is acceptable. If not softened by styrene, surface must be sandblasted or mechanically abraded to expose 75% of metal surface.

Store in a cool, dry place out of direct sunlight and away from fire hazards.

APPLICATION:

Surface Preparation:

Abrasive blast to "White Metal" in accordance with Steel Structures Painting Council Specification SP-5-89 or NACE No. 1, using clean dry abrasive to obtain a minimum 3.0 mil profile. Surface must be dry and free of foreign matter.

Number of Coats and Thickness:

One coat at 1.0-4.0 wet mils.

The appearance of CEILCOTE 370 PRIMER, when applied by brush, roller or spray, should be translucent. The metal substrate should be visible. The color of the application will be varied due to overlaps and slight thickness variation. Overlap areas should also be translucent.

CAUTION: This product is not intended to have a uniform opaque appearance. A uniform appearance with CEILCOTE 370 PRIMER indicates a dry film thickness in excess of 5 mils which is considered over thickness. Over thickness may cause polyester and vinyl ester topcoats to sag or slide off vertical surfaces.

PLACEMENT:

Brush: Use a natural bristle brush.

Roller: Use a short nap wool or mohair roller.

Conventional Spray: Use conventional pressure pot and spray equipment. With Binks 18 or 62 spray gun #63C or #66 spray tip and needle with 63 PM, 63 PB, or 63 PK air caps or equivalents from other manufacturers. Apply a light, wet coat to the surface without excessive overspray.

Airless Spray - Use a minimum 24:1 ratio pump with 0.015"-0.021" fluid nozzle and 30-60° fan angle. Adjust fluid pressure at approximately 1,000-2,000 psi to provide a uniform wet film. **CAUTION:** Working time or pot life is reduced from the amount of heat that is generated. Mix only what can be applied in 20 minutes at 70°F (21°C)

Roller Application - Use a short to medium nap roller, generally 3/8" and only apply what is necessary to cover steel (do not thin)

Brush Application - Use disposable pure bristle brushes..

Observe Pot Life Limitations:

Catalyze no more material than can be applied within the pot life period. Available working time, temperature and complexity of the area to be primed will determine how much material should be catalyzed at one time. Before placing freshly catalyzed material into pressure pot, discard all remaining primer and wipe pot clean since old primer will reduce pot life of freshly mixed material. Flush pot and lines thoroughly after every 2 - 4 batches at temperatures above 80°F (27°C). Keep material cool and shaded from direct sunlight in warm weather. Pot life can be extended by keeping material cool before and after mixing and by immersing pot in ice water during hot weather.

Flush pot and lines thoroughly and immediately after use.

CLEAN UP:

Use T-410 Solvent, Methyl Ethyl Ketone, or lacquer thinner.
DO NOT USE ACETONE SOLVENT.

SAFETY:

CEILCOTE 370 PRIMER Metal Primer contains polyester resins and styrene monomer. The hardener is an organic peroxide. Observe the following health, physical, and storage precautionary measures before using product.

Health Protection Information - Wear gloves, eye protection, and appropriate work clothing to avoid with components. Ventilation is required with special consideration for enclosed or confined areas. Air movement must be designed to insure turnover at all locations in work and adjacent areas to avoid buildup of heavy vapors. Styrene vapor concentration above 50 ppm as of March 1989 requires the use of an organic vapor cartridge respirator or a self-contained breathing apparatus.

Refer to Material Safety Data Sheets for specific health information on each product.

Physical Hazards - CEILCOTE 370 PRIMER Metal Primer components and solvents are flammable. Heat, sparks, and flames or any source of ignition must be kept at least 50 feet from working area. Use grounded non sparking tools in work area. When applying lining to enclosed area use two men, one on the outside for safety. Continue ventilation in tanks after coating until cured to minimize concentrating styrene vapors (Explosive Limit Styrene 1.1%). Empty containers with residues may ignite from source of ignition explosively.

Storage Safety - Observe safe storage practices by separating resins from hardeners, by keeping solvents and hardeners in a cool area free of sources of ignition, and by observing a special warning on RED and YELLOW labeled products. The RED label represents amine-type chemicals, and the YELLOW label represents organic peroxide-type chemicals which should not be stored adjacent or mixed together because of possible violent reaction between them.

No.3C and 3R Hardeners organic peroxides must be stored at temperatures below 100°F (38°C) to avoid decomposition and below 140°F (60°C) to avoid ignition from sparks or flame.

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Master Builders, Inc. United States

23700 Chagrin Boulevard
Cleveland, Ohio 44122-5554
(800) MBT-9990
Fax (216) 831-6910

Canada

3637 Weston Road
Toronto, Ontario M9L 1W1
(800) 387-5862
Fax (416) 741-7925

Mexico

Blvd. M. Avila Camacho 80, 3er Piso
53390 Naucalpan, México
011-525-557-5544
Fax: 011-525-395-7903