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MASTER BUILDERS TECHNOLOGIES

2.68SS

CEILCOTE 663 CEILGARD

For Steel Substrates

NOTES TO THE SPECIFIER

1. This document has been prepared to assist specifiers in the preparation of specifications for **CEILCOTE 663 CEILGARD**, 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 CEILCOTE 663 CEILGARD 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.

GUIDELINE SPECIFICATION

CEILCOTE 663 CEILGARD

(Steel)

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

1.0 GENERAL

1.1 SCOPE

This specification covers the surface preparation and application of CEILCOTE 663 CEILGARD 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 coating by written addendum or amendment.

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1.3 APPLICABLE STANDARDS AND TEST METHODS

Physical properties and test methods for CEILCOTE 663 CEILGARD are listed in CEILCOTE 663 CEILGARD TECHNICAL DATA SHEET.

- .1 Other reference documents include: CEILCOTE 600 FLAKELINE SERIES INSTALLATION PROCEDURES and CEILCOTE Standard Specification for Steel Substrate 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.

2.2 MATERIALS

- .1 Materials for CEILCOTE 663 CEILGARD include:
 - CEILCOTE 680 or 680C Primer and Hardener if required
 - CEILCOTE 663 CEILGARD Resin and Hardener
 - CEILCOTE 663G CEILGARD Resin and Hardener

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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 Immersion or direct spillage conditions -- Steel surface must be sandblasted to "White Metal" in accordance with SSPC SP-5 or NACE No.1 using a clean, dry blasting media and a 3 mil anchor pattern. Blasted surfaces must be primed immediately after blasting or within an eight hour shift.

For Splash and Spillage applications use SSPC SP-10 or NACE No.2.

- .2 Atmospheric Conditions -- Steel surface must be sandblasted to "Near White" finish in accordance with SSPC SP-10 or NACE No.2 using a clean, dry blasting media. Blasted surface must be primed immediately after blasting.

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.

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3.4 INSTALLATION/APPLICATION

- .1 Primer shall be CEILCOTE 680 Primer and hardener. It shall be applied by brush, roller or spray to a film thickness of 2-3 mils.

Ingredients are to be mixed thoroughly and immediately applied to steel. Working time at 73°F (23°C) is approximately 3 hours.

- .2 Basecoat shall be a mixture of CEILCOTE 663 CEILGARD liquid and hardener. It shall be applied at a thickness of 6-9 wet mils.

Ingredients are to be mixed thoroughly and in sequence. Stir hardener into liquid. Apply immediately, working time at 73°F (23°C) is 35 minutes.

- .3 Topcoat shall be a mixture of CEILCOTE 663 CEILGARD liquid and hardener. It shall be applied at a thickness of 6-9 wet mils (Same material as Basecoat).

Ingredients are to be mixed thoroughly and in sequence. Stir hardener into CEILCOTE 663 CEILGARD then apply immediately, working time at 73°F (23°C) 35 minutes.

CEILCOTE 663 CEILGARD may be applied by means of brushing, rolling or spraying.

- .4 Technical Data Sheet provides further details on procedures listed previously.

3.5 TESTING

- .1 During application random wet film thickness readings shall be taken. Target thickness shall be 6-9 mils for both basecoat and topcoat yielding a total target thickness of 12-18 dry mils. Dry film thickness shall be checked with a magnetic dry film gauge.
- .2 After Topcoat is hard, test with low voltage wet sponge testing to ensure pinhole free lining.
- .3 Dry film thickness can be measured by use of Dry Film Thickness Gauge.

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