

CEILCOTE® 322 FLAKELINE®

Thin-film vinyl ester coating

DESCRIPTION:

CEILCOTE® 322 FLAKELINE® coating is a thin film, flake filled catalyzed vinyl ester system that exhibits excellent resistance to acids, salts, oils, grease and aliphatic organics. It is recommended for dilute alkaline environments.

TYPICAL USES:

- Structural steel.
- Chemical process equipment.
- Immersion services for many dilute acids.

ADVANTAGES:

- Can be applied over concrete or steel.
- Excellent resistance to acids.
- Low permeability.
- Reinforced with laminar flake particles.

COLORS:

White

PHYSICAL PROPERTIES:

Generic Type	Catalyzed flake filled vinyl ester resin system
Density	10.0 +/- 0.2 lbs/gal (1.2 +/- 0.09 kg/litre)
Viscosity	1,400 to 1,800 cps @ 77°F (25°C)
Solids Content	100% Reactive
Flash Point	Mixed 84°F (29°C)
Volatile Organic Compounds (VOC)	
Lab 23 method of Reg. 8-4-111 of California Code	0.081 lbs/gal (0.01 kg/litre)
Temperature Resistance	
• 250°F (121°C) continuous dry	
• 120°F (49°C) immersion or condensing vapors	
Thinning	
DO NOT THIN	
Shelf Life	
• 8 months	@ 40°F to 70°F (4°C to 21°C)
• 6 months	@ 70°F (27°C)
• 4 months	@ 90°F (32°C)

MIXING RATIO:

1 gal CEILCOTE 322 FLAKELINE Resin (Part A) to 2 oz of Hardener #2C (Part B).

COVERAGE:

Actual coverage is approximately 50 ft²/gal (1.2 m²/litre) @ 16 to 20 mils which includes approximately 20% loss due to waste and overspray.

HANDLING PROPERTIES:

(Approximate Time)

	50 °F (10 °C)	75 °F (24 °C)	90 °F (32 °C)
Working Time	45 min	20 min	10 min
Recoat Time	8 hrs	3 hrs	2 hrs
Cure Time	48 hrs	24 hrs	16 hrs

PACKAGING:

- Available in 5 gal units.

LIMITATIONS:

Store in cool, dry area [50°F to 90°F (10°C to 30°C)] away from direct sunlight, flame or other hazards. Do not apply CEILCOTE 322 FLAKELINE coating when the surface temperature is below 50°F (10°C).

APPLICATION: (Abbreviated)

Surface Preparation:

Steel:

For immersion or intermittent splash and spillage conditions sandblast to "White Metal" in accordance with Steel Structures Painting Council (SSPC) Specifications SP-5-89 or NACE Specification #1. For fumes and dry environments sandblast to "Near White" in accordance with SP-10-89 or NACE #2. A minimum surface profile of 3.0 mils is required.

Concrete:

Abrasive blasting, or scarification or 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. Use plastic sheet test method to ensure concrete is moisture free (ASTM D-4263). If condensation appears on the underside of the plastic or if the concrete becomes visibly damp within 8 hours, the concrete is not dry enough to place the CEILCOTE 322 FLAKELINE coating.

Mixing:

Thoroughly stir resin (Part A) and then add 2 oz of Hardener #2C (Part B) for each gallon of CEILCOTE 322 FLAKELINE coating.

Number of Coats and Thickness:

Each coat requires application of 11 to 13 mils wet film thickness to achieve 8 to 10 mils dry. Two coats are generally required.

Airless Spray:

Use a minimum 28:1 ratio pump with a 3/8 inch ID fluid line. A 60 mesh screen is recommended and Graco REVERSE-A-CLEAN or Spraying Systems ROTOCLEAN tips to eliminate possible tip plugging. Tungsten Carbide spray tips are recommended with orifice sizes of 0.018 to 0.035 inches. Adjust outbound pressure between 2,000 to 3,000 psi (13.8 to 20 MPa) to obtain a suitable spray pattern.

Conventional Spray:

Use a conventional pressure pot with 3/8 inch fluid line (maximum 30 feet length) or 1/2 inch ID fluid line when spraying at heights or where 50 feet hose length is required. For high volume applications or long hoses, a 4:1 or 8:1 ratio pump can be used to provide material to the spray gun.

Brush or Roll:

Application may require an additional coat to obtain recommended film thickness.

CLEAN UP:

Use T-410 solvent, methyl ethyl ketone or lacquer thinner.

DO NOT USE ACETONE SOLVENT.

SAFETY:

- CEILCOTE 322 FLAKELINE coating contains vinyl ester resins, styrene monomer and inert flake fillers. The hardener is an organic peroxide. The product's components have been formulated to optimize physical lining characteristics 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 322 FLAKELINE coating materials always wear gloves and appropriate work clothing to minimize contact. Ventilation is required with special consideration for enclosed or confined area. Air movement must be designed to ensure turnover at all locations in work 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 and hardeners in a cool area free of sources of ignitions, 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 the possible violent reaction between them.
- Product Material Safety Data Sheets (MSDS) and Installation Procedures are available and should be consulted when handling products. These products are for industrial and professional use only; application directions must be followed.

For more information, contact your local Master Builders Representative.

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