

CEILCOTE® 650 FDA CEILGARD®

Epoxy coating

DESCRIPTION

CEILCOTE 650 FDA CEILGARD is a medium gloss, polyamide epoxy finish coat for application to metal or concrete surfaces. It provides excellent chemical, moisture and abrasion resistance.

TYPICAL USES

CEILCOTE 650 FDA CEILGARD is recommended for immersion service of water, potable water or noncorrosive effluents at solution temperatures up to 120°F.

Concrete and metal surfaces in:

- Food and beverage plants
- Pulp and paper mills
- Chemical plants
- Marine vessels and structures

ADVANTAGES

- Used in conjunction with potable water
- FDA acceptable
- Excellent chemical resistance
- Moisture tolerant cure

COLORS

White

PHYSICAL PROPERTIES

Generic Type	Polyamide epoxy
Solids by Volume	56%
Viscosity	70 to 100 cps @ 77°F (25°C) mixed
Weight/Gallon	10.9 + 0.2 lbs. mixed
Flash Point (Seta Flash)	64°F (18°C) mixed
Service Temperature Limits (continuous)	
Immersion/Condensing Fumes	120°F (49°C)
Atmospheric/Noncondensing Fumes	250°F (107°C)
Taber Abrasion (ASTM D 4060)	210 to 220 mg
Coverage Theoretical	900 sq.ft/gal @ 1 mil DFT
Number of Coats and Thickness	

One or two coats at 2 to 4 dry mils per coat. For chemical service or immersion two coats applied over the primer to achieve a minimum total film thickness of 10 dry mils are required.

Mix Ratio 6:1 - liquid to hardener by weight
4:1 - liquid to hardener by volume

Thinning Generally not required.

Handling Properties (Approximate Time)

	50°F (10°C)	73°F (23°C)	90°F (32°C)
Pot Life	20 to 24 hrs.	8 to 10 hrs.	5 to 6 hrs.
Drying Time	24 to 28 hrs.	14 hrs.	8 hrs.
To Recoat	36 hrs.	18 hrs.	10 hrs.
Cure Time	48 hrs.	24 hrs.	16 hrs.

Packaging

Available in 1 and 5 gallon (U.S.) units

Shelf Life

Shelf life for material is one year minimum, if kept tightly sealed at 70°F.

LIMITATIONS:

Do not apply CEILCOTE 650 FDA CEILGARD when the surface temperature is below 50°F.

Allow 60 minutes after mixing before applying material.

CEILCOTE 650 FDA CEILGARD should be recoated within two (2) weeks to assure proper adhesion of topcoat to basecoat. 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.

APPLICATION: (ABBREVIATED)

Detailed installation procedures are contained in the - Installation Procedures Bulletin for CEILCOTE 650 FDA CEILGARD.

SURFACE PREPARATION:

Steel - For metal surfaces sandblast per SSPC SP-5-89 "White Metal" blast with 2.0 mil anchor pattern.

Concrete - Gritblasting or scarification to remove laitance and surface contaminants is recommended but acid etching with a 1 :2 solution of hydrochloric acid in water can be employed on horizontal surfaces. Concrete must be thoroughly cured (minimum of 14 days), free of oils, curing solutions or mold release agents, dust and must be dry at time of application. Refer to ASTM D-4263.

PLACEMENT:

Mix thoroughly. Allow 60 minutes after mixing before applying material.

Mechanically premix each component (i.e., CEILCOTE 650 FDA CEILGARD liquid and hardener) individually prior to blending together. After initial mixing, add hardener to liquid and mix for two more minutes to ensure that the hardener is well dispersed. CEILCOTE 650 FDA CEILGARD may be applied by airless or conventional spray, brush or roller.

Air Spray - Use Binks 18 or 62 spray gun; minimum 3/8" ID. fluid line with #66 (.070) fluid tip and needle with 67PD air cap. Adjust fluid pressure to provide adequate material to spray gun and use minimum atomization pressure to break up and flow out with minimum overspray.

Airless Spray - Minimum 28:1 ratio pump with 60 mesh filter recommended. A Spraying Systems 25-A Gunjet spray gun with Rotoclean tip and tungsten carbide orifices of .017 to .026" and 25 to 60° fan angle is recommended. Adjust material pressure between 1200 -2500 psi as required.

Brush or Roller - Generally requires additional applications to obtain the recommended milage. Use short nap rollers and medium stiff natural bristle brushes.

CLEAN UP

Use Toluene, Xylol or T410. MEK, Lacquer Thinner

SAFETY

Store in cool, dry area (50 - 90°F) away from direct sunlight, flame or other hazards.

CEILCOTE 650 FDA CEILGARD contains epoxy resins and polyamide catalyst and aromatic solvents. The product's 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 concerned 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 650 FDA CEILGARD materials always wear gloves and appropriate work clothing to minimize contact. Ventilation is required with special consideration for enclosed or confined areas. 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.

Product Material Safety Data Sheets 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 as needed. Consult your Master Builders representative for additional information.

TECHNICAL ASSISTANCE

For technical assistance please contact your Master Builders representative .

Master Builders, Inc.

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