

CEILCOTE 675 FLAKEPRIME®

Catalyzed epoxy primer

DESCRIPTION:

Most advanced of epoxy primers CEILCOTE 675 FLAKEPRIME is a two component product which combines the layering of micro-thin flake pigments with a unique resin/cure process. Thus it not only provides exceptional resistance to rust, chemical corrosion and resistance to undercutting, but also has the ability to cure at low temperatures and over damp surfaces.

CEILCOTE 675 FLAKEPRIME utilizes an advanced rust inhibiting system which does not rely solely upon the gradual deterioration of soluble pigments to prevent rust formation. Under highly corrosive conditions the primer retains its inhibitive properties much longer resulting in improved corrosion resistance and longer service life.

RECOMMENDED USES:

Prime coat on steel or concrete surfaces. Although generally recommended for sandblasted surfaces. CEILCOTE 675 FLAKEPRIME'S exceptional moisture tolerance permits its use over waterblasted or wet sandblasted surfaces. (Consult Master Builders technical representative.)

USE IN CONJUNCTION WITH:

Prime coat for CEILCOTE 600 FLAKELINE Epoxy Topcoat, optional prime coat for CEILCOTE 661 FLAKETAR Coal Tar Epoxy.

GENERIC TYPE:

Catalyzed. rust inhibitive epoxy primer.

SURFACE:

Applied over properly prepared masonry and steel substrates.

RESISTANCE:

Highly resistant to alkalis or solvents, equivalent to the best amine or polyamide primers. Superior to other epoxies in resistance to inorganic acids in water, and can be considered equivalent to vinyls in acid fumes, spillage or

water immersion environments. It is equivalent to amine cured epoxies in resistance to organic acids.

PRODUCT DATA:

Color	Red
Density (wt. per gal)	10.7 ± 0.2 lbs. (mixed)
Solids Content	73% by volume, 82% by weight
V.O.C. (Volatile Organic Compounds)	2.4 lbs per gal
Viscosity	300 ± 50 cps @ 77°F
Flash Point (Pensky-Martens Closed Cup)	Part A-65°F (18°C) Part B-130°F (54°C)
Shelf Life	Six months at temperatures below 90°F
Pot Life	12 hrs @ 24°F; 8 hrs @ 50°F 3 hrs @ 70°F; 2 hrs @ 90°F
Temperature Resistance	350°F continuous dry wet varies depending upon topcoat.

SURFACE PREPARATION:

Steel – For immersion or direct spillage use a "White Metal" sandblast in accordance with Steel Structures Painting Council Specification SP-5-89 or NACE Specification #1. For non-immersion a "Commercial" sandblast in accordance with SP-6-89 or NACE #3 is acceptable if cleaning is maintained in strict accordance with these specifications. Profile depth should be 1.0 to 2.0 mils. Can be applied over hand cleaned surface but reduced performance will result.

Concrete – Sandblast to provide a clean, sound, dry surface. Concrete must be thoroughly cured before preparing surface. All laitance, dust, curing or release agents must be removed during surface preparation. Reference ASTM D-4263.

APPLICATION:

Suitable for spray application at temperatures below 20°F and will cure properly at temperatures as low as 10°F.

PRECAUTIONS — Maintain adequate ventilation and avoid application over frosted surfaces or ice.

CEILCOTE 675 FLAKEPRIME will bond to damp concrete surfaces after acid etching or to concrete containing residual moisture as long as the surface is not visibly wet or hydrostatic pressure is not present. On moist surfaces apply with brush or roller to insure optimum adhesion.

Number of Coats and Thickness

One coat at 2.0 to 3.0 dry mils. Three wet mils will yield 2.5 dry mils.

Coverage

Theoretical coverage is 1,171 ft²/gal @ 1 mil DFT. Concrete surfaces will average about 250 ft²/gal depending upon surface texture and actual film thickness.

Thinning

If needed, add up to 2 oz. per gal. of MEK at temperatures between 20 to 70°F. Use up to 2 oz. per gal. of Solvent T-460 at temperatures above 70°F.

Recoat & Curing Time

	Recoat Time	Cure Time
@ 25°F (-4°C)	12-18 hrs	96 hrs
@ 50°F (10°C)	6-8 hrs	36 hrs
@ 70°F (21°C)	3 hrs	12 hrs
@ 90°F (32°C)	1 hr	8 hrs

For immersion service, topcoating should be done within 30 days. For atmospheric service, topcoating should be done within 120 days.

MIXING::

Mix Hardener (Part B) into Resin (Part A) using mechanical agitation to assure complete mixing. Material will become thinner when mixed. *Observe pot life limitations.*

APPLICATION EQUIPMENT:

Brush or roller applications are particularly recommended for concrete—use a short nap roller, working material into surface, or use medium stiff natural bristle brush.

Conventional Spray—Use 3/8" I.D fluid hose of 75 ft. maximum length. Use Binks #66 fluid tip and needle, 63 PJ or 63 PB air caps, or equivalents from other manufacturers.

Airless Spray—Use a minimum of 23:1 ratio pump and 60 to 100 mesh filter. Use tungsten carbide fluid orifice sizes of 0.015-0.023, with 25 to 70° angles.

CLEAN UP:

Use T410 solvent methyl ethyl ketone or lacquer thinner.

PACKAGING:

Available in 1 gal. and 5 gal. units.

STORAGE:

Store in a cool, dry place away from fire hazards

SAFETY:

CEILCOTE 675 FLAKEPRIME contains epoxy resins, polyamide catalyst and aromatic solvent. 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 675 FLAKEPRIME 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, try keeping solvents in a cool area free of sources of ignitions.

Product Material Safety Data Sheets and Installation Bulletins are available and should be consulted when handling products. These bulletins are for industrial and professional use only; application directions must be followed.

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