

# CEILCOTE® 251 FLAKELINE® and CEILCOTE® 252 FLAKELINE®

*Catalyzed polyester coatings*

## DESCRIPTION:

CEILCOTE® 251/252 FLAKELINE® coatings are flake filled, catalyzed polyester systems that exhibit excellent resistance to acids, salts, alkalies and many organic solvents. CEILCOTE 251 FLAKELINE coating is a rapid cure version of CEILCOTE 252 FLAKELINE coating and must be applied with special spray equipment.

## TYPICAL USES:

- Metal processing areas.
- Oil production facilities.
- Chemical processing plants.
- Waste treatment systems.

## ADVANTAGES:

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

## COLORS:

Off white and gray. CEILCOTE 252 FLAKELINE is available in special colors you request.

## PHYSICAL PROPERTIES:

**Generic Type**  
polyester

**Density**  
10.0 ± 0.2 lbs/gal (1.2 ± 0.09 kg/liter)

**Volatile Organic Compounds (VOC)**  
Lab 23 method of Reg. 8-4-111 of California Code  
0.28 lbs/gal (0.03 kg/liter)

**Viscosity**  
3,500 to 4,000 cps @ 77°F (25°C)

**Flash Point**  
Pensky Martens Closed Cup  
93°F (34°C)

**Service Temperature Limits (continuous)**

- Immersion/Condensing Fumes 130°F (54°C)
- Continuous Dry 350°F (177°C)

**Shelf Life (Expiration dates printed on labels)**  
CEILCOTE 251 FLAKELINE coating

- 3 months at 70°F to 90°F (21°C to 32°C)

CEILCOTE 252 FLAKELINE coating

- 6 months at 70°F to 90°F (21°C to 32°C)

## MIXING RATIO:

Stir thoroughly, then add 2 oz. of Hardener #3R or #3C for each gallon of CEILCOTE 251 FLAKELINE coating or CEILCOTE 252 FLAKELINE coating.

## COVERAGE:

Actual coverage is 25 to 35 ft<sup>2</sup>/gal (.6 to .86 m<sup>2</sup>/liter) @ 35 mils which includes approximately 20% loss due to waste and overspray.

## HANDLING PROPERTIES:

### Pot Life Temperature

• CEILCOTE 251 FLAKELINE coating	
@ 50°F (10°C)	15 to 20 min.
@ 70°F to 80°F (21°C to 27°C)	7 to 12 min.
@ 90°F (32°C)	2 to 5 min.
• CEILCOTE 252 FLAKELINE coating	
@ 50°F (10°C)	100 min.
@ 70°F to 80°F (21°C to 27°C)	60 min.
@ 90°F (32°C)	45 min.

Temperature	To Recoat/ Handle (hours)	To Cure (hours)
• CEILCOTE 251 FLAKELINE coating		
@ 50°F (10°C)	3 to 6	24
@ 75°F (24°C)	1-1/2 to 3	16
@ 90°F (32°C)	1 to 2	8
• CEILCOTE 252 FLAKELINE coating		
@ 50°F (10°C)	12 to 24	48
@ 75°F (24°C)	4 to 8	24
@ 90°F (32°C)	3 to 4	16

## PACKAGING:

Available in 1 gal and 5 gal containers. Hardener (catalyst) is included in the material price with 2 oz of hardener per gallon of material in separate container.

## LIMITATIONS:

Do not apply CEILCOTE 251 FLAKELINE coating or CEILCOTE 252 FLAKELINE coating when the surface temperature is below 50°F (10°C) or over 110°F (43°C). Store in a cool, dry place away from fire hazards.

## APPLICATION: (ABBREVIATED)

For complete details, refer to Installation Procedure #2.2I for CEILCOTE 200 FLAKELINE Series.

### Surface Preparation:

#### Steel:

Blast with sharp abrasive. A "White Metal" surface (SSPC #5-89 or NACE #1) is required with a minimum anchor pattern profile of 3 mils.

**APPLICATION (Abbreviated), continued:**

**Concrete:**

Grit blasting or scarification to remove laitance and surface contaminants is required. Concrete must be thoroughly cured, free of oils, curing solutions and mold release agents, dust and must be dry at time of application. Reference ASTM D-4263.

**Primers:**

**For Steel Surfaces:**

CEILCOTE 370 PRIMER

**For Concrete Surfaces:**

CEILCOTE 380 PRIMER

CEILCOTE 380C (Conductive) PRIMER [Use when spark testing (High voltage Holiday testing) will be conducted on concrete]

- Mechanically premix CEILCOTE 251 FLAKELINE coating or CEILCOTE 252 FLAKELINE coating resin (i.e. Part A) 2 minutes individually prior to adding hardener. After initial mixing, add **2 oz of #3R or #3C Hardener per gallon** of CEILCOTE 251/252 FLAKELINE resin and mix three additional minutes.
- Apply CEILCOTE 251 FLAKELINE coating or CEILCOTE 252 FLAKELINE coating resin and hardener at 20 to 32 mils WFT to yield 15 to 25 mils DFT, target of 18 mils DFT. Allow to harden. Repeat for second coat.

**Thinning:**

None required. DO NOT THIN.

**Application Equipment:**

- **Conventional Spray:**  
For equipment recommendation, please reference Installation Procedure 2.2I.
- **Air Assisted Airless:**  
For equipment recommendation refer to Installation Procedure #2.2I (Special Catalyst Spray Equipment section).
- **Airless Spray:**  
Normally not recommended. Consult Master Builders, Inc.
- **Brush or Roller:**  
When rolling or brushing three coats may be required to achieve recommended film thicknesses.

**CLEAN UP:**

Use T-410 Solvent, methyl ethyl ketone or lacquer thinner.  
**DO NOT USE ACETONE SOLVENT.**

**SAFETY:**

- CEILCOTE 251 FLAKELINE coating and/or CEILCOTE 252 FLAKELINE coating contain polyester 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 insure product safety.
- During application of CEILCOTE 251 FLAKELINE coating and/or CEILCOTE 252 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 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 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 chemical 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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