

# CEILCOTE® 600 FLAKELINE®

*Amine adduct cured epoxy coating*

## DESCRIPTION:

CEILCOTE® 600 FLAKELINE® coating is a two-component, high build (6 to 8 mils/coat) flake filled epoxy topcoat providing improved chemical resistance to alkalis, inorganic acids and many aromatic and aliphatic solvents. Unique curing systems allow application at low temperatures.

## TYPICAL USES:

- For corrosion protection in chemical fumes, spillage or marine environments.
- Structural steel.
- Piping.
- Tanks.
- Equipment in chemical, paper, marine & petroleum facilities.
- May also be used as a light duty lining in water or mild chemical solutions at ambient temperatures.
- Secondary containment.

## ADVANTAGES:

- Moisture tolerance.
- Low temperature cure capability.
- Flake reinforced.
- Good chemical resistance.
- Low permeance.

## COLORS:

White, Light Gray, Medium Gray, Dark Gray, Beige, and Tile Red. Special colors available upon request.

## PHYSICAL PROPERTIES:

**Density:** (wt./gallon) 10.3 + 0.02 lbs  
**Solids Content:** 83% by Volume  
**Viscosity:** (Mixed) 700 + 200 cps @ 77°F (25°C)

### Flash Point:

*Pensky-Martens Closed Cup*

Part A -	35 °F	(2 °C)
Part B -	210 °F	(99 °C)
Mixed -	61 °F	(16 °C)

### Temperature Resistance:

Continuous Dry	220 °F	(104 °C)
Immersion	120 °F	(49 °C)
Splash and Spillage	160 °F	(71 °C)

### Resistance:

Resistant to alkalis, inorganic acids, chemical fumes, solvents and fresh and salt water immersion.

### Shelf Life:

One (1) year at temperatures below 90°F (32°C)

## MIXING RATIO:

- 4 parts resin to 3 parts hardener (by volume)
- 4 fl. ozs. (118 ml) of LTC Accelerator per gallon (litre) of CEILCOTE 600 FLAKELINE coating.

## COVERAGE:

Approximately 140 to 160 ft²/gal (3.4 to 3.9 m²/litre)  
 @ 6 dry mils

## HANDLING PROPERTIES:

Without LTC Accelerator

	25 °F (-4 °C)	50 °F (10 °C)	73 °F (23 °C)	90 °F (32 °C)
Working Time	8 hrs	3 hrs	2 hrs.	45 min.
Recoat Time	48 hrs	15 hrs.	4 hrs.	3 hrs.
Cure Time	48 to 72 hrs.	18 to 24 hrs.	6 to 12 hrs	4 hrs.

With LTC Accelerator

	25 °F (-4 °C)	50 °F (10 °C)	73 °F (23 °C)	90 °F (32 °C)
Working Time	4 hrs	1-1/2 hrs.	1 hrs	20 min.
Recoat Time	24 hrs.	7 to 8 hrs.	2 hrs.	1-1/2 hrs.
Cure Time	24 to 36 hrs.	9 to 12 hrs.	3 to 6 hrs.	2 hrs.

## PACKAGING:

Available in 1 & 5 gal. units

## LIMITATIONS:

Store in a cool, dry place away from fire hazards. May be recoated up to 30 days. After 30 days, sand or sweep blast to remove gloss and roughen surface to proper adhesion.

## APPLICATION: (abbreviated)

### Surface Preparation:

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

**Concrete** - New, previously coated or heavily contaminated surfaces should be abrasive blasted, Blast Trac or scarify to provide a clean surface. Concrete must be thoroughly cured, free of oils, curing solutions and mold release agents, dust and contamination.

The major problem with curing concrete is the water content, therefore a thorough moisture test must be done on the substrate. This can be checked by ASTM D-4263, which calls for taping an 18" x 18" square of polyethylene or other clear film to the floor. If condensation appears on the underside of the film or if the concrete becomes visibly damp within 8 hours, the concrete is not dry enough to place the materials.

#### **Primers:**

**For Steel Surfaces** - CEILCOTE 680 PRIMER or CEILCOTE 675 FLAKEPRIME

**For Concrete Surfaces** - CEILCOTE 680 PRIMER

#### **MIXING:**

Add Catalyst Part B into Resin Part A and mix thoroughly with mechanical agitation. Material will become much thinner when mixed. **OBSERVE POT LIFE LIMITATIONS.** If material thickens in pot, discard material and flush pot and lines.

#### **Thinning:**

Generally not required. May use up to 4 oz. of MEK solvent at temperatures below 70°F (21°C). Use T-460 solvent at temperatures above 70°F (21°C).

#### **APPLICATION:**

Airless, Conventional, Brush or Roller.

#### **Number of Coats and Thickness:**

One coat at 8 to 10 mils WFT for chemical fumes or weathering. For direct spillage or immersion, apply two coats at 8 to 10 mils WFT per coat. For low temperature capabilities or reducing cure time CEILCOTE LTC Accelerator can be used. Suggested quantity, add 4 oz. of LTC Accelerator to every gal. of CEILCOTE 600 FLAKELINE coating. PLEASE NOTE THAT THE USE OF LTC ACCELERATOR REDUCES THE POT LIFE AND CURE TIME APPROXIMATELY IN HALF. It also thins the material.

#### **Application Equipment:**

**Air Spray** - Use Binks 18 or 62 spray gun; minimum 3/8" I.D. fluid line with #66 (.070) fluid tip and needle with 63PJ or #63 PB air caps. For high production spraying, substitute #67 (.086) 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 over spray.

**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 0.017 to 0.026"; and 25 to 60° fan angle is recommended. Adjust material pressure between 1,200 - 2,500 psi as required.

#### **CLEAN UP:**

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

#### **SAFETY:**

CEILCOTE 600 FLAKELINE coating contains epoxy resins, polyamide catalyst and aromatic solvent. The product's components have been formulated to optimize physical characteristics such as filling capacity, abrasion, moisture and chemical resistance 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 600 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 turn-over 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 (MSDS) and Installation Bulletins 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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