

CEILCOTE® 661 FLAKETAR®

Amine adduct coal tar epoxy

DESCRIPTION:

CEILCOTE® 661 FLAKETAR is a two-component, coal tar epoxy which is flake reinforced to reduce permeation and cured with an amine adduct that greatly increases chemical resistance. It can be cured at temperatures as low as 10°F (- 12°C) and is used in conjunction with FLAKEPRIME 675 or 680 Primer/Saturant.

Resistance

Suitable for exposure to dilute organic and inorganic acids, dilute caustics, salts, brine and petroleum products such as jet fuels and mineral acids.

RECOMMENDED USES:

- Protecting buried equipment such as tanks, pilings and piping.
- Marine applications such as bilge tanks and barge or ship hulls
- Tank lining material resistant to sea water, brine, sour crude, petroleum products and mild-to-moderate chemical solutions.

PRODUCT DATA:

Color	Black
Density <i>[Weight per gallon (liter)]</i>	10.4 ± 0.2 lbs. (4.7 ± 0.09 kg)
Solids Content	80% by volume
Viscosity	1,500 to 2,100 cps @ 77°F (25°C)
Flash Point <i>(Pensky Martens Closed Cup)</i>	44°F (7°C) mixed
Shelf Life	6 months at temperatures below 90°F (32°C).
Pot Life	24 to 48 hours @ 25°F (4°C) 6 to 12 hours @ 50° F (10°C) 4 hours @ 75°F (24°C) and 3 hours @ 90°F (32°C)
Acceleration of Cure	FLAKETAR 661 epoxy cures slowly at lower temperatures. To speedup curing time, order 4 fl ozs. (118 ml) of LTC Accelerator per gallon (liter) of FLAKETAR 661 epoxy.
Temperature Resistance	
Immersion	120°F (49°C)
Continuous Dry	220°F (104°C)

PACKAGING:

CEILCOTE 661 FLAKETAR epoxy is available in 1 and 5 U.S. gallon (3.8 and 19 liter) containers.

ESTIMATING:

Number of Coats and Thickness

CEILCOTE 661 FLAKETAR epoxy is normally applied with a conventional or airless sprayer, brush or roller in two 8 to 10 mil coats to achieve 16.0 dry mils. 10 wet mils will yield 8.0 dry mils.

Coverage

Theoretical coverage is 1,283 ft²/gallon (31.4 m²/liter) at a 1 mil DFT.

TYPES OF SURFACE:

Can be applied over masonry and all metal surfaces with proper surface preparation.

SURFACE PREPARATION:

Metal

For immersion or intermittent splash and spillage conditions, sandblast to "White Metal" in accordance with Steel Structures Painting Council Specification SP-5-89 or NACE Specification No.1. For fume and dry environments, sandblast to "Near White" in accordance with SP-10-89 or NACE No. 2. A minimum surface profile of 3.0 mils is required.

Concrete

Abrasive blasting or scarification to 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. Refer to ASTM D-4263.

MIXING:

Mix equal quantities of the Resin Component "Part A" into the Tar Component "Part B." Stir with mechanical agitation for several minutes until thoroughly mixed. MIX NO MORE MATERIAL THAN CAN BE USED DURING THE SPECIFIED POT LIFE.

Thinning

Thinning is normally not required. If needed, add up to 4 fl. ozs. (118 ml) of T-460 solvent per gallon (liter) of FLAKETAR epoxy at temperatures above 70°F (21°C). At temperatures below 70°F (21°C), use MEK solvent.

APPLICATION EQUIPMENT:

Air Spray

Use a Binks 18 or 62 spray gun, minimum 3/8" (9.5 mm) I.D. fluid line with a #66 (0.070) fluid tip and needle and a #63 PJ or a #63PB air cap. For high production spraying, substitute a #67 (0.086) fluid cap needle and 67 PD 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

A minimum 28:1 ratio pump with a 60 mesh filter is recommended. A Spraying Systems 25-A Gunjet spray gun with a Rotoclean tip and tungsten carbide orifices of 0.017 to 0.026" (0.43 to 0.66 mm) and a 25 to 60° fan angle is recommended. Adjust material pressure to between 1,200 and 2,500 psi (8.3 and 17.2 MPa) as required.

RECOAT AND CURING TIME:

Temperature	Standard Recoat Time (Hours)	Formulation Cure Time (Hours)	With LTC Recoat Time (Hours)	Accelerator Cure Time
25°F (-4°C)	24 to 48	96 to 120	12 to 24	48 to 60
50°F (10°C)	6 to 12	48 to 72	3 to 6	24 to 36
75°F (24°C)	4	16	2	8
90°F (32°C)	3	8	1-1/2	4

CLEAN UP:

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

STORAGE:

Store in a cool, dry place away from fire hazards.

SAFETY:

CEILCOTE 661 FLAKETAR coal tar epoxy contains epoxy resins, an amine adduct catalyst and an aromatic solvent. The product's components have been formulated to optimize physical lining 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 ensure product safety.

During application of CEILCOTE 661 FLAKETAR coat tar epoxy 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 ensure turnover at all locations in the work area and in adjacent areas to avoid buildup of heavy vapors. Use caution when handling flammable liquids, and eliminate sources of ignition from work areas and containers with residues.

Observe safe storage practices by separating resins from hardeners and by keeping solvents in a cool area free of sources of ignition.

Product Safety Material Data Sheets (MSDS) and installation bulletins are available and should be consulted when handling this product. This product is for industrial and professional use only. Application directions must be followed.

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