

12/1/93

MASTER BUILDERS TECHNOLOGIES

2.31SS

CEILCOTE 300 FLAKELINE SERIES *

For Steel Substrates

NOTES TO THE SPECIFIER

1. This document has been prepared to assist specifiers in the preparation of specifications for ***CEILCOTE 300 FLAKELINE SERIES***, a Master Builders Inc., CEILCOTE Corrosion Control Product.
2. This document was prepared as part of a complete specification for new construction or the renovation and upgrading of existing structures.
3. This specification defines the necessary practices for surface preparation and application of CEILCOTE 300 Flakeline Series along with tolerances where applicable.
4. Application under this specification must be done in accordance with the standard installation procedures and related documents.
5. Questions regarding the selection, installation or intended end use of Master Builders Inc., CEILCOTE CORROSION CONTROL PRODUCTS should be directed to Master Builders, Inc.

* This specification may be used for all CEILCOTE 300 FLAKELINE SERIES types including 301 and 322.

GUIDELINE SPECIFICATION
CEILCOTE 300 FLAKELINE SERIES
(Steel)

The specification information below is intended for use by architects, engineers or other specifiers in defining the criteria needed to specify this polyester/vinyl ester coating systems.

1.0 GENERAL

1.1 SCOPE

This specification covers the surface preparation and application of CEILCOTE 300 Flakeline Series as normally encountered in field installations.

Deviations from this specification due to unforeseen or unknown field conditions, must be authorized by Master Builders.

The contractor shall furnish all materials, tools, equipment, appliances, transportation, labor and supervision required during the preparation and installation process.

1.2 PRE-QUALIFICATION

Applicator of material must be approved by material manufacturer and have at least (5) years experience in the application of this product. Previous experience must be verified by (3) references having similar applications.

Contractor(s) seeking approval of substitute materials shall submit their request in writing to the specifier at least 7 days before closing of bids. Include samples; complete performance data; certification from independent testing laboratory regarding conformity with specifications and list of completed successful installations, with phone number of responsible person to contact, to enable accurate appraisal of the system. Bidders shall be notified of acceptable substitute coating system by written addendum or amendment.

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1.3 APPLICABLE STANDARDS AND TEST METHODS

Physical properties and test methods for CEILCOTE 300 FLAKELINE SERIES are listed in CEILCOTE 300 FLAKELINE SERIES TECHNICAL DATA SHEET.

- .1 Other reference documents include CEILCOTE 300 FLAKELINE SERIES INSTALLATION PROCEDURES and CEILCOTE Standard Specification for steel substrate to receive monolithic linings - CPT-2.

1.4 PROJECT/SITE CONDITIONS

- .1 For all application steps, the surface temperature, air temperature and material temperature should be between 50°F (10°C) and 110°F (43°C).

Do not apply if the relative humidity is more than 90% or the surface temperature is less than 5° above the dew point of the air in the working area.

- .2 Adequate ventilation and clean water supply required during installation.

2.0 PRODUCTS

2.1 ACCEPTABLE MANUFACTURER

- .1 Master Builders, Inc., 23700 Chagrin Boulevard, Cleveland, Ohio 44122-5554, 216/831-5500 or 1-800-628-9990.
- .2 Master Builders Technologies Ltd. 3637 Weston Road, Toronto, Ontario, Canada, M9L1W1, 416-741-3830.
- .3 Tecnocreto, S.A. de C.V., Blvd. M. Avila, Camacho #80, 3er Piso, 53390 Naucalpan, Mexico Mexico 1-905-557-5544.

2.2 MATERIALS

- .1 Materials for CEILCOTE 300 Flakeline Series include:
 - CEILCOTE 370 Primer
 - CEILCOTE 300 Flakeline Series Resin and Hardener

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3.0 EXECUTION

3.1 INSPECTION

- .1 Before starting work, ensure environmental and site conditions are suitable for application and curing.
- .2 Inspect surface for acceptability.
- .3 Any and all deficiencies shall be reported in writing.

3.2 PREPARATION

- .1 For immersion service, sandblast or abrasive blast to "White Metal" in accordance with SSPC SP-5 or NACE No.1 using a clean, dry blasting media and a 3.0 mil anchor pattern. Blasted surfaces must be primed immediately after blasting

For splash & spillage applications the steel surface must be sandblasted to "Near White" in accordance with SSPC SP-10 or NACE No.3 using a clean, dry blasting media and a 3.0 mil anchor pattern.

Blasted surfaces must be primed immediately after blasting.

3.3 PROTECTION

- .1 Traffic Control - No individuals permitted in areas during application and until surface has cured, including protection after cure, against damage by others working in or over the area.
- .2 Compliance with OSHA, EPA, State and Local regulations or applicable agencies is mandatory when using these products.

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3.4 INSTALLATION/APPLICATION

- .1 Primer shall be CEILCOTE 370 Primer, Polyester steel primer and hardener. It shall be applied by brush or roller to a film thickness of 1-4 mils.

Ingredients are to be mixed thoroughly and applied to steel. Working time at 75°F (24°C) is approximately 45 minutes.

- .2 Basecoat shall be a mixture of CEILCOTE 300 Flakeline Series liquid and hardener. It shall be applied at a thickness of 11-13 mils.

Ingredients are to be mixed thoroughly and in sequence. Stir hardener into liquid. Apply immediately, working time at 75°F (24°C) is 45-60 minutes.

- .3 Topcoat shall be a mixture of CEILCOTE 300 Flakeline Series liquid and hardener. It shall be applied at a thickness of 11-13 mils.

Ingredients are to be mixed thoroughly and in sequence. Stir hardener into CEILCOTE 300 Flakeline then apply immediately, working time at 75°F (24°C) is 60 minutes.

- *** CEILCOTE 300 Flakeline Series may be applied by means of brushing, rolling or spraying. If spraying is employed use pressure pot or special catalyst pumping methods, airless spray is not recommended.

- .4 Installation Bulletin provides further details on procedures listed previously.

3.5 TESTING

- .1 During application random wet film thickness readings shall be taken. Target thickness shall be 8-10 mils DFT for both basecoat and topcoat yielding a total target thickness of 16-20 mils.
- .2 After Topcoat is hard, spark test at 2,500 volts to ensure pinhole free lining.

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(Steel)

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