



12/1/93

MASTER BUILDERS TECHNOLOGIES

2.61SS

CEILCOTE 600 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 600 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 600 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 600 FLAKELINE SERIES types including 600 and 630.

GUIDELINE SPECIFICATION

CEILCOTE 600 FLAKELINE SERIES

(Steel)

The specification information below is intended for use by architects, engineers or other specifiers in defining the criteria needed to specify these flake filled epoxy coatings.

1.0 GENERAL

1.1 SCOPE

This specification covers the surface preparation and application of CEILCOTE 600 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 or a similar system. 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 by written addendum or amendment.

CEILCOTE 600 FLAKELINE SERIES

(Steel)

1.3 APPLICABLE STANDARDS AND TEST METHODS

Physical properties and test methods for CEILCOTE 600 FLAKELINE SERIES are listed in CEILCOTE 600 FLAKELINE SERIES TECHNICAL DATA SHEET.

- .1 Other reference documents include: CEILCOTE 600 FLAKELINE SERIES INSTALLATION PROCEDURES and CEILCOTE Standard Specification for Steel Substrate to Receive Monolithic Linings - CPT-2.

1.4 PROJECT/SITE CONDITIONS

- .1 For optimum performance, 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 600 FLAKELINE Series include:
 - CEILCOTE 675 Flakeprime or CEILCOTE 680 Primer
 - CEILCOTE 600 FLAKELINE Resin and Hardener

CEILCOTE 600 FLAKELINE SERIES

(Steel)

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 Immersion or direct spillage conditions -- Steel surface must be sandblasted to "White Metal" in accordance with SSPC SP-5 or NACE No.1 using a clean, dry blasting media. Blasted surfaces must be primed immediately after blasting or within an eight hour shift.

For Splash and Spillage applications use SSPC SP-10 or NACE No.2.

- .2 Atmospheric Conditions -- Steel surface must be sandblasted to "Commercial" finish in accordance with SSPC SP-6 or NACE No.3 using a clean, dry blasting media. Blasted surface 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.

CEILCOTE 600 FLAKELINE SERIES

(Steel)

3.4 INSTALLATION/APPLICATION

- .1 Primer shall be CEILCOTE 675 Flakeprime Epoxy steel primer and hardener or CEILCOTE 680 and hardener. It shall be applied by brush, roller or spray to a film thickness of 2-3 mils.

Ingredients are to be mixed thoroughly and immediately applied to steel. Working time at 75°F (24°C) is approximately 3 hours.

- .2 Basecoat shall be a mixture of CEILCOTE 600 FLAKELINE Series liquid and hardener. It shall be applied at a thickness of 8-10 mils WFT to achieve 6-8 mils DFT.

Ingredients are to be mixed thoroughly and in sequence. Stir hardener into liquid. Apply immediately, working time at 75°F (24°C) is 2-3 hours.

- .3 Topcoat shall be a mixture of CEILCOTE 600 FLAKELINE Series liquid and hardener. It shall be applied at a thickness of 8-10 mils WFT to achieve 6-8 mils DFT (Same material as Base coat).

Ingredients are to be mixed thoroughly and in sequence. Stir hardener into CEILCOTE 600 FLAKELINE then apply immediately, working time at 73°F (23°C) is 2-3 hours.

- *** CEILCOTE 600 FLAKELINE Series may be applied by means of brushing, rolling or spraying.

- .4 Installation Procedure 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 6-8 mils for both basecoat and topcoat yielding a total target thickness of 12-16 mils. Dry film thickness shall be checked with a magnetic dry film gauge.
- .2 After Topcoat is hard, spark test at 2,500 volts to ensure pinhole free lining.
- .3 Dry film thickness can be measured by use of Dry Film Thickness Gauge.

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(Steel)

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