

PRODUCT DESCRIPTION

Ceilcote 370HT Primer is a catalysed vinyl ester primer. It provides excellent bonding and adhesion for various polyester and vinyl ester linings, coatings and flooring systems, as well as for Ceilcote Hybrid Polymer systems.

INTENDED USES

As a primer for steel substrates prior to placing polyester/vinyl ester linings, coatings or flooring systems.

As a primer for concrete substrates prior to placing polyester/vinyl ester linings, coatings or flooring systems.

PRACTICAL INFORMATION FOR CEILCOTE 370HT PRIMER

Colour	Translucent purple
Gloss Level	Not applicable
Volume Solids	100% reactive, although determined volume solids depends upon the application conditions. A recommended working figure is 75%.
Typical Thickness	25-75 microns (1-3 mils) dry equivalent to 33-100 microns (1.3-4 mils) wet
Theoretical Coverage	10 m ² /litre at 75 microns d.f.t and stated volume solids 401 sq.ft/US gallon at 3 mils d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors. Coverage will vary depending on the condition of the substrate and environmental conditions. For practical coverage rates, please refer to the Application Guidelines.

Method of Application Airless spray, Roller

Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			<i>Minimum</i>	<i>Maximum</i>
10°C (50°F)	3 hours	15 hours	5 hours	4 weeks ¹
15°C (59°F)	2.5 hours	11.5 hours	3 hours	2 weeks ¹
25°C (77°F)	60 minutes	3 hours	2 hours	2 weeks ¹
35°C (95°F)	45 minutes	2 hours	60 minutes	7 days ¹

¹ When surface temperatures exceed 35°C (95°F) or are exposed to direct sunlight, overcoating should take place as soon as the coating may be walked on, in order to avoid intercoat adhesion issues.

REGULATORY DATA

Flash Point	Part A 33°C (91°F); Part B 77°C (171°F); Mixed 32°C (90°F)	
Product Weight	1.26 kg/l (10.5 lb/gal)	
VOC	2.00 lb/gal (240 g/l)	EPA Method 24
	148 g/kg	EU Solvent Emissions Directive (Council Directive 1999/13/EC)

See Product Characteristics section for further details

SURFACE PREPARATION

All surfaces to be coated should be clean, dry and free from contamination. Prior to application, all surfaces should be assessed and treated in accordance with ISO 8504:2000. Oil or grease should be removed in accordance with SSPC-SP1 Solvent Cleaning.

Steel Substrates

For immersion service or service in humid conditions or elevated temperatures, this product should be applied to suitably primed surfaces which have been prepared by abrasive blast cleaning to Sa3 (ISO 8501-1:2007), SSPC SP5 or NACE #1. For dry environments or fume service, abrasive blast cleaning to Sa2½ (ISO 8501-1:2007), SSPC SP10 or NACE #2 will be suitable. A minimum surface profile of 75 microns (3 mils) is required.

Concrete Substrates

The CPT-1 Concrete Substrate Guide should be consulted prior to preparation.

Concrete should be well cured prior to coating. The concrete surface should be dry and pass the plastic sheet test (ASTM D4263). All surfaces should be clean, dry and free from curing compounds, release agents, trowelling compounds, surface hardeners, efflorescence, grease, oil, dirt, old coatings and loose or disintegrating concrete. All concrete surfaces must also be abrasive blast cleaned to provide a roughened surface and remove laitance. The surface tensile strength (ASTM 4541) as prepared should be at least 2MPa (300 psi) for linings (1.4MPa (200 psi) for coatings).

APPLICATION

Mixing	Material is supplied in two containers as a unit. Always mix a complete unit in the proportions supplied. Once the unit has been mixed it must be used within the working pot life specified.			
	(1)	Agitate Base (Part A) with a power agitator.		
	(2)	Combine entire contents of Initiator (Part B) with Base (Part A) and mix thoroughly with power agitator.		
	Where powders are to be used, these should be mixed with the combined Part A and Part B mixture. Do not mix more material than can be applied within the recommended pot life.			
Mix Ratio	51.2 part(s) : 1 part(s) by volume			
Working Pot Life	10°C (50°F)	15°C (59°F)	25°C (77°F)	35°C (95°F)
	40 minutes	35 minutes	30 minutes	20 minutes
Airless Spray	Recommended	Tip Range 0.63-0.89 mm (25-35 thou) Total output fluid pressure at spray tip not less than 211 kg/cm ² (3000 p.s.i.)		
Brush	Suitable - Small areas and stripe coating only			
Roller	Recommended	Use a short nap roller.		
Thinner	DO NOT THIN			
Cleaner	Ceilcote T-410 Solvent			
Work Stoppages	Once units of paint have been mixed they should not be resealed and it is advised that after prolonged stoppages work recommences with freshly mixed units.			
	Once units have been mixed, work should continue until all mixed material has been used.			
Clean Up	Clean all equipment immediately after use with T-410 Solvent. Frequency of cleaning will depend upon amount applied, temperature and elapsed time, including any delays.			
	All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.			

PRODUCT CHARACTERISTICS

The detailed Application Guidelines for the relevant Ceilcote system should always be consulted prior to use.

The Ceilcote 370HT Primer application shall be conducted by the Applicator Company using employees trained in the appropriate application procedures. It is strongly advised that both supervisory and application personnel on site shall have attended a Ceilcote Applicator Training Program.

Consult International Protective Coatings to confirm that the intended Ceilcote system is suitable for contact with the service conditions.

Exact specification for total dry film thickness and number of coats will be dependent upon service end use requirements. Consult International Protective Coatings for specific advice.

Apply in good climatic conditions. The temperature of the surface to be coated should be between 10°C (50°F) and 45°C (113°F) and at least 3°C (5°F) above the dew point. In line with good painting practice, application should not take place in conditions which are deteriorating, e.g. the temperature is falling or there is a risk of condensation forming. Ensure adequate ventilation is provided throughout application and curing. Dehumidification (DH), air conditioning and/or heating equipment may be necessary to control environmental conditions.

Where the overcoating interval is exceeded, confirm recoatability by wiping with styrene monomer. If the surface becomes 'tacky', adhesion is acceptable. If not softened by styrene, the surface must be sweep blasted or mechanically abraded to provide a non-glossy, abraded surface. Primed surface must be dry and free of foreign matter at time of lining, coating or flooring application.

Where application is by airless spray, care should be taken to avoid excessive thickness. For optimum adhesion, the materials should then be back-rolled to ensure an intimate contact with the surface.

Note: VOC values are typical and are provided for guidance purpose only. These may be subject to variation depending on factors such as differences in colour and normal manufacturing tolerances.

Low molecular weight reactive additives, which will form part of the film during normal ambient cure conditions, will also affect VOC values determined using EPA Method 24.

SYSTEMS COMPATIBILITY

Ceilcote 370HT Primer is designed to be used in combination with a number of Ceilcote primers, linings or coatings. Please consult the specification and Application Guidelines.

ADDITIONAL INFORMATION

Further information regarding industry standards, terms and abbreviations used in this data sheet can be found in the following documents available at www.international-pc.com:

- Definitions & Abbreviations
- Surface Preparation
- Paint Application
- Theoretical & Practical Coverage

Individual copies of these information sections are available upon request.

SAFETY PRECAUTIONS

This product is intended for use only by professional applicators in industrial situations. All work involving the application and use of this product should be performed in compliance with all relevant national Health, Safety and Environmental standards, regulations and legislation.

Proper ventilation must be provided during application and afterwards during curing (refer to product datasheets for typical curing times) to ensure safe limits and prevent fires and explosions. Forced extraction will be required in confined spaces. Ventilation and/or respiratory personal protective equipment (airfed hoods or appropriate cartridge masks) must be provided during application and curing. Take precautions to avoid skin and eye contact (overalls, gloves, goggles, masks, barrier cream, etc).

Before use, obtain, read and then follow the advice given on the Material Safety Data Sheets (Parts A and B if two-pack) and the Health and Safety section of the Coatings Applications Procedures for this product.

In the event that welding or flame cutting is performed on metal coated with this product, dust and fumes will be emitted which will require the use of appropriate personal protective equipment and adequate local exhaust ventilation.

The detailed safety measures are dependent on application methods and the work environment. If you do not fully understand these warnings and instructions or if you cannot strictly comply with them, do not use the product and consult International Protective Coatings.

PACK SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	15 litre	14.71 litre	20 litre	0.29 litre	0.7 litre
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT	Unit Size	Part A		Part B	
		17.65 kg		0.39 kg	
	15 litre				
STORAGE	Shelf Life	3 months minimum at 20°C (70°F). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.			

Important Note

The information in this data sheet is not intended to be exhaustive; any person using the product for any purpose other than that specifically recommended in this data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at their own risk. All advice given or statements made about the product (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing to do so, we do not accept any liability at all for the performance of the product or for (subject to the maximum extent permitted by law) any loss or damage arising out of the use of the product. We hereby disclaim any warranties or representations, express or implied, by operation of law or otherwise, including, without limitation, any implied warranty of merchantability or fitness for a particular purpose. All products supplied and technical advice given are subject to our Conditions of Sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is liable to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to check with their local International Paint representative that this data sheet is current prior to using the product.

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