

PRODUCT DESCRIPTION

Ceilmote 380 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 Ceilmote Hybrid Polymer systems.

INTENDED USES

As a primer for various Ceilmote schemes over both steel and concrete.

PRACTICAL INFORMATION FOR CEILCOTE 380 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	50-125 microns (2-5 mils) dry equivalent to 67-167 microns (2.7-6.7 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, Brush

Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
10°C (50°F)	90 minutes	5 hours	5 hours	4 weeks ¹
15°C (59°F)	60 minutes	3.5 hours	3 hours	4 weeks ¹
25°C (77°F)	45 minutes	90 minutes	2 hours	1 week ¹
35°C (95°F)	45 minutes	90 minutes	1 hour	3 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.

Minimum overcoating intervals are indicative and overcoating may take place as soon as walk-on hardness is achieved.

REGULATORY DATA

Flash Point	Part A 32°C (90°F); Part B 77°C (171°F); Mixed 32°C (90°F)		
Product Weight	1.04 kg/l (8.7 lb/gal)		
VOC	3.01 lb/gal (361 g/l)	EPA Method 24	
	229 g/kg	EU Solvent Emissions Directive (Council Directive 1999/13/EC)	

See Product Characteristics section for further details

Protective Coatings

SURFACE PREPARATION

All surfaces to be coated should be clean, dry and free from contamination. Prior to paint application, all steel 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 surfaces which have been prepared by abrasive blast cleaning to Sa3 (ISO 8501-1:2007), SSPC SP5 or NACE #1. For dry environments 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.

Ceilcote 380 Primer must be applied before oxidation of the steel occurs. If oxidation does occur the entire oxidised area should be reblasted to the standard specified above. Surface defects revealed by the blast cleaning process should be ground, filled or treated in the appropriate manner.

Concrete Substrates

Concrete should be well cured prior to priming with the appropriate primer. 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). Refer to the Concrete Surface Preparation Guidelines for more information.

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.

Do not mix more material than can be applied within the recommended pot life.

Mix Ratio

1 litre Part A : 20ml Part B (1 gallon Part A : 2½ oz Part B)

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	15 minutes

Airless Spray

Recommended

Tip Range 0.48-0.58 mm (19-23 thou)
Total output fluid pressure at spray tip not less than 70 kg/cm² (995 p.s.i.)

Brush

Suitable

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 Ceilmote system should always be consulted prior to use.

The Ceilmote 380 Primer application shall be conducted by the Applicator Company using employees trained in the appropriate application procedures. It is strongly advised that both application and application supervision is only carried out by professional personnel who have been trained in the correct use of the products.

The exact specification with regards to dry film thickness and number of coats will be provided by International Protective Coatings prior to application start up.

For concrete substrates where film integrity spark testing of lining and coating systems applied over Ceilmote 380 Primer is required, a conductive powder should be added. The type and quantity of powder per litre (and gallon) of mixed resin is as follows:

C-1 Powder 0.14kg/l (1.2lb/gal).

The powder must first be added and mixed into Part A resin prior to adding Part B.

Surface temperature must always be a minimum of 3°C (5°F) above dew point.

Ensure adequate ventilation is provided throughout application and curing.

Dehumidification (DH) air conditioning and/or heating equipment may be necessary to control environmental conditions.

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

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.

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.

Consult International Protective Coatings for temperature limits for specific end use requirements.

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**

Ceilmote 380 Primer is designed for application to correctly prepared substrates.

It is compatible with various Ceilmote coatings and linings; consult International Protective Coatings or further advice.

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
	5 US gal	5 US gal	5 US gal	12.5 fl oz	1 US pint
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT	Unit Size	Part A		Part B	
	15 litre	17.06 kg		0.39 kg	
	5 US gal	47.8 lb		1 lb	
STORAGE	Shelf Life	6 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.

This Technical Data Sheet is available on our website at www.international-marine.com or www.international-pc.com, and should be the same as this document. Should there be any discrepancies between this document and the version of the Technical Data Sheet that appears on the website, then the version on the website will take precedence.

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