

## Polyester

### PRODUCT DESCRIPTION

Ceilcote 103 Flakeline is a heavy duty, glass flake reinforced, chemical-resistant polyester lining for protection of steel against aggressive chemicals in immersion service.

### INTENDED USES

For use in aggressive environments in a wide range of industries including petrochemical, power, chemical, offshore structures and pulp and paper.

### PRACTICAL INFORMATION FOR CEILCOTE 103 FLAKELINE

<b>Colour</b>	Off White
<b>Gloss Level</b>	Not applicable
<b>Volume Solids</b>	100% reactive, although determined volume solids depends upon the application conditions. A recommended working figure is 90%.
<b>Typical Thickness</b>	875-1900 microns (35-75 mils) dry equivalent to 975-2100 microns (39-83 mils) wet
<b>Theoretical Coverage</b>	0.90 m <sup>2</sup> /litre at 1000 microns d.f.t and stated volume solids 36 sq.ft/US gallon at 40 mils d.f.t and stated volume solids
<b>Practical Coverage</b>	Allow appropriate loss factors.
<b>Method of Application</b>	Trowel, Brush, Roller

#### Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
10°C (50°F)	5 hours	24 hours	24 hours	4 weeks
15°C (59°F)	4 hours	16 hours	16 hours	4 weeks
23°C (73°F)	2 hours	5 hours	4 hours	4 weeks
30°C (86°F)	90 minutes	3 hours	3 hours	7 days

The drying times quoted have been determined at the quoted temperature and 50% relative humidity.

### REGULATORY DATA

<b>Flash Point (Typical)</b>	Part A 30°C (86°F); Part B 82°C (180°F); Mixed 30°C (86°F)	
<b>Product Weight</b>	1.27 kg/l (10.6 lb/gal)	
<b>VOC</b>	2.73 lb/gal (328 g/lit)	EPA Method 24

See Product Characteristics section for further details

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### SURFACE PREPARATION

All surfaces to be coated should be clean, dry and free from contamination. Prior to paint 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 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.

Surfaces must be primed using Ceilcote 380 Primer at 50-125 microns WFT (2-5 mils WFT).

#### Concrete Substrates

Ceilcote 103 Flakeline is not recommended for application to concrete substrates.

### APPLICATION

<b>Mixing</b>	Ceilcote 103 Flakeline must always be mixed and applied in accordance with the detailed Application Guidelines for the subsequent system. 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 Curing Agent (Part B) with Base (Part A) and mix thoroughly with power agitator.		
<b>Mix Ratio</b>	64 part (s) : 1 part (s) by volume (1 gallon Part A : 2oz Part B)			
<b>Working Pot Life</b>	10°C (50°F)	15°C (59°F)	23°C (73°F)	30°C (86°F)
	90 minutes	45 minutes	60 minutes	45 minutes
<b>Air Spray (Pressure Pot)</b>	Not recommended			
<b>Brush</b>	Suitable - small areas only	Multiple coats may be required to achieve specified film thickness.		
<b>Roller</b>	Recommended	Roller is used to smooth and orientate the glass flakes after trowel application of each coat		
<b>Trowel</b>	Recommended			
<b>Thinner</b>	DO NOT THIN			
<b>Cleaner</b>	Ceilcote T-410 Solvent (or MEK)			
<b>Work Stoppages</b>	Do not allow material to remain on equipment. Thoroughly clean all equipment with T-410 Solvent (or MEK). 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.			
<b>Clean Up</b>	Clean all equipment immediately after use with T-410 Solvent (or MEK).			
	All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.			

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### PRODUCT CHARACTERISTICS

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

The Ceilcote 103 Flakeline 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.

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).

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.

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.

Following correct installation, Ceilcote 103 Flakeline may be returned to service after the following intervals:

10°C (50°F):	48 hours
23°C (73°F):	24 hours
30°C (86°F):	16 hours

Ceilcote 103 Flakeline is not intended to be used as a cosmetic finish and colour stability will not be achievable.

Maximum continuous dry temperature resistance for Ceilcote 103 Flakeline is 121°C (250°F).

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

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Ceilcote 103 Flakeline is designed to be used in combination with a number of Ceilcote primers, linings or coatings. Please consult the specification and Application Guidelines.

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### 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](http://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 in accordance with the advice given on this sheet, the Material Safety Data Sheet and the container(s), and should not be used without reference to the Material Safety Data Sheet (MSDS) which International Protective Coatings has provided to its customers.

All work involving the application and use of this product should be performed in compliance with all relevant national, Health, Safety & Environmental standards and regulations.

In the event 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.

If in doubt regarding the suitability of use of this product, consult International Protective Coatings for further advice.

PACK SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	4 US gal	4 US gal	5 US gal	10 fl oz	1 US pint
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
		47 lb		0.8 lb	
	4 US gal				
STORAGE	Shelf Life	6 months minimum at <20°C (68°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 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](http://www.international-marine.com) or [www.international-pc.com](http://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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