

## Epoxy

### PRODUCT DESCRIPTION

Ceilcote 680 Primer is a low viscosity epoxy primer for steel and concrete.

### INTENDED USES

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

### PRACTICAL INFORMATION FOR CEILCOTE 680 PRIMER

<b>Colour</b>	Clear			
<b>Gloss Level</b>	Not applicable			
<b>Volume Solids</b>	100%			
<b>Typical Thickness</b>	50-125 microns (2-5 mils) dry equivalent to 50-125 microns (2-5 mils) wet			
<b>Theoretical Coverage</b>	13.30 m <sup>2</sup> /litre at 75 microns d.f.t and stated volume solids 535 sq.ft/US gallon at 3 mils d.f.t and stated volume solids			
<b>Practical Coverage</b>	Allow appropriate loss factors. Coverage will vary according to individual systems; consult the relevant Application Guidelines and specification for further information.			
<b>Method of Application</b>	Airspray, Roller, Brush			
<b>Drying Time</b>	Overcoating Interval with recommended topcoats			
<b>Temperature</b>	<b>Touch Dry</b>	<b>Hard Dry</b>	<i>Minimum</i>	<i>Maximum</i>
25°C (77°F)	3 hours	8.5 hours	5 hours	4 weeks
40°C (104°F)	2.5 hours	3 hours	3 hours	2 weeks

### REGULATORY DATA

<b>Flash Point (Typical)</b>	Part A 97°C (207°F); Part B 108°C (226°F); Mixed >100°C (212°F)		
<b>Product Weight</b>	1.08 kg/l (9.0 lb/gal)		
<b>VOC</b>	0.23 lb/gal (28 g/l)	EPA Method 24	
	85 g/kg	EU Solvent Emissions Directive (Council Directive 1999/13/EC)	

See Product Characteristics section for further details

## Protective Coatings

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### 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 680 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

<b>Mixing</b>	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.
	<ul style="list-style-type: none"> <li>(1) Agitate Base (Part A) with a power agitator.</li> <li>(2) Combine entire contents of Initiator (Part B) with Base (Part A) and mix thoroughly with power agitator.</li> </ul>
<b>Mix Ratio</b>	3 part(s) : 1 part(s) by volume
<b>Working Pot Life</b>	25°C (77°F)    40°C (104°F) 30 minutes    20 minutes
<b>Airless Spray</b>	Not recommended
<b>Air Spray (Conventional)</b>	Suitable
<b>Brush</b>	Recommended
<b>Roller</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 in hoses, gun or spray equipment. Thoroughly flush all equipment with T-410 Solvent. 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. It is good working practice to periodically flush out spray equipment during the course of the working day. Frequency of cleaning will depend upon amount sprayed, temperature and elapsed time, including any delays.
	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 680 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 Ceilcote 680 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** 0.16kg/l (1.3lb/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.

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

Do not apply when relative humidity exceeds 90% or when condensation is likely to occur.

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

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

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Ceilcote 680 Primer is designed for application to correctly prepared substrates.

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

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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. 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 drying (Refer to product datasheets for typical drying times) to keep solvent concentrations within 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 drying. 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
	20 litre	15 litre	20 litre	5 litre	5 litre
	4 US gal	3 US gal	5 US gal	1 US gal	1 US gal
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
	20 litre	18.41 kg		5.48 kg	
	4 US gal	32 lb		8.8 lb	
STORAGE	Shelf Life	12 months minimum at 25°C (77°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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