



PRODUCT DATA SHEET: CERAM-KOTE 99P

Description: CeRam-Kote 99P is a thin-film, spray applied, brushed or rolled on air-cured ceramic epoxy coating system recommended for use as a protective coating for residential, public and commercial pools and spas. CeRam-Kote 99P is available in a variety of colors. Fast, one coat, three pass application. No primer needed.

Advantages:

- Good cure at 50°F (10°C)
- Zero induction time at ambient temperature
- Good glossy finish
- Not affected by humidity during application
- Non-critical curing agent ratio
- Excellent flexibility
- Excellent water spotting resistance

Suggested Uses: Recreational and commercial pools and spas

TECHNICAL DATA

Volume Solids (catalyzed): 70% +/- 2%

VOC: 1.86 lb/gal (221 g/liter) less water

Number of Coats: One Coat, three passes (each pass 4½ - 6 mils WFT, 112½ - 150 microns)

Dry Film Thickness: CeRam-Kote 99P should be applied at a minimum of 10 mils (250 microns) with a maximum thickness of 15 mils (375 microns) DFT.

Cure Time: A three-pass film of 10-15 mils DFT (250 - 375 microns) air dries to a touch-dry finish within eight (8) hours at 77°F (25°C) and dries to a 70% cure in seventeen (17) hours. Cure times lengthen at lower temperatures and shorten at higher temperatures. Coating should be fully cured before placing into service.

Surface Preparation: Bonding strength depends on proper preparation of the surface to be protected for long-term performance of the product. The substrate should be free of oil, grease and salt/chloride contamination. Specifications call for a white metal (NACE 1, SSPC-SP5, Swedish Standards SA-3) cleanliness with a 2.0-2.5 mil (50-62.5 microns) anchor profile. Surface preparation should be no less than a near white (NACE 2, SSPC-SP10, Swedish Standards SA 2½) finish. Cleanliness is the most important step to produce a surface that will perform and last. Call CERAM-KOTE COATINGS, INCORPORATED for surface preparation recommendations of materials such as aluminum, brass, plastic, fiberglass, plaster and/or concrete.

Mixing Ratio: Weight ratio = 3.0 parts A to 1.0 Part B: Volume ratio = 2.3 parts A to 1.0 Part B

Mixing: CeRam-Kote 99P contains a high loading of ceramic particles which must be placed into full suspension within the epoxy resin prior to application. CeRam-Kote 99P is packaged in two cans, Part A (resin and ceramics) and Part B (curing agent). Shake Part A (base) with a Cyclone air-powered shaker or mix Part A with a paddle mixer until all ceramic particles are suspended in the resin. Time required to place ceramics into suspension varies according to temperature and length of material storage time. At 72°F (22.2°C), generally a four (4) to six (6) minute shake will place the ceramic particles into suspension. **Regardless of time needed, shake all ceramic material into suspension prior to proceeding.** Failure to properly mix will keep CeRam-Kote 99P from performing or curing properly. Check the can to assure all solids are in suspension prior to proceeding to the mixing step.

Combine Part A (base) and Part B (curing agent) and *stir* with a paint stick or paddle mixer until both parts are thoroughly mixed. Shaking can cause excessive heat to build up, thus causing curing problems. Stirring time is temperature dependent, but it should take only three (3) to four (4) minutes to thoroughly mix the components. No induction time is needed before application.

Pot Life & Shelf Life: Pot life for CeRam-Kote 99P at 72°F (22.2°C) is one (1) hour. Colder temperatures will increase the pot life and warmer temperatures will decrease the pot life. Keep cans out of direct sunlight to prevent heat buildup. CeRam-Kote 99P has an indefinite shelf life. Preferred storage/usage is a dry enclosed area under 85°F (29°C) /used within two (2) years. However, if stored more than two years above 85°F (29°C), call CERAM-KOTE COATINGS' Technical Support prior to use.

- Thinning:** Adjust viscosity with small amounts of CeRam-Kote Thinner 1 (MEK) or CeRam-Kote Thinner 3 (Acetone) only. Use caution when adjusting the viscosity. A little goes a long way. Only a small portion of the total solution is epoxy resin and the resin is the only ingredient that can be thinned. Thinning dilutes the high solids of CeRam-Kote 99P, creates excessive overspray and can cause some color changes in bright colors.
- Application:** Spray apply for best results using conventional, airless, HVLP or cup gun. **The air source must be dry.** The compressed air source should be outfitted with air dryers as needed to supply moisture-free air. No special spray equipment is needed. Normal spray equipment may be used. Airless: use reversible carbide tip with orifice size of 0.025-0.027 inches. If applying with roller, use short nap, such as 1/4" (.244 mm).
- After thoroughly mixing CeRam-Kote 99P, strain it with a standard paint strainer and pour CeRam-Kote 99P into the spray equipment.
- Apply a first pass of four and one-half (4½) to six (6) mils (112½ – 150 microns) WFT and allow sufficient time for solvent to flash off. At 72°F (22.2°C), 30-40 minutes is sufficient. Apply a second and third pass of four and one-half (4½) to seven (7) mils (112½ - 250 microns) for a total DFT of ten (10) to fifteen (15) mils (250 – 375 microns). Cure time is temperature dependent.
- Apply additional mils without incurring runs or sags if the finished product requires thicker coverage per manufacturer's instructions. Whenever possible, apply second and third coats using a cross-coat method.
- Climate:** Use CeRam-Kote 99P only if the substrate temperature and ambient air temperature is above 50°F (10°C).
- Holiday Detection:** Only if applied to steel: CeRam-Kote 99P is classified as a thin-film coating and should be tested for defects and holidays using a 67½ volt, wet sponge spark detector set at 80,000 ohms resistance, such as a Tinker and Razor model M-1.
- Repairs:** If application of the coating is less than seventy-two (72) hours old and has not been exposed to contamination, clean any loose contamination by pressure washing with at least 2,500 psi pressure washer. Let dry, then re-apply CeRam-Kote 99P. If contaminated or more than 72 hours old, first sand with appropriate grit sandpaper, then repeat repair process.
- Cleanup:** Purge and clean spray equipment within thirty (30) minutes of the final spray. Flush equipment with CeRam-Kote Thinner 1 or CeRam-Kote Thinner 3 until solvent sprays clear. Disassemble and clean equipment to manufacturer's recommendations. Material left in spray equipment will solidify and damage equipment. Use precautionary measure applicable to any catalyzed material.
- Safety:** See individual product label for safety and health data. A Material Safety Data Sheet is available upon request.

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