



6650 Coating System

Product Data Sheet

DESCRIPTION:

6650 CS is a two-component, high performance, vinyl ester coating system. It is designed for walls, ceilings, columns, and other surfaces subjected to immersion, spills or fumes. 6650 CS is a high film build system with excellent adhesion to concrete or steel.

ADVANTAGES:

- Excellent Chemical Resistance
- Temperature Resistant
- High Film Build
- Low Permeability
- Quick Cure, Low Down Time

USES:

- Walls, Ceilings, and Columns
- Interior and Exterior of Tanks
- Curbs and Pump Pads
- Equipment Coating
- Structural Steel

SUPPLEMENTAL PRODUCTS:

- Epofil Masonry Filler (2 Day cure required, and seal with Ultraprime)
- ULTRAPRIME – Penetrating Moisture Cure Primer
- 6000 FS - Flooring Systems
- 5500 Grout – Pitching And Filling
- 6600 LS - Lining System – Trenches And Sumps

PACKAGING AND COVERAGE:

6650 CS – 1 gallon kit – covers approximately 100 square feet at 15 mils, and consists of the following –
 1 container – Part A (pigmented resin)
 1 container – Part B (catalyst)

6650 CS - 5 gallon kit – covers approximately 500 square feet at 15 mils, and consists of the following –
 1 container – Part A (pigmented resin)
 1 container – Part B (catalyst)

Recommended Film Thickness:

- Fume exposure – 24-30 mils. Applied in two coats.
- Spills/Immersion – 32-40 mils. Applied in three coats.

PROPERTIES:

Compressive Strength (ASTM C-579) <resin>:	16,000 psi	Shelf Life:	60 days
Tensile Strength (ASTM C-307) <resin>:	13,300 psi	Colors:	Gray, White, Red
Bond Strength (on steel):	3500 psi	Solids by Content-Theoretical:	By Weight: 99% By Volume: 98.5%
Impact Strength:	100 in./lbs.	Indentation (MIL-D-3134F):	No indentation
Abrasion Resistance (ASTM D-1044):	68 milligrams	Max Temperatures:	Wet Exposure: 190°F Dry Heat: 300°F

SURFACE PREPARATION:

6650 CS may be installed only on clean, sound surfaces. Concrete:

New concrete must be cured a minimum of 28 days. All coatings, oils, grease and unsound concrete substrate must be removed. Concrete surfaces must then be acid etched, scarified or blasted to remove surface laitance. A good bonding tooth, the texture of 60 grit sandpaper, is desired for adhesion, with the removal of all surface glaze.

For Metal Surfaces:

Blast the surface to near white SSPC-SP10-70 or NACE No. 2 using a Venturi blast nozzle with 100 psi air. To produce the proper 4 mil anchor profile, the blast media should be properly graded, clean, sharp, and angular similar to Humble Abrasive Flint #7 (6-30) mesh, or Steel Grit (HG25).

MIXING:

Prior to starting, materials should be stored at 70°F (21°C) for at least 48 hours.

ULTRAPRIME (optional - concrete surfaces only) - single component product, so it can be applied directly from the can without mixing.

6650 CS - Empty 1/2 of the material into a clean container. Mix remainder to disperse coloring. Pour back material from other container. Add catalyst 2 oz/gallon at 60°F (10°C), 1.5 oz/gallon at 75°F (24°C), 1 oz/gallon at 90°F

(32°C) and mix for 2 minutes. Pot-life is approximately 15-20 minutes.

APPLICATION:

Substrate temperatures should be at 65°-85°F (18°-29°C) during application and for 96 hours for complete cure. Do not apply if surface temperature is below 60°F (16°C). On concrete surfaces, first apply PROTECTIVE ULTRAPRIME Penetrating Moisture Cure Primer. 6650 CS Coating can be applied by spray, roller, or brush. Recoat time is: 12 hours at 60°F (10°C), 6 hours at 75°F (24°C), 3 hours at 90°F (32°C). If basecoat is left for more than 48 hours, the surface must be wiped down with MEK or acetone before top coating.

CURE TIME:

6650 CS will harden in 6 hours and cure for spill exposure within 96 hours at 75°F (24°C). For chemical immersion applications - 7 days cure at 75°F (24°C). Cure can be accelerated by introducing heat to tank. Do not heat over 120°F (49°C), and only increase at a rate of 20°F (-7°C) per hour. Caution: 6650 CS is flammable.

CLEANUP:

Cured or hardened 6650 CS will bond to practically all surfaces, and is extremely difficult to remove. Clean all tools and mixer immediately after use with acetone or other solvent based cleaners.

SAFETY:

Avoid skin contact. If eye contact occurs, flush with water and consult a physician immediately. Keep work areas well ventilated. Never seal a container of mixed Part A and B as the continuing exothermic reaction may cause container to explode. 6650 CS is manufactured using a styrene monomer, which will give off an odor during application. Customer is responsible for protecting employees and food

products from these odors. Cured product poses no threat of odor contamination. 6650 CS Material Safety Data Sheets are available upon request.

Limited Warranty

Milamar Coatings products are manufactured to be free of defects in material and workmanship in meeting the properties specified on its individual Product Data Sheets. Users and installers of Milamar Coatings products are solely responsible for determining the suitability of the products for specific product applications. Milamar Coatings makes no Warranty or Guarantee, express or implied, including warranties of fitness, design compatibility or merchantability, for any particular use and shall have no responsibility or liability, including direct, indirect or consequential damages, due to injury, delay or third party claims for installation or repair. Likewise, Milamar Coatings assumes no liability of any nature for products that are adjusted in the field or that do not utilize all specified Milamar Coatings components. Should any Milamar Coatings product be proved to be defective within one year from the date of shipment, Milamar Coatings will, at its sole discretion, replace the material; issue a credit to the customer's account; or provide a cash refund for the initial, paid purchase price of the material. Potential claims regarding product quality must be received in writing by Milamar Coatings within 30 days of the discovery of such potential defect. This Warranty is exclusive of all other warranties, expressed or implied, and may only be adjusted in writing, signed by an officer of Milamar Coatings, L.L.C.

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