

Albi Clad 800

FIREPROOFING APPLICATION MANUAL & FIELD GUIDE



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INTRODUCTION

Throughout the years, Albi has earned an enviable reputation for its dependable, high quality fireproofing systems. Providing maximum protection with minimum thickness, Albi mastic fireproofing has demonstrated a unique ability to withstand abuse, impact, vibration and adverse environmental conditions, while still continuing its outstanding performance record.

This manual has been prepared to provide you with basic information pertinent to the properties and application methods of Albi Clad 800. Further, equipment recommendations and application suggestions are included to assist you and your job superintendent in proper job preparation and professional execution of work. The objective of this manual is to explain in detail the necessary components and methods to provide the required fire protection as specified by the owner or architect.

In addition, the manual highlights the responsibilities of a qualified, licensed Albi applicator in providing the customer with the basic fire protection needed for safeguarding human life and property.

It is your responsibility, as a competent and reputable applicator, to apply the product in accordance with Albi tests and in compliance with our recommendations. It is important that you have full knowledge of our product and its application methods in order to maintain our record of proven performance and consistent customer satisfaction. We urge your studied review of the information contained in this manual and the transmission of this same information to all personnel who will be involved in the application of Albi Clad 800.

As additional information is developed, it will be forwarded to you for insertion in this manual. Should you desire additional copies, or should there be questions requiring clarification, please contact our home office or your local representative.

ALBI PRODUCT DESCRIPTION

ALBI CLAD 800

Albi Clad 800 is a proprietary formulation consisting of heavy-bodied vinyl based resins, binders, intumescent agents and reinforcing inorganic fibers. It is factory formulated for maximum quality control, and is shipped in 55 gallon (U.S.) drums or 5 gallon (U.S.) pails. Albi Clad 800 is applied directly from the shipping containers, requiring no special additives or field mixing procedures other than initial mechanical agitation to uniformly suspend the material in the drum. Albi Clad 800 CONTAINS NO ASBESTOS, and is available in both spray and trowel grades to suit the desired end use requirements. Albi Clad 800 meets the fire test criteria of ASTM E84, ASTM E119, BS 476, U.L. 1709, and other high intensity hydrocarbon fires including.

Formulated for interior or exterior application wherever fireproofing material is to be left exposed. Use where a hard, smooth-surfaced, thin coating is required and/or where heavy service abuse is anticipated. Designed to have superior weathering and aging characteristics, Albi Clad 800 is recommended for exterior application where the finish coating will be exposed to exterior weather environment or corrosive fume atmosphere.

Observe standard red label precautions when using Albi Clad 800. This product contains solvent mixtures and must be protected from open flame. Adequate ventilation must be provided to prevent buildup of vapor concentrations in confined locations. Albi Clad 800 mastic should not be applied inside buildings, which are occupied during the time of application.

ALBI 487S PRIMER

Since Albi Clad 800 is not formulated to function as a surface sealer or moisture barrier, a compatible primer is required as protection against corrosion of steel substrates, typical standard coatings practice. Albi 487S is a phenolic modified alkyd primer recommended for use with Albi Clad 800 under most conditions. Albi 487S should be allowed to cure for at least 48 hours prior to application of Albi Clad 800. For complete product description refer to the Albi 487S product data sheet.

ALBI POLYURETHANE TOPCOAT

A flexible aliphatic polyurethane recommended for use over Albi Clad 800 in unusually severe exposure areas. For interior or exterior applications. For complete product description refer to the Albi Polyurethane Topcoat product data sheet. NOTE: Be sure that Albi Clad 800 is completely cured prior to application of a topcoat.

ALBI CLAD SOLVENT

Albi Clad Solvent is a special blend of solvents for equipment and general cleanup. We recommend that one drum of Albi Clad Solvent be purchased for every 50 drums of material used. This solvent is a red label material requiring proper storage and handling safety precautions.

FIBERGLASS RIBBON

Fiberglass ribbon is used for exposed flange edge protection as required for specific U.L. listings. This fiberglass ribbon comes in 150 foot rolls, 5-1/2 " and 12 "wide 20 X 20 mesh with a .004" fabric thickness, weighing 1.6 oz. per square yard. Other widths are also available.

EQUIPMENT RECOMMENDATIONS

Because Albi Clad 800 is heavy-bodied mastic, we recommend spray application with a heavy-duty pneumatic operated positive action pump. A power ratio of at least 10 to 1 is recommended. These pumps are air operated, requiring no electrical source, and are manufactured and distributed by leading pump manufacturers including:

Brand / Model

Graco 205-628 President 10:1
206-281 Bulldog
207-567 King
Binks 41-6820 Saturn 6E

Adequate air in sufficient volume and pressure is required for the activation of the pump and for the air atomization of the mastic at the spray gun nozzle. For each pump utilized, an air compressor or plant air supply must be available and capable of providing at least 80 CFM at 100 PSI at the pump. Of utmost importance is the proper use of an effectively functioning oil-water filter or moisture trap. Such a trap or filter should be installed at the pump and one at the compressor. Refer to page 12 for more detailed information.

The spray gun must be a unit designed for use with heavy-duty mastics such as the Binks 7E2 gun with 45 X 1/4" tip. The gun must have a minimum 3/4" material inlet and 3/8" air inlet ports. Experience has proven that the Binks 7E2 atomizes the mastic more productively and uniformly due to a circumferential air port design. A 5/16" round or 3/8" slotted tip is recommended. The round nozzle generally provides greater production rates whereas the slotted nozzle provides a more controllable spray pattern.

Suitable pressure rated air line from the compressor or plant air outlet to the pump should be a minimum of 3/4" i.d. The air line from the pump to the gun should be a minimum of 3/8" i.d. The following air hose specification is recommended: 50 ft. Binks Manufacturing Part # 71-1306 (or equivalent).

The material line from the pump to the spray gun should be a minimum 3/4" i.d. hose suitably lined with a solvent resistant material, which will provide longer service life. The following nylon reinforced material hose is recommended: 3/4" nylon lined hose, manufactured by Binks Manufacturing Company and identified as 50 ft. of # 72-284W hose with # 72-417 connectors. The complete material hose and connector assembly is designated Fluidall (Nyall) Binks Part # 71-3344 (or equivalent). For applications requiring material hose greater than 50 ft. in length, contact Albi for specific recommendations.

Those not familiar with heavy-duty pneumatic spray rigs should contact the nearest equipment manufacturer or service office to obtain basic information and training in the operation and care of the equipment. Never begin a job without first making a test application to familiarize yourself with the proper air pump pressures and techniques required.

SPARE PARTS AND ACCESSORIES

To reduce additional job application start-up or down time expenses due to equipment failure, the following spare parts and accessories are recommended:

1. Sufficient tools in the form of long handled screwdrivers, wrenches, hose clamps, etc. to allow for quick maintenance checks and repairs in the field.
2. Adequate supply of leather or Thiokol impregnated leather packings, as recommended by the pump manufacturer. Teflon packings should not be used.
3. Extra 50 ft. section of material hose
4. Sufficient supply of empty 5 gallon pails to allow for cleaning of pump and material hose with solvent flushing.
5. A recommended spare parts kit as published by the pump manufacturer.
6. Spare material and air hose connectors (including swivel end connectors).

PRIMER AND TOPCOAT APPLICATION

Where a primer and a topcoat are required, use conventional spray equipment (air or airless). Because the primer and weather resistant coatings are in the paint family, they cannot be effectively pumped through the above described heavy-duty mastic pump equipment. For further product and application recommendations on these coatings, refer to their respective Albi product data sheets.

MISCELLANEOUS EQUIPMENT

The following items are recommended for use or storage on the job for optimum job production:

1. During cold weather applications, heated storage (50 degrees F) of Albi Clad 800 is recommended. Even though the solvent-based Albi products can be applied at below freezing temperatures, preconditioned heating of the Albi Clad 800 assures proper material viscosity for efficient pump operation. Refer to page 12 for details.
2. Drum heaters and hose heating tapes, for maintenance of material temperature and viscosity during cold weather application.
3. Sufficient masking paper and tape as well as non-absorbent masking cloths to prevent or minimize overspray or solvent attack on finished surfaces or equipment due to spills.
4. Movable scaffolding as required.
5. Barrel or drum handling equipment to facilitate moving of Albi Clad 800. (A 55-gallon drum of Albi Clad 800 weighs approximately 600 pounds).
6. Adequate supply of face shields, breathing masks or fresh air hoods where

needed.

7. Proper fire extinguishing equipment and "No Smoking" signs to protect the area in accordance with required safety precautions. A carbon dioxide type extinguisher (25 pound capacity) is recommended.
8. Thickness measuring gauges to assure adequate wet film thickness.
9. Fiberglass ribbon or wire mesh and furring clips (as required for specific applications).
10. Supply of short nap paint rollers and Albi Clad Solvent for required rolling of sprayed material and clean up.
11. Trowel and protective glove for patch up work, and for trowelling or palming material in areas difficult to reach with spray application equipment.
12. Grounding cables, for use to ground material containers and/or equipment to eliminate the hazard of sparks generated by static electricity.
13. Mechanical mixing of Albi Clad 800 is recommended to assure uniformity of blended ingredients and proper material viscosity. For best results, use of an air operated motor or explosion proof electric mixer is recommended. If this equipment is not available, roll closed Albi drum back and forth on the ground. Stand drum upright and uniformly mix with wood paddle or hoe until there is no settled material remaining on the bottom of the drum.
14. To properly blend old, heavily settled Albi Clad 800 material, the following procedure is suggested. Remove liquid material from top of container and place in empty drum. Gradually remove the settled material from old container and place in drum with previously removed liquid material. Agitate this material continuously until all of the material has been reworked into the other drum. Do not add solvents as this generally will result in too soupy a mixture.

SURFACE PREPARATION

The surface to receive Albi Clad 800 must be properly prepared in accordance with good painting practice. The surface must also be clean of all residual oil, moisture, dust, frost or other contaminants that may have formed. When in doubt, soak rags in Albi Clad Solvent or trisodium phosphate (TSP) solution and thoroughly wipe down all surfaces to be coated. As the solvent evaporates, make certain any frost, moisture or oil deposits have been removed. In areas where spot rusting has occurred, be sure all loose rust, scale, etc. is removed. Spot prime all bare steel areas with a compatible primer.

PRIMERS

To provide proper protection against corrosion, all steel must be primed with a proven compatible primer. If Albi 487S is used as the primer, allow at least 48 hours for

thorough drying and curing before applying the Albi Clad 800.

Before commencing work it is vitally important to determine the compatibility of Albi Clad 800 with the primers. Due to aromatic solvents used with the mastics, Albi Clad 800 applied to non compatible surfaces will have a softening, or in some cases, a total paint removal effect on the primed surfaces. Albi Clad 800 has shown suitable compatibility with the following type of high quality, properly cured primers:

1. Albi 487S -- phenolic modified alkyd primer.
2. Most modified alkyd red oxide or zinc chromate primers that have been dried and well cured for at least three months prior to Albi Clad 800 application.
3. Most two component epoxy primers (low gloss).
4. Most inorganic zinc primers.
5. Galvanized surfaces which are free of oil and salts and which have been weather oxidized for at least 4 months. For application to new galvanized surfaces having less than 4 months weathering, wash thoroughly with acetic acid or zinc phosphate solution.
6. Aluminum surfaces must be primed with a vinyl-wash primer. Be sure to follow the surface preparation and application procedures as recommended by the coating manufacturer.

PROCEDURES TO DETERMINE COMPATIBILITY OF EXISTING PRIMED SURFACES

To be fully assured that the primed surface will be compatible, proceed as follows:

1. For a quick check of substrate compatibility, soak a cloth or rag with lacquer thinner or methyl ethyl ketone (MEK) type solvent. Place soaked cloth or rag against primer surface making sure that primer is thoroughly soaked down with solvent. To prevent rapid evaporation of solvent, cover cloth or rag with plastic. If primer is lifted from steel, or crinkles, bubbles, or sags, you can be sure that the primer is non-compatible. Where primer is softened, but not affected as detailed above, proceed to Steps 2 and 3 as outlined below.
2. To the questionable surface, apply by hand or trowel a 1/4" thick patch of Albi Clad 800 at least 1 sq. ft. in area. It must be applied in sufficient thickness to meet the specified fire rating. Allow the patch to thoroughly dry, 10 to 21 days, or until patch is uniformly dry and cured throughout. Endeavor to remove the patch of Albi Clad 800 by knife or chisel. If the Albi Clad 800 pops off easily revealing deterioration of the primer by crinkling, blistering, removal, etc., then that primer is incompatible.
3. Reapply Albi Clad 800 to another section of the questionable primer surface. This time spray apply a mist or scratch coat. Allow this scratch coat to set up thoroughly. If bonding appears evident, proceed to build up

to required thickness by spray application. After this application is thoroughly cured, examine as outlined above.

Incompatible primer must be removed by acceptable techniques and subsequently primed with Albi 487S or an equal. One technique recommended is commercial blast cleaning as outlined in the Steel Structure Painting Council (SSPC), Special Procedure 6-63.

APPLICATION

1. Stand pump in 5-gallon container filled with solvent
2. Connect air line from pump to gun.
3. Reduce air adjustment controls (material pump pressure and air pressure at pump).
4. Start compressor. Direct the free end of the material hose into solvent container.
5. Adjust atomization air pressure control with gun trigger pulled until air feeds through the gun.
6. Adjust pump pressure control until the pump starts and the solvent feeds through the hose.
7. Reduce pressure controls. Remove pump from solvent container and place into Albi Clad 800 drum, making sure that the pump is rigidly supported and that the dump valve is aimed into the container.

Remove material hose from pump. Turn on pressure controls to activate pump when trigger of gun is depressed. Make sure that material outlet of pump is directed back into Albi Clad 800 container. Increase material pressure at pump until satisfactory material flow is obtained. This assures that the pump is functioning properly. Connect material line to pump. Direct free end of material hose into Albi Clad 800 container. Activate pump by depressing trigger on gun. Increase material pressure at pump until adequate material flow through open end of material hose is obtained, to insure that material hose is clean and usable for job production spraying. If adequate material flow cannot be obtained through the open end of the material hose, it can be assumed that the material hose is clogged, or otherwise deficient, and should be replaced.

Connect material line to gun. Adjust air pressure and pump pressure to achieve proper feed rate and atomization of Albi Clad 800. A suggested guide would be to initially set the air pressure at about 45 pounds per square inch and the pump pressure at about 60 pounds. Make adjustments from that benchmark. If the spray is too coarse, this indicates the material is not atomizing properly and the air pressure must be increased. If the spray is too fine, increase material pump pressure to feed more material to the gun. Adjust air pressures and material flow rates to suit job conditions, substrates, etc.

EQUIPMENT OPERATION HINTS

If the pump fails to operate correctly, check the following points:

1. Check pressure gauges to make sure they are operable.
2. Check air pressure to be sure adequate supply is going to the pump.
3. Check material level in Albi Clad 800 drum to be sure sufficient material is covering the inlet material orifice and no cavitation is occurring.
4. Check lower pump inlet for possible malfunction such as:
 - a. Foreign matter lodged in check valves.
 - b. Worn or defective packings.
5. Check for inoperative air motor.
6. Check surge control unit for proper adjustment.
7. It is important that all personnel involved in the use of the equipment be familiar with its operation and understand the manufacturer's recommendations for trouble shooting.
8. Check pump for freeze up. Icing of pump will reduce orifice size of exhaust manifold, causing pump to slow down or completely stop.

SPRAY APPLICATION PROCEDURE

Hold the spray gun 6" to 12" from the surface. Maintain a steady pull on the trigger. Do not stop and start any more frequently than necessary. With steady uninterrupted flow of material, move along surface to be sprayed at sufficient speed to avoid heavy film build-up and possible sag. A comfortable rate would be to apply an average thickness of 1/16" at a time working back to the surface for supplemental coats within about a 5 to 10 min. lag.

Proper distance and angle position of gun from surface will also minimize overspray. Obviously, anticipate a greater overspray or blow-by when Albi Clad 800 is applied to small (less than 8") or difficult to reach steel members. Use of a back-up shield can reduce overspray loss since the material deposited on the shield can then be redeposited in Albi Clad 800 containers.

As a general guide, wet film thickness coatings up to 1/4" can be built up in one day through multiple passes. Thickness applied during each pass will depend upon weather conditions and skill of the applicator.

It is important to recognize, as pointed out above, that this 1/4" total thickness application would be accomplished in multiple passes, each pass depositing a 1/16" - 1/8" film thickness and allowing sufficient time lapse between passes to achieve skin drying. Application beyond that 1/4" total thickness in one day will increase the hazard of material sagging.

Where application calls for Albi Clad 800 thickness greater than 1/4", overnight drying of initial applied coating is required.

After application and before surface has hardened (generally with 15 minutes), all surfaces shall be smoothed down by rolling with a smooth or short nap roller applying light pressure to the surface. Such procedure is required in order to eliminate uneven application or unsightly drippings. The roller should be kept damp with Albi Clad Solvent to avoid picking up sprayed material from surface.

Thickness measurements should be taken at frequent intervals during application, using a probe-measuring device. In accordance with UL test procedures, average thicknesses are taken during the "wet film" stage, i.e. within an hour after application. Therefore, such listings by UL in conformance with specific hourly ratings are based upon wet film thickness. Albi Clad 800 dries, the material shrinks, affecting the film thickness. Most of this shrinkage occurs in the first 24 hours.

DOWN TIME AND CLEAN UP

When stopping work for a break or overnight, immerse the tip of the gun in Albi Clad Solvent and cover the open drum to prevent the material from hardening. This will permit quick resumption of work without the need to clean the equipment.

If proper solvent resistant material hoses and wettable parts are used, cleaning the inside of the pump and hoses is only necessary when down time exceeds 2 days.

When stopping work for 2 days or longer, as well as when the job is completed, place pump equipment in a container of Albi Clad Solvent. Clean pump stem of residual Albi Clad 800 material with old brush or rag. Activate pump in order to cycle solvent, directing the material hose back into the solvent can. When the pump and material hose are thoroughly clean, disconnect the material line and remove the gun for hand cleaning.

Remove pump from immersion in solvent container and activate the pump to blow out all the residual solvent in the material line.

IMPORTANT APPLICATION PROCEDURES

1. **Cold Weather Application.** Because Albi Clad 800 is solvent-based, it can be applied, if necessary, under low temperature weather conditions. However, the following important points should be noted:
 - a. It is imperative that the steel to which the material is being applied is free of frost film or ice, which prevent proper adhesion.
 - b. When spraying Albi Clad 800 at below freezing temperatures, the material in the drum shall be warmed to at least 50_i F temperature. This is most readily accomplished by housing the containers in a heated storage area. Allowing material to drop below 50_i F increases the viscosity, which can cause cavitation of the pump. Such cavitation will cause erratic material feed and adversely affect production rates.

When the drums are removed from the heated storage area, and exposed to the low temperature field application conditions, we recommend that the drum be encased with a drum heater and the material lines be protected with heating tape so that the proper

viscosity is maintained during the spraying operation. To prevent rapid cooling of Albi Clad 800 in the material hose, insulate over the heater tape on the material hose.

2. **Humid Application Conditions.** When applying Albi Clad 800 in areas under high humidity conditions, it is important to note the following:
 - a. Surfaces to be coated must be free from all residual moisture. Albi Clad 800 should not be applied whenever the substrate surface temperature is less than 5 degrees F above the dew point of the surrounding air.
 - b. Following good painting practice, Albi Clad 800 should not be applied when the relative humidity exceeds 85%.
 - c. The use and maintenance of properly functioning oil and water filters are specifically required on all jobs. These filters should be positioned at the air compressor and at the mastic pump. Regular maintenance checks should be made daily to assure proper functioning of oil and water traps.
 - d. Cool temperatures combined with high humidity can cause the pump air motor to freeze up. To prevent this, use an alcohol or antifreeze mist injection as available from pump manufacturers. Be sure to inject the alcohol or antifreeze into the air motor only.

3. **Hot Weather Conditions.** When applying Albi Clad 800 with high temperatures, coats must be thick enough to allow the solvent to remain on the steel long enough to obtain proper adhesion. High temperature environments accelerate solvent evaporation. The following important points should be noted:
 - a. The temperature of the steel substrate should not be higher than 140 degrees F (60 degrees C).
 - b. Material should be stored out of direct sunlight at less than 140 degrees F (60 degrees C). We recommend storing drums in the open in shaded areas, since containers can act like ovens.

4. **Albi Clad 800 Finished Appearance.** While Albi Clad 800 serves as a functional fireproofing material, it can and should be applied to provide a neat acceptable finished appearance. Careless and sloppy workmanship always results in costly additional work and customer dissatisfaction. An Albi Clad 800 coating applied in uniform thickness, free from globs, sags, and craters can only result in greater acceptance and use of Albi products in the future; since a satisfied customer is a repeat customer.

- a. The final appearance of the Albi Clad 800 installation is directly dependent on the initial and subsequent spray coats. Build up the thickness slowly and uniformly through the use of successive passes. Building up the thickness too rapidly causes sagging and sliding. Once this occurs it cannot be corrected.
 - b. The required finish appearance of Albi Clad 800 is easily and quickly achieved by light rolling with a smooth roller immediately after spraying. Keep the roller moist with solvent to avoid "picking up" the applied material.
 - c. Where Albi Clad 800 has dried hard, leaving globs or other unsightly areas, a surform or grinder can be used to correct or even out these areas.
- 5. **Small Jobs or Patch Areas.** For very small jobs, not justifying the use of heavy-duty pump equipment, application of Albi Clad 800 can be made as follows:
 - a. Albi Clad 800 may be applied by trowel or palming method. Material is applied by a Teflon coated trowel or a steel trowel thoroughly wetted with Albi Clad Solvent. Do not work the Albi Clad 800 too much, as it will tend to dislodge itself from the surface to which it is being applied.
 - b. To fill cracks or voids, stuff opening with sections rock wool or similar material then cover over while applying Albi Clad 800 to adjacent areas.
 - c. To repair damaged areas, first remove any loose particles. Then apply Albi Clad 800 with putty knife.

EQUIPMENT TROUBLE TIPS

1. If gun spurts at start of work, adjust surge control on pump to relieve build-up of internal pressure.
2. If material flow does not stop cleanly when trigger is released, clean interior mechanism of gun to be sure stop valve is properly seated.
3. If material flow is inadequate, check for kinked or otherwise obstructed material hose.
4. If material spray pattern is not complete, be sure air holes in nozzle are clear. Also check air supply and pressure.
5. If material fails to feed through line while pump is working, be sure entry port at bottom of pump is clear. If material supply is inadequate, check air supply to the pump and adjust accordingly. Also, check for partial stoppage in the material line or at the gun.
6. If material feed rate is inadequate, check for partially clogged material line. Under prolonged usage material hoses are known to swell and

sometimes to clog due to the ultimate friction wear of the mastic flow. Check for clogged material line, slow down, or stoppage by removing the material line from the pump. Then start the pump. If material feeds through the pump at the proper rate, it is reasonable to assume that the hose is partially blocked or clogged.

7. Check for build-up of material behind piston, nozzle or external cap of gun, causing stoppage of material flow. Also, check trigger adjustment of gun.

WARRANTY/GUARANTEE INFORMATION

Limited warranty/limitation of liability: Information and recommendations provided by Albi are based upon extensive test data, laboratory experiments and years of field experience believed to be reliable. Statements made herein as to coverage, drying performance, application, and other properties will vary according to the nature and conditions of the surfaces to which the product is applied.

Albi warrants that its products will meet the specifications, which it sets for them. Albi's responsibility under this warranty will be limited solely to replacing the products which prove defective, provided that Buyer gives Albi prompt notice in writing of said defect and satisfactory proof thereof. Products may be returned to Albi only after written authorization has been obtained from Albi. The foregoing warranty is in lieu of all other warranties, whether oral, written, express, implied or statutory. **IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE WILL NOT APPLY.** Technical or other advice is furnished by us solely as an accommodation and shall not increase the scope of our responsibilities or liability. Albi's warranty obligations and Buyer's remedies hereunder are solely as stated herein: In no event will Albi be liable either for the labor and other associated costs incurred in replacing the product, including, but not limited to, its removal and application, or for other incidental or consequential damages.

Applicator shall guarantee that its installation of material conforms to manufacturer's recommendations, and shall further guarantee his workmanship connected with the installation for a period of one year from the date of installation.