

SIPOXY-GUARD 245

Epoxy Tank Lining

Product No. 6245

Features

- Low VOC fuel and ballast tank lining.
- Two coat system.
- Exceed the requirements of MIL-C-4556E.
- Outstanding resistance to fuels & various chemicals.
- Approved under APCS-2D

Recommended Use

- Suitable for cargo / ballast tanks containing aviation, motor & home fuels - lube and motor oils - hydraulic fluids - crude oil (sweet or sour).
- Suitable for fuel tanks, cargo tanks, cargo ballast tanks & landside storage tanks

Physical Data

Finish	:	Semi-Gloss
Colours	:	Yellow , White
Volume Solids	:	80%
Recommended Film Thickness:		
100 microns dry = 150 microns wet per coats		
200 – 300 mic wet = 250–375 mc wet in two coats		
Theoretical Coverage:		
8 m ² /ltr. at 100 microns DFT		

Density (mixed)	:	1.40 kg/ltr.
Drying Times :		
<u>25°C / RH 65%</u>		
Dry to Recoat	:	24 Hours
Hard Dry	:	48 Hours
Maximum Recoating Time	:	18 days
Heat Resistant	:	149°C dry
Flash Point	:	38°C

Specification Data

Preparation

Steel

All surfaces must be free of grease, oil, and moisture before blast cleaning to Near White Metal equivalent to Steel Structures Painting Council SP10 or ISO 8501-1 Sa 2.5. The steel profile after blasting should be 1.5 to 2.5 mils (38 to 63 microns) in depth and be of a jagged nature as opposed to a peen pattern. Surfaces must be free of grit dust. Primer or first coat should be applied to clean surfaces as soon as possible to prevent rerusting or contamination.

Paint System

2 coats SIPOXY-GUARD 245 in contrasting colours at 4 mils (100 microns) per coat, plus two stripe coats in contrasting colours over sharp edges, cut-outs and welds.

MIL-C-4556E requires Yellow primer as the first coat, and White as the finish coat.

Note: Because SIPOXY-GUARD 245 has minimal shrinkage, a film thickness well in excess of 4 mils (100 microns) can be applied without adverse performance effects.

Application Data

Mixing Ratio by Volume	Base : 4 parts Hardener : 1 part
Mixing Advice	SIPOXY-SHIELD 245 is a two component product supplied in 20 ltr. and 5 ltr. kits which contain the proper ratio of ingredients. The entire contents of each container must be mixed together. Power mix the base portion first to obtain a smooth, homogeneous condition. After mixing the base portion for 5 to 10 minutes, add the hardener slowly with continued agitation. After the hardener add is complete, continue to mix slowly until homogeneous.
Thinning	Thinner 720 / Thinner T-4. Thinning is not normally required or desired; however, at lower temperatures, small amounts (10% or less) of Thinner 720 can be added. Any solvent addition should be made after the two components are thoroughly mixed.
Induction time	SIPOXY-SHIELD 245 require 1 hour at 25°C.
Pot Life	4 hours at 25°C.
Application Details	SIPOXY-SHIELD 245 can be applied by both conventional air spray, airless spray and roller. For air spray application, use a fluid tip of .070" to .086". Where airless equipment is used, a 30 : 1 pump and .019" to .023" tip size will provide a good spray pattern. For touch-up work, SIPOXY-SHIELD 245 can be applied by brush or roller. Care should be taken that proper and uniform film thickness is obtained. For application by roller use Thinner 740 upto 20% by volume for the first coat only, depending upon porosity of the surface.
Cleaning of Equipment	Use Thinner 720 / Thinner T-4.

Storage Information

Pack Size	5 and 20 ltr. two component kits.
Storage	Store generally in original sealed container indoors at a temperature between 5 and 40°C and relative humidity below 70%.
Shelf Life	1 Year

Safety Information

See the material safety data sheet and product label for complete safety and precaution requirements.

Disclaimer

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