

SIPTANK 255

100% Solids Epoxy Tank Coating

Product No. 6255

Features

- Versatile: excellent adhesion to both steel and concrete.
- Easy Application and Long Pot Life
- Excellent Water Immersion Properties
- Excellent Chemical and Solvent Resistance.
- Excellent wetting of glass mat and chopped glass fibres. Can be applied up to 1/2 inch thick on horizontal surfaces.
- Approvals: NSF-Potable water tank lining.
- Environment friendly. 100% solids.

Recommended Use

- Repair of tank bottoms with or without glass reinforcement, including water tanks, fuel tanks, selected chemical tanks and ballast tanks. Sewage and waste treatment plants.
- Tank Lining for Potable Water
- Tank Lining for Tanks carrying (aromatic solvents including xylene, cumene and aromatic naphthas. All gasoline including the super unleaded grades, methyl tertiary butyl ether, caustic solutions)
- Super unleaded gasoline containing methanol or ethanol are not suitable.

Physical Data

Finish : Gloss

Colours : Aluminium Grey, Oxide Red

Volume Solids : 100%

Recommended Film Thickness:

100 - 125 microns dry / wet x two coats

Theoretical Coverage:

10 m²/ltr. at 100 microns

Density (mixed) : 1.75 kg/ltr.

Drying and Recoating Times

(25°C / 65% RH):

Dry to Recoat : 10 Hours

Hard Dry : 17 Hours

Maximum Recoating Time : 04 Days

Heat Resistant : 121°C Dry

Flash Point : >100°C s

Specification Data

Preparation

Steel

All surfaces must be free of oil, grease, salt and moisture before abrasive blasting to Near White Metal equivalent to Steel Structures Painting Council SP10 or ISO 8501-1 Sa 2.5. The minimum steel profile after blasting should be 2 mils (50 microns) in depth and be of a jagged nature as opposed to a peen pattern. Surfaces must be free of grit dust.

The first coat should be applied to cleaned surfaces as soon as possible to prevent rerusting or contamination.

Pre-treatment: Concrete

"New" cast concrete should be lightly blast cleaned or ground to completely remove all surfaces curing compounds or laitance. Vacuum clean or "sweep" the surface with dry clean air to ensure that no abrasive or particles are left on the surface. "Old" concrete should be carefully inspected and a pre-treatment specification worked out to ensure that SIPTANK 255 is only applied to concrete that is clean and of good structural strength.

Ventilation

Although SIPTANK 255 is solvent free, good ventilation with dry air is required for the protection of the applicator, to prevent condensation and to obtain proper coating performance. Ventilation should be maintained throughout the cure period. Be sure the air in the lowest areas is constantly replaced with fresh, dry air.

Application Data

Mixing Ratio by Volume	Base : 3 parts Hardener : 1 part
Mixing Advice	SIPTANK 255 is a two component product supplied in 20 litre kits which contain the proper ratio of ingredients. The entire contents of each container must be mixed together. Mix the base portion slowly for several minutes. After mixing the base portion, add the hardener slowly with continued agitation. After the hardener add is complete, continue to mix slowly until the system is homogeneous.
Thinning	Thinning not recommended. Clean up with Thinner 740. At lower temperatures, efforts should be made to bring the coating to 25 °C, rather than Thinning.
Induction Time	None
Pot Life	2 hours at 25°C.
Application Details	Airless spray is recommended. A 45 : 1 pump and .021" to .029" tip size will provide a good spray pattern. SIPTANK 255 can also be applied to floors or decks with a spreader or squeegee. A minimum of four days cure with ventilation at temperatures above 25°C should be allowed before tank linings are put into cargo service. Longer curing times with ventilation are required if temperatures are lower than 25°C. Do not allow coating to remain in the application equipment longer than 2 hours. Flush out all application equipment whenever there is a delay in application.
Cleaning of Equipment	Use Thinner 740 or 730.

Storage Information

Pack Size	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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