

# SIPTANK 256

100% Solids Epoxy Tank Coating

Product No. 6256

Features	Recommended Use
<ul style="list-style-type: none"> <li>● Two component high build amine cured epoxy.</li> <li>● Versatile: excellent adhesion to both steel and concrete.</li> <li>● Excellent Water Immersion Properties</li> <li>● Excellent Chemical and Solvent Resistance.</li> <li>● Water tank lining.</li> <li>● Environment friendly. 100% solids.</li> <li>● Excellent resistance to fresh and sea water</li> <li>● High build, polyamine cured system</li> <li>● Conforms to BS 6920</li> </ul>	<ul style="list-style-type: none"> <li>● Tank lining for potable water</li> <li>● Sewage waste treatment tanks</li> <li>● Ballast and selected chemicals storage tanks</li> <li>● Fuel and crude oil tanks</li> <li>● Repair of tank bottoms</li> </ul>

Physical Data	
<b>Finish</b> :	Semi Gloss
<b>Colours</b> :	Off White, Grey, Oxide Red, Blue
<b>Volume Solids</b> :	100%
<b>Recommended Film Thickness:</b>	300 – 400 microns dry in 2 coats
<b>Theoretical Coverage:</b>	5 m <sup>2</sup> /liter at 200 microns DFT
<b>Density (mixed)</b> :	1.55 kg/ltr.
<b>Drying and Recoating Times</b>	
<b>(25°C / 65% RH):</b>	
Dry to Recoat	: 24 Hours
Hard Dry	: 36 Hours
Maximum Recoating Time	: 04 Days
<b>Heat Resistant</b> :	121°C Dry
<b>Flash Point</b> :	>100°C

## 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 256 is only applied to concrete that is clean and of good structural strength.

#### Ventilation

Although SIPTANK 256 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

<b>Mixing Ratio by Volume</b>	Base : 3 parts Hardener : 1 part
<b>Mixing Advice</b>	SIPTANK 256 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.
<b>Thinning</b>	Thinning is not recommended. At lower temperatures, efforts should be made to bring the coating to 25 °C, rather than Thinning. Consult SIPCO Technical Services Department.
<b>Induction Time</b>	None
<b>Pot Life</b>	2 hours at 25°C.
<b>Application Details</b>	Airless spray is recommended. A 45 : 1 pump nozzle pressure min. 250 bar / 3625 psi and .021" to .029" tip size will provide a good spray pattern. SIPTANK 256 can be applied by brush manually.  SIPTANK 256 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.
<b>Cleaning of Equipment</b>	Use Thinner 740 or 730.

## Storage Information

<b>Pack Size</b>	10 & 20 ltr. two component kits.
<b>Storage</b>	Store generally in original sealed container, indoors, at a temperature between 5 and 40°C and relative humidity below 70%.
<b>Shelf Life</b>	1 Year

## Safety Information

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

## Disclaimer

The information in this data sheet represent test results or experience under well defined conditions. Its accuracy or suitability under the actual conditions of any intended use is not guaranteed and must be determined by the user. All advice given about this product is given in good faith. Since as we have no control over conditions of substrate and application, manufacturer and seller can not accept any liability in connection with the use of the product relative to coverage, performance, injury or damage, unless we specifically agree in writing to do so. The information in this data sheet is subject to change without notice and it is the user's responsibility to ensure it is current. For further information and advice contact SIPCO Technical Services Department on Tel. (03) 847 2299, Fax (03) 847 3780.