

# SIPOXY-SHIELD GF 268

## High Build Glass Flake Epoxy Coating

Product No. 6268

### Features

- Exceptional Corrosion Protection, salt and fresh water immersion resistance, and protection against corrosive chemical environments.
- Polyamide cured surface tolerance coating.
- Good adhesion to damp surfaces & excellent adhesion to tight rust.
- Can continue curing under water whereby ideal for splash zone and tidal zone areas.
- Excellent cathodic disbondment resistance.
- Self Priming
- Low VOC

### Recommended Use

- Tank linings and pipe coatings, ballast and potable water tanks, bilge, wet voids and drainage pipes.
- Ships, offshore and marine structures, above and below-water hull areas decks and superstructures - multi purpose repair coating.
- Structural steel, equipment and masonry surfaces, pulp and paper mills, chemical and fertilizer plants, sewage treatment plants, storage tanks and pipes, bridges.
- Fabrication and new construction, speeds up production, even at low temperatures a single multi purpose, surface-tolerant coating.

### Physical Data

<b>Finish</b>	: Semi Gloss
<b>Colours</b>	: Off-White, Buff, Grey, Oxide Red, Yellow, Black, Aluminium
<b>Volume Solids</b>	: 90%
<b>Recommended Film Thickness:</b>	400-500 microns dry = 444-555 microns wet
<b>Theoretical Coverage:</b>	9 m <sup>2</sup> /ltr. at 100 microns

<b>Density (mixed)</b>	: 1.47 kg/ltr.
<b>Drying Times:</b>	<u>25°C / 65%RH</u>
Dry to Recoat	: 04 Hours
Hard Dry	: 08 Hours
Maximum Recoat able Time:	07 Days
<b>Heat Resistant</b>	: 121°C dry
<b>Flash Point</b>	: 28°C

### Specification Data

#### Preparation Steel

All direct to metal coatings provide the maximum performance over near white blast cleaned surfaces. There are, however, situations and cost limitations, where grit blasting to near white metal is not possible.

SIPOXY-SHIELD Coatings were designed to provide excellent protection over less than ideal surface preparation.

The surface preparation recommended for SIPOXY-SHIELD GF 268 is to include removal of water, salt, dirt, oil, loose rust and all rust scale. For non immersion service is Steel Structures Painting Council Standard SSPC-SP10 or Swedish Standard Sa2.5 for immersion service, the minimum standard is SA 3, or SPCC SP – 5 with surfer profile of 50 – 75 microns.

## Application Data

<b>Mixing Ratio by Volume</b>	Base : 3 parts Hardener : 1 part
<b>Mixing Advice</b>	SIPOXY-SHIELD GF 268 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, add the hardener slowly with continued agitation. After the hardener add is complete, continue to mix slowly.
<b>Thinning</b>	Thinner 740 is recommended. Thinning is not normally required or desired; however, at lower temperatures or in extreme conditions small amounts (20% or less) one of the above solvents can be added depending on local VOC & air quality regulations. Thinning is required for conventional air spray, brush and roller. Any solvent addition should be made after the two components are thoroughly mixed.
<b>Induction Time</b>	SIPOXY-SHIELD GF 268 require a 15 minutes induction time at 25°C.
<b>Pot Life</b>	4 hours at 25°C.
<b>Application Methods</b>	SIPOXY-SHIELD GF 268 can be applied by both conventional air spray and airless spray equipment.
<b>Remarks</b>	SIPOXY-SHIELD GF 268 hardener is based on a modified amine which becomes darker during storage. This would result in more yellowish shade than Grey RAL 7038 and Off White. This color change would not be detrimental to the performance criteria.
<b>Application Details</b>	SIPOXY-SHIELD GF 268 may also be applied by brush or roller. For air spray application, use a fluid tip of .070" to .086". Where airless equipment is used, a 45 : 1 pump and .019" to .025" tip size will provide a good spray pattern. Tank Coating System - Two coats of SIPOXY-SHIELD GF 268 at 5 mils to 8 mils (125 - 200 microns) per coat, plus two stripe coats over sharp edges, cut-outs and welds. Use contrasting colours for each coat and stripe coat. Antifouling paints should be applied over SIPOXY-SHIELD GF 268 before the SIPOXY-SHIELD GF 268 Coating has cured hard.
<b>Ventilation</b>	It is very important for the safety of the applicator and the proper performance of the SIPOXY-SHIELD GF 268 that good ventilation be provided to all portions of the enclosed area. It is equally important to bring into the enclosed area dry, fresh air to remove all solvent vapours. Since all solvent vapours are heavier than air, ventilation ducts should reach to the lowest portions of the enclosed areas as well as into any structural pockets. Ventilation should be provided throughout the cure period to ensure all the solvents are removed from the coating. For potable water tanks, it is essential that full ventilation be maintained for seven days.
<b>Cleaning of Equipment</b>	Use Thinner 740.

## Storage Information

<b>Pack Size</b>	5 and 20 ltr. two component kits.
<b>Storage</b>	Store originally 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 SPCO Technical Services Department on Tel. (03) 847 2299, Fax (03) 847 3780.