

SIPOXY-GUARD 270

Chemical Resistant Epoxy Tank Lining

Product No. 6270

Features

- Exceptional resistance to a wide range of chemicals and solvents.
- Excellent resistance over a wide range of temperatures and pressures.
- No bake cure.
- Two coat system in two contrasting colours.
- Conforms to BS 6920.
- Approved under APCS-2A & 2B.

Recommended Use

- Cargo tanks in chemical tankers, barges & railroad tanker cars.
- Potable water tanks.
- Industrial storage and process chemical tanks and pipelines.
- High pressure crude oil pipes and separation tanks.
- Protective coating for highly corrosive environments.

Physical Data

Finish : Semi-Gloss

Colours : Manila, Pale Blue, Off-White, Grey

Volume Solids : 72%

Recommended Film Thickness:
125-150 micron dry in two coat system.
100 micron dry in three coat system.

Theoretical Coverage:
5.8 m²/ltr. at 125 microns

Density (mixed) : 1.50 kg/ltr.

Drying Times : see table over

Heat Resistant : 149°C dry

Flash Point : 28°C

Specification Data

Preparation

All surfaces must be free of oil, grease, salts and moisture before abrasive blasting to near white metal equivalent to Steel Structure Painting Council SP10 or ISO 8501-1 Sa 2.5. The steel profile after blasting should be 1.5 to 2.5 mils (38 - 63 microns) in depth and be of a jagged nature as opposed to a peen pattern. Surfaces must be free of grit dust. Dehumidification equipment should be employed to prevent rerusting. Before applying the first coat be sure all surfaces are clean and dust free.

Ventilation

It is very important for the safety of the applicator and the proper performance of the SIPOXY-GUARD 270 Coating 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 vapors throughout the cure period.

Coating System

2 Coats of SIPOXY-GUARD 270 Coating at 5 - 6 mils (125 - 150 microns) per coat. All sharp edges, cut-outs and welds must receive two stripe coats first. Use contrasting colour for each coat and stripe coat.

Temp. °C	Minimum Recoating Time	Maximum Recoating Time
05°C	52 Hours	60 Days
10°C	46 Hours	45 Days
15°C	40 Hours	40 Days
20°C	13 Hours	25 Days
25°C	10 Hours	18 Days
30°C	08 Hours	13 Days
35°C	06 Hours	10 Days
40°C	04 Hours	07 Days
45°C	04 Hours	04 Days
50°C	3.5 Hours	03 Days
55°C	3 Hours	36 Hours
60°C	2 Hours	10 Hours

See application guide supplement for additional information.

Cure to put tank into service : 7 days with ventilation at 25°C for maximum chemical resistance. If forced heat cure is desired, contact SIPCO Technical Service Department.

Note: For potable water service, once coating is cured, fill twice with water each time for a period of no less than 24 hours and finally flush with fresh water.

Application Data

Mixing Ratio by Volume Base : 4 parts Hardener : 1 part

Mixing Advice SIPOXY-GUARD 270 is a two component product supplied in 10 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 for 15 minutes.

Thinning Thinner 740 / Thinner T-10

Thinning is not normally required or desired; however, at lower temperatures or in extreme conditions, small amounts (10% or less) of Thinner 740 can be added. Any solvent addition should be made after the two components are thoroughly mixed.

Induction time SIPOXY-GUARD 270 require a 15 minutes induction time at 25°C.

Pot Life The pot life of the mixed material is 4 hours at 25°C. Higher temperatures will reduce working life of the coating; lower temperatures will increase it.

Application Details SIPOXY-GUARD 270 Lining should be applied only by air or airless spray.
Air spray - use agitated spray pots, 1/2" ID air hoses and 1/2" fluid hose.
Airless - use a heavy duty 30 - 1 pump or equivalent, and .019" to .025" range tip sizes.

Cleaning of Equipment Use Thinner 740 / Thinner T-10.

Storage Information

Pack Size 5 and 10 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

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.