

SIPTAR 644

A High Build Coal Tar Epoxy

Product No. 6644

Features

- Excellent anti-corrosive properties and good impact, weather, oil and water resistance.
- Polyamine adduct cured.
- Self Priming
- Approved under APCS-3.

Recommended use

- As an outstanding protective coating on permanently submerged surfaces such as: ship's hulls, offshore structures, sheet piling, steel, concrete or asbestos cement sewer pipes etc.
- As a tank lining in crude oil and water ballast tanks, cofferdams, void spaces etc.

Physical Data

Finish : Matt

Colours : Black and Dark Brown

Volume Solids : 68%

Recommended Film Thickness:
100 - 300 microns dry = 147 – 441 microns wet

Theoretical Coverage:
6.8 m²/ltr. at 100 microns

Density (mixed) : 1.45 kg/ltr.

Drying and Recoating Times at 150 microns WFT (25°C/65% RH):

Touch Dry	:	02 Hours
Minimum recoating time	:	24 Hours
Hard Dry	:	36 Hours
Maximum recoating time	:	07 Days
Cured	:	07 Days

Heat Resistant : 120°C dry

Flash Point : 27°C

Specification Data

Preparation

Steel Substrate

Blast cleaning to SSPC-SP10 (Sa 2.5).

Concrete & Asbestos

All loose particles, dust and other contaminants must be removed from the surface. This is best achieved by light sweep blasting. The concrete must be completely thorough dry.

Ready Primed Surface

SIPTAR 644 may be applied over a compatible epoxy holding primer for steel or epoxy sealer for concrete.

Application Data

Mixing Ratio by Volume Base : 9 parts
 Hardener : 1 part

Mixing Advice Prior to application, stir the A-component, add B-component and mix thoroughly to obtain a homogeneous mixture. Use a mixer for this which is powered by air or a flameproof electric motor.

Thinning When mixed, the paint is ready for brush or airless spray application.
 If the paint is too thick, in cold weather for example, then add a small amount of the Thinner 750 / Thinner 0252 to obtain the suitable viscosity. The amount of thinner that may be added is dependent on the application conditions and methods. Overthinning will lead to poor results. Add thinner only after mixing of the components.

Pot Life 4 hours at 20°C

Application Details Application temperature: 5 - 50°C.
 The minimum temperature required for satisfactory drying is 10°C. The surface temperature must be at least 3°C above the dew point to prevent condensation. Never apply paint under adverse weather conditions.
 In confined spaces, constant purging of the air during application and drying is necessary to eliminate solvent vapours for reasons of health and safety as well as to assist evaporation.

	<u>Airless spray</u>
Recommended thinner	: Thinner 750
Thinner addition	: 5 - 10 vol.%
Nozzle orifice	: 0.019 - 0.023 inch
Working pressure	: 140 - 160 bar

	<u>Brush/Roller</u>
Recommended thinner	: Thinner 750
Thinner addition	: 5 vol.%

The recommended method of application is by airless spray. Use of brush or roller should be restricted to small areas only.

Cleaning of Equipment Use Thinner 750 / Thinner 0252

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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