

# SIPTAR 645

## 100% Solids Coal Tar Epoxy

Product No. 6645

### Features

- Self Priming
- New 100% solid technology.
- High build.
- Excellent anti-corrosive properties and good impact, weather, oil and water resistance.
- Excellent track record for underground foundations.
- Provide outstanding protection in marine environment

### 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.
- Excellent resistance to sea water, various soil chemicals and soil stress.
- Suitable for Sewerage and Waste Water Works.

### Physical Data

**Finish** : Semi-gloss

**Colours** : Black and Dark Brown

**Volume Solids** : 100%

**Recommended Film Thickness:**

200 - 300 microns dry / 200 – 300 microns wet

**Theoretical Coverage:**

10 m<sup>2</sup>/ltr. at 100 microns

**Density (mixed)** : 1.60 kg/ltr.

**Drying and Recoating Times at 100 microns (25°C/65% RH):**

Touch Dry : 04 Hours

Minimum recoating time : 24 Hours

Hard Dry : 24 Hours

Maximum recoating time : 07 Days

Cured : 07 Days

**Temp. Resistant** : 120°C dry

**Flash Point** : > 120°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 dry.

##### Ready Primed Surface

SIPTAR 645 may be applied over a compatible epoxy holding primer for steel or epoxy sealer on concrete. All damaged areas should be correctly cleaned as above.

## Application Data

<b>Mixing Ratio by Volume</b>	Base : 6 parts Hardener : 1 part										
<b>Mixing Advice</b>	Prior to application, stir the base, add the hardener and mix thoroughly to obtain a homogeneous mixture. Use a mixer which is powered by air or a flameproof electric motor.										
<b>Thinning</b>	When mixed, the paint is ready for roller or squeegee. If thinning is desirable use Thinner 750.										
<b>Pot Life</b>	4 hours at 20°C										
<b>Application Conditions</b>	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 highly recommended.										
<b>Application Methods and Details</b>	<table border="0" style="width: 100%;"> <tr> <td style="width: 60%;"></td> <td style="text-align: right;"><u>Airless spray</u></td> </tr> <tr> <td>Recommended thinner :</td> <td>Thinner 750</td> </tr> <tr> <td>Thinner addition :</td> <td>5 - 10 vol.%</td> </tr> <tr> <td>Nozzle orifice :</td> <td>0.21" - 0.025"</td> </tr> <tr> <td>Working pressure :</td> <td>250 bar / 3625 psi</td> </tr> </table> <p>The product has specially been designed to apply by roller &amp; brush but it is also applicable by heavy duty airless spray.</p> <p>Airless spray data are indicative and subject to adjustment.</p>		<u>Airless spray</u>	Recommended thinner :	Thinner 750	Thinner addition :	5 - 10 vol.%	Nozzle orifice :	0.21" - 0.025"	Working pressure :	250 bar / 3625 psi
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<b>Cleaning of Equipment</b>	Use Thinner 750.										

## Storage Information

<b>Pack Size</b>	5 and 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.