

SIPTANK 250Epoxy Tank Lining

Product No. 6250

Features

Recommended Use

- High Volume Solids: Economical for fuel and ballast tank lining.
- Low VOC.
- Two coats system.
- Outstanding resistance to fuel & various chemicals.
- Approved under APCS-2C

- SIPTANK 250 Tank Coating Systems are recommended for: fuel tanks, cargo tanks, cargo ballast tank, fish and shellfish hold and landside storage tanks.
- SIPTANK 250 Tank Coating is recommended as a lining in cargo or cargo ballast tanks where the cargoes are: aviation, motor & home fuels, lube and motor oils, hydraulic fluids, crude oil (sweet or sour), grain and other selected cargoes

Physical Data

Finish : Semi-Gloss

Colours : White, Pale Blue

Volume Solids: 93%

Recommended Film Thickness:

100 - 250 microns dry = 108 - 269 microns wet

two coats

Theoretical Coverage: 9.3 m²/ltr. at 100 microns

Density (mixed) : 1.50 kg/ltr.

Drying Times: 25°C / RH 65%

To recoat : 20 Hours
Dry Hard : 36 Hours
Maximum Recoating Time : 18 Days

Heat Resistant : 149°C dry

Flash Point : 28°C

Specification Data

Preparation

Steel

All surfaces must be free of grease, oil, and moisture before blast cleaning to Near White Metal equivalent to Steel Structures Painting Council SP10 or ISO 8501-1 Sa 2.5. The steel profile after blasting should be 1.5 to 2.5 mils (38 to 63 microns) in depth and be of a jagged nature as opposed to a peen pattern. Surfaces must be free of grit dust. Primer or first coat should be applied to clean surfaces as soon as possible to prevent rerusting or contamination.

Paint System

2 coats SIPTANK 250 in contrasting colours at 4 mils (100 microns) per coat, plus two stripe coats in contrasting colours over sharp edges, cut-outs and welds.

MIL-C-4556E requires Yellow primer as the first coat, and White as the finish coat.

Note: Because SIPTANK 250 has minimal shrinkage, a film thickness well in excess of 4 mils (100 microns) can be applied without adverse performance effects.

Ventilation

It is very important for the safety of the applicator and the proper performance of the SIPTANK 250 that good ventilation be provided to all portions of the enclosed area. It is equally important to bring into a closed area dry, fresh air to remove all solvent vapours.

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Application Data

Mixing Ratio by Volume Base : 4 parts

Hardener : 1 part

Mixing Advice SIPTANK 250 is a two component product supplied in 5 and 20 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 for 5 to 10 minutes, add the hardener slowly with continued agitation. After the hardener add is

complete, continue to mix slowly until homogeneous.

Thinning Thinner 730 / Thinner 740.

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 1 hour at 25°C.

Pot Life 4 hours at 25°C.

Application Methods SIPTANK 250 can be applied by both conventional air spray, airless spray

equipment, however airless spray is recommended.

For touch-up work, SIPTANK 250 can be applied by brush or roller. Care

should be taken that proper and uniform film thickness is obtained.

Application Details For air spray application use a fluid tip of .070" to .086".

Where airless equipment is used, a 30:1 pump and .019" to .023" tip size

will provide a good spray pattern.

A minimum of four days curing with good ventilation at temperatures above 16°C should be allowed before the tanks are put into service. Longer curing time with good ventilation is required if temperatures are lower than 16°C or if

the tank will carry aggressive cargoes.

Cleaning of Equipment Use Thinner 730 / Thinner 740.

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

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.

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