

# SIPTANK 251

## Epoxy Tank Lining

Product No. 6251

### Features

- Two component amine cured epoxy primer
- Excellent impact and chemical resistance
- Economic tank lining
- Long over coating time
- As a blast primer for heavy duty epoxy & tank lining systems

### Recommended Use

- As a tank lining in tanks containing potable water, seawater, aviation and motor fuels, crude oil and other selected products.
- As a intermediate or finish coat for structural steel and concrete surfaces.

### Physical Data

**Finish** : Flat

**Colour** : Light Green,  
Light Grey, White

**Volume Solids** : 48%

**Recommended Film Thickness:**  
100  $\mu$  microns dry (4 mils)  
25 - 50 microns dry as a holding primer for heavy duty Epoxy Tank Lining System.

**Theoretical Coverage:**  
9.6 m<sup>2</sup>/litre at 50 microns  
4.8 m<sup>2</sup>/litre at 100 microns

**Density (mixed)** : 1.3 kg/liter

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

Tack Free : 06 Hours  
Recoatable : 16 Hours

**Heat Resistant (Dry)** : 121°C

**Flash Point** : 27°C

### Specification Data

#### Preparation

##### Steel

Siptank 251 is designed to be applied over steel substrate which has been blast-cleaned and coated with epoxy primers and zinc rich primers.

##### Concrete

After proper surface preparation concrete substrates have to be primed with Concrete Sealer such as Sipseal 221 before applying Siptank 251.

All damaged areas should be rectified and made good to ensure uniformity of system. The substrate should then be thoroughly degreased in accordance with SSPC-SP1. All dust should be removed from the substrate by using vacuum cleaners or clean brushes and/or dry compressed air. Ensure that the substrate is completely dry prior to the application of Siptank 251.

## Application Data

<b>Mixing Ratio by Volume</b>	Base : 4.8 part Hardener : 1 part
<b>Mixing Advice</b>	The two components of Siptank 251 have to be mixed properly using a low speed power mixer.  After mixing the base portion for several minutes, add the hardener slowly with continued agitation. After adding the hardener continue to mix slowly for 15 minutes.
<b>Thinning</b>	Airless spray add 5% by vol. Thinner 730. Brush and Roller add 3-5% by vol. Thinner 730.  When used as an holding primer Siptank 251 can be thinned upto 35% with Thinner 730.
<b>Pot Life</b>	5 hours at 20°C.
<b>Application Details</b>	The recommended method of application is by airless spray. However, brush and roller may be used for small isolated areas only. The spray equipment should be of a type approved by the engineer e.g. 45:1 ratio airless pump.  Tip size: 0.017" to 0.023". Output fluid pressure: 150 bar (2100 PSI)  Minimum application temperature is 10°C.  Do not apply coating if difference between surface temperature and dew point is less than 4°C. Application below 10°C or where the relative humidity is over 80% should be avoided.
<b>Cleaning of Equipment</b>	Use Thinner 730.

## 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

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