

SIPTANK 263

Fiberglass Reinforced Epoxy – Hand Applied

Product No. 6263

Features

- Solvent Free
- Easy to Apply
- Good Water and Chemical Resistance
- Good Abrasion Resistance

Recommended Use

- For rebottoming of pitted & corroded chemical, water and petroleum storage tanks.
- For reinforcing the interior of concrete storage tanks for chemical, water and petroleum

Physical Data

Finish : Glossy

Colour : Clear

Volume Solids : 100%

Recommended Film Thickness:

System including mat, tissue and gel coat – approx. min. 1200 Microns.

System including double mat, tissue and gel coat – approx. min. 2500 microns

Theoretical Coverage:

0.8 m²/litre at 1250 micron

Density (mixed) : 1.12 kg/liter

Drying Times :

At 25°C / 65% RH

Dry to Handle : 30 Hours

Minimum Recoating Time : 20 Hours

Maximum Recoating Time : 40 Hours

Cured : 40 Hours

Into Service : 07 Days

In case of overcoating interval is past the maximum limit, abrade the cured film with sandpaper or sweep blast prior to application of fresh coat.

Flash Point:

Base : 138°C

Hardener CA1 : 183°C

Hardener CA2 : 163°C

Specification Data

SPECIFICATION DATA

Surface Preparation

Steel Surface

Should be degreased & cleaned using SIPCLEAN 615 to ensure the removal of oil, grease, salts, dust and other surface contaminants prior to further surface preparation.

Prior to start of blasting work, all the surface irregularities including weld splatters, weld fluxes, rough capping, etc. shall be removed or smoothed using mechanical tools.

The surface is blasted to Sa 2^{1/2} (Near White Metal) with a depth of pattern from 50-120 micron.

Blasted surface shall be vacuumed or blown clean and extra care should be taken to avoid contamination of the blast cleaned surface, severe corrosion undercut or weld porosity) larger than 1 inch in diameter) should be reported for remedial work.

Priming shall take place while surface preparation is still fresh (directly after blasting and before oxidation).

The overall steel surface such as the shell support column tank floor and bottom shall be primed with a solvent based epoxy such as SIPRIME 215/SIPTANK 251 to a dry film thickness (DFT) of 25-30 microns only.

Concrete & Masonry

Substrate should be thoroughly dry. All dirt, dust and loose flakes should be removed. The ideal preparation would be light abrasive sweep blasting followed by a seal coat of SIPSEAL 222. Any blowholes, pinholes or repairs should be filled using SIPOXY MORTAR 680 with fine aggregates applied in a skim coat.

Application Data

Caulking

Shall be applied on all sharp edges, mainly between shell and floor, between floor plates, in and around sumps, around connection between pipes and hull, and around support pipes. For Caulking, mix by weight 100 parts base/hardener mixture and 20 parts Aerosil, 202, Cabosil or equivalent. Washed, dried and sieved silica sand may also be used having a particle size predominantly in the range of 0.2-0.3 mm (60 to 80 mesh ASTM E12) then 750 parts weight of sand per 150 parts of base/hardener mix is the maximum that can be incorporated.

Base and Hardener agents are thoroughly mixed and then Aerosil/Cabosil/Sand is then incorporated slowly preferably using a rotating drum mixer to give a thick mix suitable for application by knife.

LAMINATE SYSTEM

LAMINATION SYSTEM CONSISTS of Siptank 263 Base and Hardeners CA1 and CA2 incorporated with one or two layers of 450 G/M² fiberglass chopped strand (CSM), followed by 30 g/m² of surfacing tissue followed by a gel coat to give a resin rich finish.

Mixing Ratio	Base	Hardener CA1	Hardener CA2
by weight	62.5	32.5	5
by volume	62	33	5

Thinning Thinning is not recommended.

Induction Time Not applicable.

Pot Life 3 hours 45 minutes @ 20°C.
1 hour 30 minutes @ 40°C

Application Details Hand applied. Use short pile rollers and brushes of good quality for application of the laminate resin. Use steel rollers to embed fully the fiberglass into the resin and to remove wrinkles and roll with steel roller to remove trapped air.

Cleaning of Equipment Use Thinner 740.

Storage Information

Pack Size	200 ltr and 20 ltr (on order and for repair kit only)
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.