

# SIPOXY-SHIELD 280

## Potable Water Epoxy Coating

Product No. 6280

### Features

- Outstanding Corrosion Resistance: Suitable for fresh and salt water immersion,
- Excellent Cathodic Disbondment.
- Lowers Cost Of Surface Preparation: Good adhesion to tight rust, and to damp surfaces.
- Low Temperature Cure - Fast Recoat: Cures down to 0°F (-18°C).
- Certification: NSF (National Sanitation Foundation) certified for potable water tanks, ANSI/NSF Standard 61, Potable water pipe coatings & Potable water valve coatings. See current NSF Listing for restrictions. Up to 20 mils in one coat for water pipes.

### Recommended Use

- Sipoxy-Shield 280 is recommended for application on :
- Tank Linings: for steel and concrete substrate
  - Ballast tanks, water tanks, bilge and any other water containment structures.
  - Cargo and fuel tanks.
  - Potable Water: Water tanks, water pipes, water valves.
  - Fabrication and new construction :  
Speeds up production; fast recoat and cure even at low temperatures.  
Multi-purpose, surface tolerant coating.

### Physical Data

**Finish** : Semi-Gloss

**Colours** : Off-White, Buff,  
Oxide Red, Pale  
Blue, Black

**Volume Solids** : 82%

**Recommended Film Thickness:**

100 - 150 microns dry = 125 – 188 microns wet  
625 microns wet to obtain 500 microns dry

**Theoretical Coverage:**

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

**Density (mixed)** : 1.5 kg/ltr.

**Drying Times** :

25°C / 65%RH  
Dry to Recoat : 10 Hours  
Hard Dry : 20 Hours  
Maximum Recoating Time : One Month

**Heat Resistant** : 121°C dry

**Flash Point** : 27°C

### Specification Data

**Preparation**

Steel Potable Water Tanks: all surfaces must be free of oil, grease and moisture before blast cleaning to near white metal equivalent to Steel Structures Painting Council SP-10 or ISO 8501-1 Sa 2.5. The steel profile should be 1.5 to 2.5 mils in depth, and be of a jagged nature.

All grit dust must be removed from surfaces prior to coating application.

Non-Potable Water Tanks and Fuel Tanks: For tanks not carrying potable water, a lesser degree of surface preparation can be used.

**Concrete**

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 thoroughly dry. Prime with SIPSEAL 220.

Contact SIPCO Technical Services Department for specific recommendations.

**Ventilation**

It is very important for the safety of the applicator and the proper performance of the SIPOXY-SHIELD 280 that good ventilation be provided to all portions of the enclosed area. It is equally important to bring into the enclosed area dry, fresh air to remove all solvent vapours. Since all solvent vapours are heavier than air, ventilation ducts should reach to the lowest portions of the enclosed areas as well as into any structural pockets. Ventilation should be provided throughout the cure period to ensure all the solvents are removed from the coating.

Allow at least 24 hours under full ventilation between first and second coat. Allow seven days cure time, with ventilation, before putting the tank into service. At temperatures below 25°C, a longer cure time is required.

<b>Application Data</b>
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<b>Mixing Ratio by Volume</b>	Base	:	4 parts
	Hardener	:	1 part

**Mixing Advice** SIPOXY-SHIELD 280 Coating is a two component product supplied in 20 ltr. and 5 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, add the hardener slowly with continued agitation. After the hardener add is complete, continue to mix slowly.

**Thinning** Thinning is not normally required however, small amounts of the solvent recommended can be added depending on NSF specifications. 0 -10 % of thinner 730 may be utilised. Thinner addition should be made after the two components are thoroughly mixed.

**Induction Time** SIPOXY-SHIELD 280 Coating requires a 15 minutes induction time at 25°C.

**Pot Life** 4 hours at 25°C.

**Application Details** SIPOXY-SHIELD 280 Coating can be applied by airless and air spray methods, however, the preferred method of application is with heavy-duty airless spray. For airless spray application, a 45 : 1 pump and .019" to .027" tip size will provide a good spray pattern. SIPOXY-SHIELD 280 Coating may also be applied by brush or roller.

**NSF Coating System** Potable Water Tank Coating System: One to three coats of SIPOXY-SHIELD 280 in any combination of four approved colours with a maximum dry film thickness of 12 mils. Stripe coats should be applied to all sharp edges and rough welds. Water Pipe Coating System: Up to 20 mils in one coat or up to three coats of SIPOXY-SHIELD 280 in any combination of four approved colours with a maximum dry film thickness of 20 mils. Stripe coats should be applied to all sharp edges and rough welds.

**Cleaning of Equipment** Use Thinner 730.

<b>Storage Information</b>
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**Pack Size** 5 and 20 ltr. two component kits.

**Storage** Store in original sealed container, indoors, at a temperature between 5 and 40°C and relative humidity below 70%.

**Shelf Life** 1 Year

<b>Safety Information</b>
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See the material safety data sheet and product label for complete safety and precaution requirements.

<b>Disclaimer</b>
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