

SIPTAR 646

100% Solids Coal Tar Epoxy Lining

Product No. 6646

Features

- Self Priming
- New 100% solid technology for severe corrosive environment.
- High build.
- Excellent anti-corrosive properties and good impact, weather, oil and water resistance.
- Polyamine adduct cured.

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.

Physical Data

Finish : Semi-gloss

Colours : Black and Dark Brown

Volume Solids : 100%

Recommended Film Thickness:
200 - 300 microns dry

Theoretical Coverage :
10 m²/ltr. at 100 microns

Density (mixed) : 1.50 kg/ltr.

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

Tack Free : 05 Hours

Minimum recoating time : 24 Hours

Dry to Handle : 24 Hours

Maximum recoating time : 07 Days

Cured : 07 Days

Heat Resistant : 120°C dry

Flash Point : > 27°C

Specification Data

Preparation

Steel Substrate

Blast cleaning to SSPC-SP10 (Sa 2.5) with surface profile 50 - 75 microns (2 - 3 mils)

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 646 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

Mixing Ratio by Volume Base : 3 parts
 Hardener : 1 part

Mixing Advice 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.

Thinning When mixed, the paint is ready for brush or airless spray application. If thinning is desirable, use Thinner 730.

Pot Life 3 hours at 20°C

Application Conditions 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 necessary to eliminate solvent vapours for reasons of health and safety as well as to assist evaporation.

Application Methods and Details

	<u>Airless spray</u>
Recommended thinner	: Thinner 730
Thinner addition	: 5 - 10 vol. % (if required)
Nozzle orifice	: 0.21" - 0.025"
Working pressure	: 140 - 160 bar
	<u>Brush/Roller</u>
Recommended thinner	: Thinner 730
Thinner addition	: 5 vol.% (if required)

The recommended method of application is by airless spray. Use of brush or roller should be restricted to small areas only.

Cleaning of Equipment Use Thinner 730.

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.