

## **SIPTAR 644** A High Build Coaltar Epoxy

Product No. 6644

### **Features**

- Excellent anti-corrosive properties and good impact, weather, oil and water resistance.
- Polyamine adduct cured.
- Self Priming
- Approved under APCS-3.

### **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	:	Matt
Colours	:	Black and Dark Brown

Volume Solids : 68%

**Recommended Film Thickness:** 100 - 300 microns dry =147 - 441 microns wet

Theoretical Coverage: 6.8 m<sup>2</sup>/ltr. at 100 microns

Density (mixed)	: 1.45 kg/ltr.	
Drying and Recoating Ti WFT (25°C/65% RH):	mes a	at 150 microns
Touch Dry	:	02 Hours
Minimum recoating time	:	24 Hours
Hard Dry	:	36 Hours
Maximum recoating time	:	07 Days
Cured	:	07 Days
Heat Resistant	:	120°C dry
Flash Point	:	27ºC

## **Specification Data**

#### Preparation

#### **Steel Substrate**

Blast cleaning to SSPC-SP10 (Sa 2.5).

#### **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 thorough dry.

#### **Ready Primed Surface**

SIPTAR 644 may be applied over a compatible epoxy holding primer for steel or epoxy sealer for concrete.

Application Data				
Mixing Ratio by Volume	Base : 9 parts Hardener : 1 part			
Mixing Advice	Prior to application, stir the A-component, add B-component and mix thoroughly to obtain a homogeneous mixture. Use a mixer for this which is powered by air or a flameproof electric motor.			
Thinning	When mixed, the paint is ready for brush or airless spray application. If the paint is too thick, in cold weather for example, then add a small amount of the Thinner 750 / Thinner 0252 to obtain the suitable viscosity. The amount of thinner that may be added is dependent on the application conditions and methods. Overthinning will lead to poor results. Add thinner only after mixing of the components.			
Pot Life	4 hours at 20°C			
Application Details	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. <u>Airless spray</u>			
	Recommended thinner:Thinner 750Thinner addition:5 - 10 vol.%Nozzle orifice:0.019 - 0.023 inchWorking pressure:140 - 160 bar			
	Brush/Roller   Recommended thinner : Thinner 750   Thinner addition : 5 vol.%   The recommended method of application is by airless spray. Use of brush or roller should be restricted to small areas only. Strate of the st			
Cleaning of Equipment	Use Thinner 750 / Thinner 0252			
Storage Information				
Pack Size	5 and 20 ltr. two component kits.			

Storage Shelf Life 5 and 20 ltr. two component kits. Store generally in original sealed container, indoors, at a temperature between 5 and 40°C and relative humidity below 70%. 1 Year

### **Safety Information**

See the material safety data sheet and product label for complete safety and precaution requirements.

### Disclaimer

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