STEOPOX 246

Series 6E246 · Chemical-resistant internal coating for separator systems

01 PRODUCT DESCRIPTION

STEOPOX 246 is a solvent-free, pigmented two-component liquid plastic with a thixotropic setting for coating internal tank surfaces, pipes, vessels and concrete surfaces. The chemical-resistant system is particularly suitable for light-liquid separator systems and is tested to EN 858-1 and BRL 5251. Thanks to its thixotropic setting, high film thicknesses are achievable in a single pass, even on vertical surfaces. It forms a dense, mechanically high-strength and firmly adhering film, is repairable and recoatable and can be applied economically by airless spraying.

02 PRODUCT PROPERTIES

Binder system	Epoxy resin
Hardener system	Bergolin EP Hardener 7E240, colorless
Cleaning thinner	EP Thinner 5E403
Characteristics	Solvent-free · Chemicalresistant · Thixotropic · Repairable & recoatable
Color shade	RAL 5015 (further color shades on request)
Gloss	Glossy
Shelf life	18 months in the unopened original container at +4 °C to +40 °C. Protect from frost and moisture.
Mechanical resistance	Compressive strength 53 N/mm² | flexural tensile strength 59 N/mm² | adhesive tensile strength > 5 N/mm² | Shore D hardness: 80
Chemical resistance	Resistant to solvents, acids, alkalis, petrols, oils, tar, waste water and salt water (further media on request)
Thermal resistance	Up to approx. +80 °C (dry heat), briefly approx. +120 °C | up to approx. +40 °C (moist heat and water)
Electrical resistance	Non-conductive
Abrasion resistance	To ASTM D 4060: 9 mg (CS10 / 1000 g / 1000 rev.)
Container size comp. A	12 kg (further container sizes on request)
Container size comp. B	3 kg (further container sizes on request)
Approvals	Tested to EN 858-1 and BRL 5251 (internal coating for light-liquid separator systems) | One-year test against 100 % biodiesel based on DIN EN 858-1 | Tested to DIN EN ISO 2812-1 against petrol E10 and E85

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Property	Comp. A	Comp. B	Mixture
Density · DIN EN ISO 2811-1 · +20 °C *1	Approx. 1.55 g/cm³	Approx. 1.02 g/cm³	Approx. 1.40 g/cm³
VOC content · IE Directive 2010/75/EU *1	Approx. 33.6 g/l	Approx. 0 g/l	Approx. 24.71 g/l
Solid content (wt.-%) · SDS *1	Approx. 98 %	Approx. 65 %	Approx. 94 %
Viscosity · DIN EN ISO 2555 · +20 °C *1	Approx. 55,000 mPas	Approx. 400 mPas	Approx. 15,000 mPas

*1 *Depending on color shade*

03 APPLICATION

The following information may vary depending on the application. Please contact your direct contact person for more detailed information.

Substrate	Steel, zinc/aluminium, cement concrete/screed (further substrates on request)
Surface preparation	Ensure sufficient load-bearing capacity before application. **Steel:** Surface preparation to EN ISO 12944-4. Free from weld spatter, pores, overlaps, burrs, grease, oil and dirt. Blast-clean to Sa 2½, mean roughness Rz approx. 50–70 µm. Primer: 1 × 30 µm Tenaxon T 569, consumption approx. 100 g/m² at 30 µm DFT. **Zinc/aluminium:** Clean and sweep-blast. Primer: 1 × 30 µm Tenaxon T 569, consumption approx. 100 g/m² at 30 µm DFT. **Cement concrete/screed:** Surfaces must be firm, clean, free from grease, oil, wax, sand, dust and release agents, with good grip, load-bearing and free from standing water. **Optional** primer: Steopox 220, consumption approx. 300–500 g/m² depending on absorbency; if required, broadcast with kiln-dried quartz sand 0.1–0.3 mm.
Mixing ratio	4 : 1 by weight | 100 : 35 by volume
Mixing	Stir both components separately and homogenise if necessary. Pour component B into the container of component A and mix with an electric stirrer for at least 3 min at max. 700 rpm. Transfer into a clean container and mix again thoroughly for approx. 1 min.
Theoretical consumption	140 g/m² per 100 µm WFT | 140 g/m² per 100 µm DFT
Film thickness	Max. 700 µm DFT | max. 700 µm WFT per coat
Application method	Brush · Airless spraying · Trowel
Application conditions	**Air temperature** +8 °C to +30 °C **Relative humidity** max. 85 % **Surface temperature** min. +8 °C **Dew point** min. 3 °C below surface temperature For airless spraying: material and equipment temperature +20 °C to +25 °C.
Pot life*2	Approx. 45 min
Working time*2	Approx. 45 min

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Recoating interval (with itself)	Min. 12 h at +20 °C | min. 72 h at +10 °C | max. 48 h at +20 °C. After the maximum recoating time has elapsed, mechanical surface preparation (e.g. sanding or sweep-blasting) is required.
DRYING	
Dust-dry	Approx. 4 h at +20 °C | approx. 7 h at +10 °C
Walkable / sandable	Approx. 12 h at +20 °C | approx. 24 h at +10 °C
Fully cured (mech. & chem.)	Approx. 7 days
Compatible systems	Primer: Tenaxon T 569 (3E569) · Steopox 220 (2E220). Further applications on request.

[2] Low temperatures slow down drying; higher temperatures accelerate it.

Note on epoxy resin: During curing, epoxy resin is sensitive to moisture. Exposure to moisture may lead to the formation of a carbamate layer (white spots). This has a purely visual effect. Affected areas can be treated with a 10–20 % citric acid solution.

04 NOTE

This product data sheet supersedes all previously published product data sheets. The information contained herein is based on practical experience under standard conditions and assumes proper storage and processing. Substrates, materials and working conditions may vary. Therefore, no warranty or liability can be derived from the information contained in this document or from verbal consultation. It is the buyer's responsibility to verify the product's suitability for the intended use. Preliminary trials are recommended. The relevant legal regulations, the leaflets of the BG RCI and the accident prevention regulations of the responsible employers' liability insurance association must be observed. In all other respects, our General Terms and Conditions of Sale and Delivery apply.

MODIFIED BY
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APPROVED BY
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