

STEODUR EP TANKSCHUTZ 6F9 6E682

Series 6E682 · Solvent-free 2K EP tank lining for the oil and chemical industry



01 PRODUCT DESCRIPTION

Steodur EP Tankschutz 6F9 6E682 is a solvent-free, two-component epoxy resin tank lining for the highly chemical-resistant preservation of storage tanks in the oil and chemical industry. It is applied by the 2K airless hot-spray process and forms a mechanically resistant, highly chemical-resistant internal coating for storage and waste-water tanks, sewage treatment plants, cooling-water and pipelines, collecting tanks and bioreactors. It adheres directly to blasted steel (direct-to-metal) and resists petrols, aviation fuels, crude oils, mineral and hydraulic oils, diesel and heating oil, waste water and a large number of further media.

02 PRODUCT PROPERTIES

Binder system	Epoxy resin
Hardener system	EP Hardener 7E682
Cleaning thinner	EP Thinner 5E403
Characteristics	 Solvent-free  High chemical resistance  Mechanically resistant  Direct-to-metal  Thixotropic
Color shade	Oxide red
Gloss	Satin gloss
Shelf life	Approx. 12 months in the unopened original container at +4 °C to +40 °C. Protect from frost and moisture.
Chemical resistance	Resistant to petrols, aviation fuels, crude oils, mineral oils, hydraulic oils, diesel and heating oil, waste water and a large number of further media (further media on request)

Property	Comp. A	Comp. B	Mixture
Density · DIN EN ISO 2811-1 · +20 °C *1	Approx. 1.49 g/cm³	Approx. 1.47 g/cm³	Approx. 1.49 g/cm³
VOC content · IE Directive 2010/75/EU *1	0 g/l	Approx. 6.6 g/l	Approx. 2.2 g/l
Solid content (wt.-%) · SDS *1	Approx. 100 %	Approx. 96.6 %	Approx. 98.9 %
Viscosity · DIN EN ISO 2555 · +20 °C *1	Approx. 12,000 mPas	Approx. 10,000 mPas	Thixotropic

*1 Depending on color shade

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03 APPLICATION

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

Substrate	Steel
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 (G or operating mix GS). Optional primer: 1 × 30 µm Tenaxon T 569 (3E569), consumption approx. 100 g/m² at 30 µm DFT.
Mixing ratio	2 : 1 by weight 2 : 1 by volume
Mixing	Application by the 2K airless hot-spray process. Base and hardener are metered and mixed by the equipment at a 2 : 1 ratio; use equipment with an insulated and/or heated hose package.
Theoretical consumption	Approx. 1,050 g/m² at 700 µm DFT
Film thickness	Min. 700 µm max. 1,000 µm DFT
Application method	 2K hot spraying
Application conditions	 Material temperature +20 °C to +90 °C  Tank wall temperature +7 °C to +35 °C  Relative humidity < 85 %  Dew point Surface temperature min. 3 °C above dew point
Pot life	Approx. 25 min at +20 °C approx. 90 s at +60 °C (per 0.5 kg mix)
Recoating interval (with itself) ^{*2}	Intermediate drying time at +7 °C: min. 3 h · max. 24 h.
DRYING	
Fully cured (mech. & chem.)	Approx. 3 days at +20 °C approx. 7 days at +7 °C
Compatible systems	Primer steel: Tenaxon T 569 (3E569) Further applications on request.

^{*2} Values are based on laboratory measurements at +20 °C. Lower 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.

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**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

24.08.2026 – Martin Krull, Head of Laboratory

APPROVED BY

24.08.2026 – Stefan Eisenmenger, Product Management