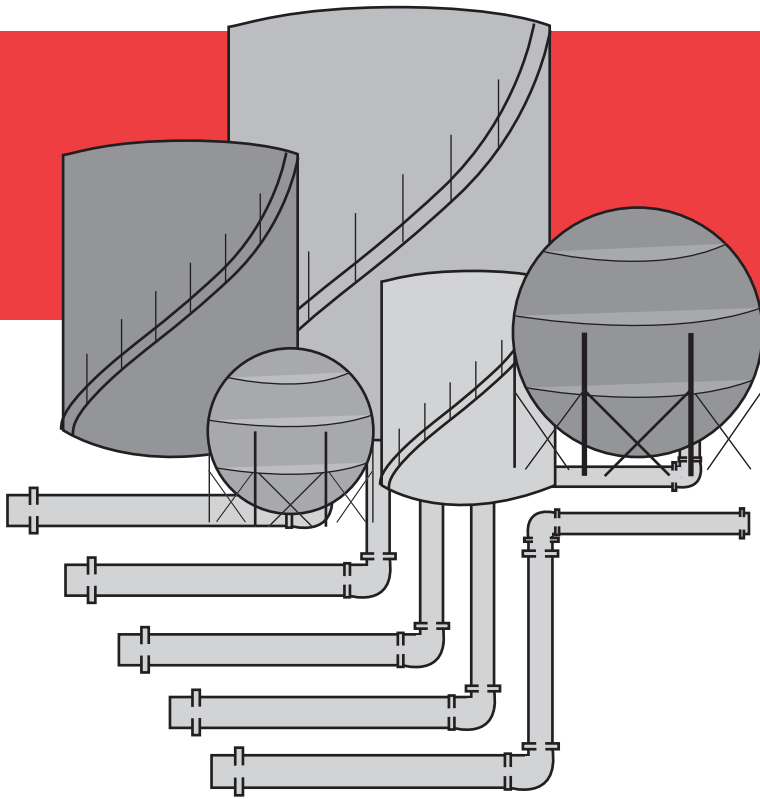


# Epi-Seal<sup>®</sup> Epoxy Seam Sealer



## Epi-Seal Epoxy Seam Sealer, for the repair of leaking seams on welded, bolted, or riveted steel storage tanks.

Epi-Seal Epoxy Seam Sealer is a two component, reinforced epoxy resin system for high efficiency repairs on steel tanks, pipes and structures. Ideal for quickly repairing and making serviceable a wide range of leaking welded, bolted, or riveted steel storage tanks. Frequently used to fill corrosion pits on steel substrates prior to painting.

Widely used to bond and seal fiberglass spacers to steel piping.  
(See [\(Epoxy Seam Sealer / FRP Spacers\)](#) literature.)

### ADVANTAGES:

- Seals leaking seams and rivets or bolts permanently.
- Unaffected by fuel and crude oil, kerosene, gasoline, furnace oil, alkalis and mild acids.
- Extremely tough, yet "gives" with tank expansion and contraction.
- Excellent adhesion to clean, or sandblasted steel surfaces.
- Easy to mix and apply.
- Will not drip or sag on vertical or overhead surfaces.
- Cure can be accelerated by application of heat.

**Available off the shelf in 1 lb. & 2 lb. kit sizes. Can be supplied in bulk.**

### PRODUCT DATA:

<b>Color</b> .....	(Base component white, curing agent black) mixed color - gray
<b>Finish</b> .....	Gloss
<b>Vehicle Type</b> .....	Epoxy resins and polyamide activators
<b>Pigment Type</b> .....	Chemical resistant pigments, fiberglass
<b>Solvent Type</b> .....	None
<b>Flash Point, minimum</b> .....	Non-flammable
<b>% Solids by Volume</b> .....	100%
<b>Recommended Dry Film</b> .	20 mils minimum (500 um) (per coat)
<b>Coverage (theoretical)</b> ....	6 sq. feet (0.5m) per pound at 20 mil build
<b>Viscosity at 75°F. (24°C)</b> .	Semi-paste
<b>Average dry time at</b> .....	To touch 4 hours. Recoat 75°F. (24°C) 8-10 hours
<b>Recommended thinner</b> ...	None normally required
<b>Recommended use</b> .....	Sealing of leaking seams on bolted or riveted tanks. To fill large gaps or crevices 1/8" to 1/4" (3-6mm) wide, add a small amount of silica sand to mixture to increase consistency.
<b>Recommended primer</b> ....	None required
<b>Surface preparation</b> .....	Blast cleaning recommended
<b>Application</b> .....	Short fibered brush, spatula, glove, etc.
<b>Pot life</b> .....	1 hour at 75°F. (24°C)- 1/2 hour at 95°F (35°C)
<b>Caution</b> .....	A minimum of 24 hours cure time at 75°F (24°C) must be allowed before filling tanks or subjecting to pressure. At least 48 hours at temperatures below 65°F (18°C)
<b>Note</b> .....	Do not use for heated tanks where metal temperature will exceed 160°F (71°C)

## PHYSICAL PROPERTIES:

---

	24 hr. 72°F cure	7 day 72°F cure
Tensile Shear @ 76°F ..... ASTM D1002	2,618 psi	2,892 psi
Tensile Strength ..... ASTM D638	2,004 psi	3,661 psi
Flexural Strength ..... ASTM D790	5,570 psi	5,518 psi
Compressive Yield Strength ... ASTM D695	2,400 psi	3,910 psi
Flexural Bond Strength ..... Fed. Spec. MMM-A-1754 4.4.2	322 psi	274 psi
Elongation .....	1 1/2%	
Ratio by Weight -50 -50	Ratio by Volume -47 (Resin) -53 (Activator)	
Excellent Resistance to:	Fresh/salt water, kerosene, gasoline, crude oil, alkalies, mild acids, solvents.	

---

## APPLICATION INSTRUCTIONS

### SURFACE PREPARATION:

1. The liquid level inside the tank to be repaired must be maintained below the leaking seams and rivets to be repaired. (Level should be maintained below repaired area for 48 hours minimum after application.)
2. Sandblast to a commercial finish an area 2" to 3" on each side of the seam and a minimum of a 1" circle on the shell surface around each rivet. (For spot repairing of seams, sandblast 18" to 24" beyond each end of the leaking area.)
3. After sandblasting, there often appears some seepage of product entrapped between the plates. It is essential that this be wiped clean

using a solvent such as toluol, MEK, chloroethene, etc. (Any solvent which evaporates fast and leaves no film.)

**Paint remover should never be used.**

---

### APPLICATION OF SEAM SEALER:

**SEAM SEALER should be applied immediately following sandblasting - normally the area blasted in one scaffold drop. SEAM SEALER should not be applied at temperatures below 50°F or when surfaces are moist.**

1. Brush away all residue from sandblasting with stiff painters duster.
2. Mix the SEAM SEALER in accordance with instructions appearing on cans. The pot life, or working time, of a mixed unit is approximately 1-1 1/2 hours at 75°F - longer at lower temperatures, shorter at higher temperatures.

To prevent waste and permit easy mixing, use a heavy duty can opener to remove the lips of the cans prior to combining the epoxy resin and hardener. For easier cool temperature mixing, warm the seam sealer to 100°-110°F.

3. Using a stiff short brush or gloved finger, apply SEAM SEALER along the seams with sufficient pressure to force it into space between plate edges. Build up a 1/4" fillet so that the material covers the edge of the overlapping plate. Spread or flare out almost one inch each side of seam.
4. Rivet heads should be completely coated with a minimum thickness of 1/8" and extending approximately 1" around the rivet. Application with a gloved finger is an easy way to apply to rivets.
5. Liquid level inside the tank should not be raised for 48 hours or more after application. If temperature is below 70°F, it is desirable to allow an additional 24 hours.

**REMEMBER, THE BETTER THE SURFACE PREPARATION, THE BETTER THE BOND.**

#### WARRANTY

This product has been designed for use by persons having practical skill and experience in the application of industrial epoxy materials. Before applying the user shall determine the suitability of this product for the intended use. Seller has no control over specific application of this product. The seller's sole warranty with respect to this product is that the product is of merchantable quality and the materials meet quality control standards, established by the manufacturer. Seller makes no other warranty, expressed or implied, and the seller disclaims all warranties except as set forth herein. Seller shall not be liable under any circumstances for consequential or incidental damages. Seller shall not be liable for any damage caused by storms, lightning, earthquakes, icing or other acts of nature. Seller's liability for breach of warranty hereunder is limited to the purchase price of the quantity of the seller's product proved to be defective.