



# EPOXY PETROL TANK SEALANT

The ultimate cure against leaking and rusted tanks

## Manual

### Epoxy coating for the inside of petrol and oil tanks

#### Applications and features

Petrol tanks that are porous or rusted on the inside, can be treated successfully with the Tank Cure system. The result is a plastic layer that seals small holes and prevents rust formation. The Tank Cure system has been used successfully for many years in various countries in Europe. For environmental reasons, increasing percentages of Bio-Ethanol have been added to petrol in recent years. As a result, the requirements for Tank Cure Sealant are becoming increasingly higher. This addition will also increase the risk of rust formation in the tank. To obtain sufficient layer thickness on the inside, a set of 450 grams of Tank Cure Sealant is required for a tank of 15 - 20 liters.

#### Comments

Through extensive laboratory testing it has been determined that with a strong increase of added Bio-Ethanol, the durability of the coating is reduced. Tank Cure has been extensively tested and found suitable for fuel with a Bio-Ethanol content of up to 10% (E10). When a petrol tank is treated with Tank Sealant it is recommended not to use aggressive carburetor cleaners in the petrol, because it can affect the coating.

#### Mixing of the components

A set of Tank Cure Tank Sealant consists of base component A and hardener component B in the right mixing ratio. There is sufficient space in the packaging of the A-component to add the B-component for mixing. After removing the red cap from the B-component canister, remove the aluminum seal completely to allow the canister to drain completely. Then stir the components intensively for a few minutes with a stirring stick. To prevent mixing errors, the mixture should be poured into a clean container or mixing cup and stirred well again. If only a portion is used, carefully weigh both components in the correct mixing ratio (100:50 parts by weight).

## Processing in 3 steps

#### Step 1: Tank Cure Cleaner

The inside of the petrol tank should be cleaned well with Tank Cure Cleaner. For an average motorcycle tank 0.5 liter Tank Cure Cleaner is needed. Shake the tank regularly. Drain the Tank Cleaner after some hours. When the petrol tank is very dirty, let the Tank Cure Cleaner work in overnight. Rinse the tank well with water and let it dry.

#### Step 2: Tank Cure Rust Remover

Treat the tank with Tank Cure Rust Remover, even when there is no rust. This not only removes rust, but also etches the surface ensuring good adhesion of the sealer can be obtained. Old tanks are often rusty on the inside, but newer tanks can also be affected by rust due to the use of petrol with added Bio-Ethanol .

Rust can be removed with Tank Cure Rust Remover. The Rust Remover works best when it has a temperature above 25 °C. By adding a hand of coarse gravel or chipboard screws and regularly shaking the tank back and forth, the rust can be properly loosened and removed. **Do not leave the Tank Cure Rust Remover in the tank for too long.** Inspect the tank regularly to ensure that all rust has been removed. After this treatment remove the Rust Remover and rinse the tank well with water. Directly afterwards dry the petrol tank thoroughly to prevent rust formation. A hair dryer is a useful tool.



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### Step 3: Tank Cure Sealant

**Preparation:** Remove tap(s) and close all openings except for the filler cap, but make sure that you have a substitute for the filler cap available to shut this opening at a later stage. Tap holes can be shut with a bolt with non-adhesive tape. This guarantees that the inside thread of the tap will not be covered by the sealant. It is recommended to wrap the outside of the tank with a plastic foil or a bag to avoid spilling on the outside. Just leave an opening at the filler cap that can be taped. Before applying the sealant, the tank should be completely dry internally.

**Applying:** Make sure that the coating and the tank in which it is applied, have a temperature of at least 20°C, so the coating can spread properly. Sometimes it may be advisable to gently heat the tank with a hairdryer. When the Tank Cure Coating has been mixed according to the description, the tank can be filled. Close the filling opening. Slowly rotate the tank in all directions so the coating spreads evenly on the entire interior. Do this for 15 to 20 minutes and then drain the remaining liquid through the filling opening. Now remove the seals from the fuel tap opening and check the thread inside. Clean these with acetone if necessary. Remove the plastic foil/bag and check that there are no splashes on the outside of the tank, which must be removed immediately. Leave the tank open after treatment. The tank can be used again after 7 days of curing at room temperature.

## Practical tips

Old layers of paint, rust or contamination can cause poor adhesion of the Tank Cure Sealant.

Sometimes petrol tanks have small pin holes in the bottom. Before treatment, these holes should be sealed with tape on the outside. After tapping off the excess liquid, the petrol tank should be put away in such a position that the porous spots are the lowest point. On these spots you get a thicker layer. Ventilation tubes in modern petrol tanks should be plugged before coating. Remove the plugs before the sealant starts to harden. To free the ventilation tubes from excess sealant, use compressed air to open them up.

Although we are convinced of the quality of our product, a good result is very much dependent on the way you prepare the petrol tank and handle the sealant .

**Safety:** Take the required safety measures during processing and ensure sufficient ventilation and/or personal protective equipment. For detailed information, please refer to the product safety data sheet.

<b>Mixing ratio by weight</b>	<b>A : B = 100 : 50</b>
<b>Processing temperature</b>	At least 20 °C
<b>Processing time</b>	30 minutes by 20 °C 15 minutes by 30 °C
<b>Hardening time</b>	7 days at 20°C
<b>Packaging</b>	Sets of 450 grams and 600 grams
<b>Shelf life</b>	12 months in sealed package
<b>Storage</b>	Store dry and free of frost

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#### Disclaimer

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