

# Dip tanks - factory finished joinery

## Application guidelines

### Design tips

- The tank should be manufactured from corrosion resistant materials for use with waterbased products.
- Ensure the tank is installed clear of the floor and fit a drain valve to allow the tank to be emptied for cleaning.
- A close fitting lid is essential to minimise contamination and evaporation.
- The tank should be situated in a warm, draught free area and ideally kept above 10oC to prevent product performance issues. Under no circumstance should the tank or stored material go below 5oC.
- The size and proportions of the dip tank should be appropriate to the operation. For example, a long, thin design allows larger frames to be dipped in component form. Minimising the surface area and volume of the tank simplifies maintenance and cleaning and ensures the product is regularly refreshed.
- 'Run off' or drip areas should be designed to allow recirculation of the excess material to reduce wastage. A heavy duty polythene cover on adjacent floors will facilitate regular cleaning of the area.
- Circulation pumps with in-line filters can be used for larger tanks to keep the material fresh and clean. For smaller tanks, regular filtering and refilling may be more appropriate.



### Dip tank maintenance

- Ensure the tank is covered when not in use. Stir the product at least twice a day, and always before use, with a clean stirring stick.
- Check the viscosity of opaque primers using a Din Cup 4 prior to use. The target viscosity for opaque primers is 12.5 to 13 seconds Din 4, but some products do vary so please contact Teknos for further information.
- Base coat stains do not need viscosity adjustment. If there are signs of poor run off, this could be due to either dust contamination in the tank or low pH of the product, in either case, please contact Teknos for further advice.
- Preservatives, such as **TEKNOL AQUA 1410**, should be tested every few months to ensure the solid content remains at the require level. We can arrange for these tests to be carried out and advise you of any required adjustments.
- Any adjustments made to the material must be carried out using clean water to prevent bacterial contamination and in accordance to product information supplied by Teknos.
- Do not keep stirring sticks in a bucket of water as bacterial contamination can occur.
- All material must be filtered regularly to prevent contamination of the tank and the product. We can supply a 125µm micron filter bag (part number 1542981) and give further advice on good working practice.

*For low volume manufacturers, dip tanks offer a cost effective method of applying base stain and preservatives.*