



**SHALIMAR
PAINTS**

TUFFKOTE

PROTECTIVE COATINGS

BIPIGARD 580 HB CTE BLACK

Data Sheet No. SPL/PMG/2019100061

A two component amine-adduct cured high build coal tar epoxy paint giving very good toughness and water resistance. The product performs extremely well in total, partial or intermittent immersion in salt or fresh water. It is suitable for soil immersion and also certain acidic and alkaline environments. Bipigard 580 HB CTE BLACK can be used with cathodic protection systems.

Product Information

Color	Black
Finish	Semigloss
Flash Point	Above 23°C
Mixing Ratio (By Volume)	Base : Accelerator 10 : 1
Volume Solids	80 ± 3 %
Recommended dry film thickness	150 – 200 microns
Corresponding wet film thickness	190 - 250 microns
Theoretical Spreading Rate	5.3 – 4.0 Sq.m/ltr
Drying time @ 30°C	Surface dry 18 hours Handleable 48 hours Full curing 7 days
Interval before Over-coating	Minimum 24 - 48 hours Maximum 7 days
Volatile organic Compound (VOC)	170 gm/ltr (EPA Method 24)
Storage Life	12 months minimum @ 30°C if stored in a dry sealed container at shaded condition away from heat source and ignition
Dry Heat Resistance	Up to 120°C (Intermittent)

Surface Preparation

Steel Surface

Surface must be clean, dry & free from contamination. Prior to paint application all surfaces should be assessed and treated in accordance with ISO 8504:2000. Abrasive blast clean to SA 2½ is recommended. If Abrasive blast cleaning is not possible it is recommended to hand tool/ power tool cleaning up St2 or St3 before application of this this product.

Concrete Substrate

Ensure that the surface is cured for minimum 28 Days. Remove laitance, loose surface powder by light sand blasting. If blast cleaning is not feasible, roughen the surface by acid etching with 10% Hydrochloric Acid solution followed by thorough freshwater hosing to remove any residual acid. The surface should be perfectly dry and clean before applying this coat.

For damage area rectification please contact the Technical team of Shalimar Paints Limited

Application Details

Method of Application

Airless Spray/Brush/Plural Component gun

Notes on Airless Spray

Tip Range	23 – 27 thou.
Total Output Fluid	2700-3500 psi.
Pressure	(176 - 211 kg/sq.cm.)
Pot Life	2 – 4 hours
Thinner	Thinner 6756

Uses

For use as topcoat in Sluice gate, Barrage Gates, Pipes, Penstocks, Storage Tank, Structural Works in Power Plants, Fertilizer Plants, Chemical Factories and Concrete bridges etc

Typical System Selection Guide

SURFACE	1 ST COAT	2 ND COAT	3 RD COAT	4 TH COAT
Steel	Epigard Zinc Rich / Tuffkote Zilicate / Epigard Zinc Phosphate Primer	BIPIGARD 580 HB CTE BLACK	BIPIGARD 580 HB CTE BLACK	-
- Do -	- do -	Epigard HB MIO Brown/Grey	Bipigard 580 HB CTE BLACK	Bipigard 580 HB CTE Black
- Do -	Epiplus556	BIPIGARD 580 HB CTE BLACK	BIPIGARD 580 HB CTE BLACK	-
Concrete Surface	Epigard HP Off White Primer / Bipigard CTE XL Brown / Black	- do -	- do -	-

Chemical Resistance Guide (with suitable top coat)

EXPOSURE	Acids	Alkalis	Solvents	Salt	Water
SPLASH & SPILLAGE	Good	Excellent	Good	Excellent	Excellent
FUMES & OUTDOOR EXPOSURE	Good	Excellent	Very Good	Excellent	Excellent

Health & Safety

Use Proper Personal Protective Equipment(PPE) during application of this product.

Please consult Material Safety Datasheet (MSDS)

Precaution

Provide adequate ventilation during application and drying. Clean Spray gun equipment and hose immediately after application of material.

Standard Pack Size

11 & 22 litres - For available pack size contact local representative of Shalimar Paints Limited

NOTES:

1. This Product datasheet supersedes all previous datasheet and subject to change without prior notice
2. Do not apply when surface temperature is less than 3 °C than dew point.
3. Mixing with mechanical agitator is strongly recommended
4. Use material within stipulated pot life
5. Do not apply paints when environment temperature rises above 50 °C or when relative humidity rises above 85%. Do not apply during rain, fog or mist.
6. Use of thinners other than supplied or approved by Shalimar may adversely affect product performance
7. Drying is dependent on temperature, relative humidity and thickness; ranges is given for considering those parameters
8. System Guide is a typical and for indicative purpose only, however this can have wide range of combination. For details, please contact Shalimar Paints limited
9. Request for details information of surface preparation, paint application on the recommended coating system

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