



**SHALIMAR  
PAINTS**

# TUFFKOTE

## PROTECTIVE COATINGS

### EPIGARD 4 ROZP

Data Sheet No. SPL/PMG/2019100001

A two component polyamide cured, epoxy anticorrosive primer containing Zinc phosphate pigment. The red version contains red oxide of iron apart from zinc phosphate. The primer gives excellent adhesion to steel. This also gives excellent water Permeability. It is compatible with a wide range of topcoats.

### Product Information

<b>Color</b>	Grey / Red Oxide
<b>Finish</b>	Matt to Eggshell
<b>Flash Point</b>	Above 23°C
<b>Mixing Ratio (By Volume)</b>	Base : Accelerator 3 : 1
<b>Volume Solids</b>	42 ± 2 %
<b>Recommended dry film thickness</b>	30 – 35 microns
<b>Corresponding wet film thickness</b>	70 - 85 microns
<b>Theoretical Spreading Rate</b>	14.0 – 12.0 Sq.m/ltr
<b>Drying time @ 30°C &amp; RH -50</b>	Surface dry 2 - 3 hours Handle dry 6 - 8 hours Full cure 7 days
<b>Interval before Over- coating</b>	Minimum 18 hours Maximum 7 days
<b>Volatile organic Compound (VOC)</b>	500 gm/ltr (EPA Method 24)
<b>Storage Life</b>	12 months minimum @ 30°C if stored in a dry sealed container at shaded condition away from heat source and ignition.
<b>Dry Heat Resistance</b>	Up to 150°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 clean to St2 or St3 before application of this product.

*For Damage area rectification contact the Technical team of Shalimar Paints Limited*

### Application Details

#### Method of Application

Air Spray / Airless Spray/ Brush / Roller

#### Notes on Airless Spray

Tip Range	15 – 21 thou.
Total Output	2500 – 3000 psi.
Fluid Pressure	(176 - 210 kg/sq.cm.)
Pot Life	4 - 8 hours
Thinner	Thinner 6756

#### Notes on Air Spray

Nozzle Orifice – 1.2 mm to 3 mm  
Nozzle Pressure – 0.3-0.4 Mpa

### Uses

Suitable as primer for fertilizer, Refineries, Petrochemicals, Pulp & Paper, Chemicals and other industries where high performance coating system are required.

### Typical System Selection Guide

SURFACE	1 <sup>ST</sup> COAT	2 <sup>ND</sup> COAT	3 <sup>RD</sup> COAT	4 <sup>TH</sup> COAT
Steel	Epigard 4 ZP Primer	Epigard HB MIO Brown / Grey	Epigard Finish/ Shalithane Finish/ Shalithane HB Finish	Epigard Finish/ Shalithane Finish/ Shalithane HB Finish
- Do -	Epigard 4 Z P Primer	Epigard XL HB finish	Epigard XL HB finish	-
- Do -	Epigard 4 Z P Primer	Bipigard CTE XL Black / 580 HB CTE Black	Bipigard CTE XL Black / 580 HB CTE Black	-
- Do -	Epigard 4 Z P Primer	Chlorokote Intermediate	Chlorokote Finish/Chlorokote HB Finish	

### Chemical Resistance Guide (with suitable top coat)

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

### 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

20 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 potlife
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

**DISCLAIMER:** This PDS is by no means a comprehensive data. The company will not be liable for losses or damages howsoever caused including liability for negligence, which may be suffered by the user of the data contained therein. It is the user's responsibility to conduct all necessary tests to confirm the suitability of any product or system for their intended use. No guarantee of result is extended since conditions of use are beyond our control. Liability is limited to replacement of the product hence cost of labour charges or consequential damages are excluded.