



**SHALIMAR  
PAINTS**

# TUFFKOTE

## PROTECTIVE COATINGS

### EPIGARD 5 HB ZINC PHOSPHATE PRIMER

Sheet No. SPL/PMG/2019100005

A two pack polyamide cured modified epoxy high build primer with zinc phosphate pigment for excellent protection to steel in severely corrosive environment . The red version contains red oxide of iron apart from zinc phosphate.

#### Product Information

<b>Color</b>	Grey / Red
<b>Finish</b>	Matt
<b>Flash Point</b>	Above 23°C
<b>Mixing Ratio (By Volume)</b>	Base : Accelerator 5 : 1
<b>Volume Solids</b>	55 ± 3 %
<b>Recommended dry film thickness</b>	75 – 100 microns
<b>Corresponding wet film thickness</b>	135 - 180 microns
<b>Theoretical Spreading Rate</b>	7.33 – 5.5 Sq.m/ltr
<b>Drying time @ 30°C &amp; RH -50</b>	Surface dry      2 - 3 hours Handle dry      4 – 6 hours Hard dry        10-14 hours Full cure        7 days
<b>Interval before Over-coating</b>	Minimum        18 hours Maximum        7 days
<b>Volatile organic Compound (VOC)</b>	390 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.

*For Damage area rectification and hand tool and power tool cleaning 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	21 – 26 thou.
Total Output Fluid	2500 – 3000 psi.
Pressure	(176 - 210 kg/sq.cm.)
Pot Life	3 - 5 hours
Thinner	Thinner 6756

##### Notes on Air Spray

Nozzle Orifice – 1.2 mm to 1.8 mm  
Nozzle Pressure – 0.3-0.4 Mpa

#### Uses

Suitable for use for new constructions for as a primer for wide range of Anti-corrosive system for various industries like offshore, petrochemical, chemical, Pulp & paper, pipe coating.

## EPIGARD 5 HB ZINC PHOSPHATE PRIMER

### 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 5 HB Zinc Phosphate Primer	Epigard XL HB MIO/ Epigard HB MIO	Epigard 4 Finish / Epigard Finish/ Epigard XL HB finish/ Shalithane Finish /Shalithane HB Finish	Epigard 4 Finish / Epigard Finish/ Epigard XL HB Finish/ Shalithane Finish /Shalithane HB Finish
- Do -	- do -	Epigard DT HB finish	Epigard DT HB finish	-
- Do -	- do -	Bipigard CTE XL / Bipigard 580 HB CTE	Bipigard CTE XL / Bipigard 580 HB CTE	-

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

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

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.