



**SHALIMAR
PAINTS**

TUFFKOTE

PROTECTIVE COATINGS

EPIGARD HB ZINC RICH PRIMER

Data Sheet No. SPL/PMG/2019100095

A two pack polyamide cured epoxy primer containing metallic zinc pigment. It is ideally suited for priming all types of structural steel work following blast cleaning, providing a protective film and giving excellent results on outdoor exposure when it is coated with suitable intermediate and topcoat. It has good resistance to undercutting at damaged areas.

Product Information

Color	Grey
Finish	Matt
Flash Point	Above 25° C
Mixing Ratio (By Volume)	Base : Accelerator 4 : 1
Volume Solids	55 ± 3 %
Recommended dry film thickness	65 - 100 microns
Corresponding wet film thickness	118 - 142 microns
Theoretical Spreading Rate	8.64 – 5.5 Sq.metre/litre
Drying time @ 30°C & RH -50	Touch dry 35-60 minutes Handle dry 4 – 6 hours Hard Dry 8 -12 hours Full cure 7 Days
Interval before Over-coating @ 30°C & RH -50	Minimum 12 hours Maximum Indefinite
Dry Heat Resistance	Up to 200°C (intermittent)
Volatile organic Compound (VOC)	390 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.

Surface Preparation

Steel Surfaces

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 strongly recommended.

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

Application Details

Method of Application

Brush / Airless Spray/ Air Spray

Notes on Airless Spray

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

Notes on Air Spray

Nozzle Orifice – 1.4 mm to 3 mm
Nozzle Pressure – 0.3-0.4 Mpa

Limitations

Being Zinc based the coating is not resistant to acid and alkali solutions.

Uses

A superior Zinc Rich Primer for protection of Refineries, Power Plants, Petrochemical units, Gas Plants, Fertilizer Units, pen stock, sluice gates etc.

Typical System Selection Guide

SURFACE	1 ST COAT	2 ND COAT	3 RD COAT	4 TH COAT
Steel	Epigard HB Zinc Rich Primer	Epigard MIO Intermediate	Epigard Finish / Shalithane Finish	Epigard Finish / Shalithane Finish
- Do -	Epigard HB Zinc Rich Primer	Bipigard CTE XL / Bipigard 580 HB CTE	Bipigard CTE XL Black / Bipigard 580 HB CTE	-

Chemical Resistance Guide (with suitable top coat)

EXPOSURE	Acids	Alkalis	Solvents	Salt	Water
SPLASH & SPLIAGE	Good	Good	Excellent	Excellent	Excellent
FUMES & OUTDOOR EXPOSURE	Good	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.

Pack Size

4 & 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 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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