



**SHALIMAR
PAINTS**

TUFFKOTE

PROTECTIVE COATINGS

EPIGARD HBN PRIMER

Data Sheet No. SPL/PMG/2019100064

A two pack polyamide cured heavy duty epoxy anticorrosive primer containing Zinc phosphate pigment. The red version contains red oxide of iron along with zinc phosphate. The primer gives excellent adhesion to steel. It is compatible with a wide range of topcoats. This coating when applied with proper intermediate and topcoat provide highly efficient protective system for corrosive environments.

Product Information

Color	Grey / Red
Finish	Matt
Flash Point	Above 23°C
Mixing Ratio (By Volume)	Base : Accelerator 5 : 1
Volume Solids	40 ± 2%
Recommended dry film thickness	35 - 50 microns
Corresponding wet film thickness	90 - 125 microns
Theoretical Spreading Rate	11.4 – 8.0 Sq.m/ltr
Drying time @ 30°C & RH -50	Surface dry 1 - 2 hours Handle dry 6 - 8 hours Hard Dry 16-18 hours Full cure 7 days
Interval before Over-coating	Minimum 18 hours Maximum 7 days
Volatile organic Compound (VOC)	550 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 SA2½ 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

Brush / Roller / Spray

Notes on Airless Spray

Tip Range	15 – 21 thou.
Total Output Fluid	2500 – 3000 psi.
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 ST COAT	2 ND COAT	3 RD COAT	4 TH COAT
Steel	Epigard HBN Primer	Epigard HB MIO EPIGARD XL HBN MIO	Epigard Finish	Epigard Finish
- Do -	-do-	Epigard XL HB 533 / Shalithane HB Finish	Shalithane HB Finish/ Shalithane HBN Finish	-
- Do -	-do-	Bipigard CTE XL Black / 580 HB CTE	Bipigard CTE XL Black / 580 HB CTE	-

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.

Pack Size

1,4 & 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 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

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