



**SHALIMAR
PAINTS**

TUFFKOTE

PROTECTIVE COATINGS

EPIGARD RC DTM

Data Sheet No. SPL/PMG/2019100197

A two pack polyamide cured unicoat – direct to metal (DTM) epoxy high build rapid cure primer cum Finish with a high level of anti-corrosive Zinc phosphate pigment loading for excellent protection to steel in corrosive environment. It is ideal for application in areas where higher thickness is required with quick drying & rapid cure as direct to metal . It has an excellent mechanical strength & resistance to splash, spillage & fumes of chemicals.

Product Information

Color	Selected Range
Finish	Eggshell to Semi Gloss
Flash Point	Above 23°C
Mixing Ratio (By Volume)	Base : Accelerator 4 : 1
Volume Solids	70 ± 3 %
Recommended dry film thickness	75 - 150 microns
Corresponding wet film thickness	105 - 215 microns
Theoretical Spreading Rate	9.33 – 4.66 Sq.m/ltr
Drying time @ 30°C	Touch dry 30 minutes Hard dry 60 minutes Full cure 7 days
Interval before Over-coating	Minimum 60 minutes Maximum Indefinite
Volatile organic Compound (VOC)	250 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)

Uses

Suitable as DTM for PEB industries.

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

Airless Spray/Air spray/ Brush / Roller

Notes on Airless Spray

Tip Range	19 – 29 thou.
Total Output	2100-3000 psi.
Fluid Pressure	(147-210 kg/sq.cm.)
Pot Life	6 - 8 hours
Thinner	Thinner 6756

Notes on Air Spray

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

Limitations

In common with all epoxies, this product may chalk on exposure. Discolouration also occurs under certain exposure conditions, but this is not detrimental to coating's performance. The product is not recommended for immersion service in acids, alkalis and water.

Typical System Selection Guide

SURFACE	1 ST COAT	2 ND COAT	3 RD COAT	4 TH COAT
Steel	EPIGARD RC DTM	EPIGARD RC DTM	SHALITHANE HPUV FD	-

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

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

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.