



**SHALIMAR
PAINTS**

TUFFKOTE

PROTECTIVE COATINGS

EPIGARD TL HB INTERMEDIATE

Data Sheet No. SPL/PMG/20191000151

A two pack amine-adduct cured high build epoxy coating specially formulated as high performance intermediate coat for medium to highly aggressive structural steel.

Product Information

| | |
|---|--|
| Colour | Selected Range |
| Finish | Eggshell to Semi gloss |
| Flash Point | Above 23°C |
| Mixing Ratio (By Volume) | Base : Accelerator 4 : 1 |
| Volume Solids | 60±3% |
| Recommended dry film thickness | 100 - 125 microns |
| Corresponding wet film thickness | 167 – 208 microns |
| Theoretical Spreading Rate | 6.0 – 4.8 Sq.m/ltr |
| Drying time @ 30° C | Touch dry 2 - 4 hours Handle dry 10 - 12 hours Full cure 7 days |
| Interval before Over-coating | Minimum 18 hours Maximum 7 days |
| Volatile Organic compound (VOC) | 350 gm/ltr (EPA Method 24) |
| Storage Life | Up to 12 months so long as the material is stored in a sealed containers under standard warehouse storage conditions |
| Dry Heat Resistance | Up to 150°C (Intermittent) |

Uses

As tank lining for MS storage tanks in refineries, petrochemical units, fertilizer plants, oil installations, etc.

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.

it is recommended to hand tool/ power tool cleaning upto St2 or St3 before application when abrasive cleaning is not possible.

This product can be applied on tightly adhered aged/old Coating.

For damage area rectification and concrete coating, please contact the Technical team of Shalimar Paints Limited.

Application Details

Method of Application

Brush/ Airless spray/Air Spray

Notes on Airless Spray

| | |
|----------------|-----------------------|
| Tip Range | 23 - 26 thou. |
| Total Output | 2500 - 3500 psi. |
| Fluid Pressure | (176 - 246 kg/sq.cm.) |
| Pot Life | 1 to 1.5 hour |
| Thinner | Thinner 6756 |

Notes on Air Spray

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

Limitations

The finish tends to chalk when exposed to sunlight although protective properties of the film remain practically unaffected.

System Selection Guide

| SURFACE | 1 ST COAT | 2 ND COAT | 3 RD COAT | 4 TH COAT |
|---------|--|-------------------------------|---------------------------|----------------------|
| Steel | Epigard Zinc Rich / Tuffkote Zilicate Primer | Epigard TL HB Internedite | Shalithane Finish | |
| - Do - | Epigard 5 HB Zinc Phosphate | Epigard TL HB Internedite | Epigard TL HB Internedite | |
| - Do - | Tuffkote Zilicate | Epigard Zinc Phosphate Primer | Epigard TL HB Internedite | Shalithane Finish |

Chemical Resistance Guide (with suitable top coat)

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