



**SHALIMAR
PAINTS**

TUFFKOTE

PROTECTIVE COATINGS

EPIGARD XL HB FINISH

Data Sheet No. SPL/PMG/2019100066

A two pack polyamide cured High Build epoxy coating specially formulated as a finish or intermediate coat for the protection of steel and concrete surfaces exposed to medium industrial corrosive environment.

Product Information

Color	Selected Range
Finish	Eggshell to Semigloss
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 gms/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 topcoat and intermediate Moderate industrial exposure in Refineries & Petrochemical Units, Power Plants, Gas Plants, Fertilizer Plants, Chemical Plants, Pulp & Paper Mills.

Surface Preparation

Steel Surface

Surface to be coated should be clean, dry and free from contamination. Prior to paint application all surfaces should be assessed and treated in accordance with ISO 8504:2000.

It is always recommended to apply suitable primer coat before application of this product. Ensure surfaces to be coated is dried and followed overcoating interval and if required sufficiently roughened by emery paper.

This product can be applied over Hand & Power tool cleaning to St2 & St3.

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	1900 – 2800 psi.
Fluid Pressure	(147- 196 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

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

Typical System Selection Guide

SURFACE	1 ST COAT	2 ND COAT	3 RD COAT	4 TH COAT
Steel	Tuffkote HB Ziliplate / Tuffkote Zilicate / Epigard Zinc Rich Primer	Epigard HB MIO	Epigard XL HB Finish	Epigard XL HB Finish
- Do -	Epigard Zinc Phosphate Primer	Epigard Zinc Phosphate Primer	Epigard XL HB Finish	Shalithane Finish
- Do -	Epiplus 56/Epiplus 556	Epigard XL HB Finish	Epigard XL HB Finish	-

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

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