



**SHALIMAR  
PAINTS**

# TUFFKOTE

## PROTECTIVE COATINGS

### EPIGARD XL SHB FINISH

Data Sheet No. SPL/PMG/20191000074

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

## Product Information

<b>Color</b>	Selected Range
<b>Finish</b>	Eggshell
<b>Flash Point</b>	Above 23°C
<b>Mixing Ratio (By Volume)</b>	Base : Accelerator 10 : 1
<b>Volume Solids</b>	80 ± 3 %
<b>Recommended dry film thickness</b>	100 - 125 microns
<b>Corresponding wet film thickness</b>	125 - 160 microns
<b>Theoretical Spreading Rate</b>	8.0 – 6.4 Sq.m/ltr
<b>Drying time @ 30°C</b>	Touch dry      1 - 2 hours Handle dry     8- 10 hours Hard dry        16-18 hours Full curing     7 days
<b>Interval before Over-coating</b>	Minimum        18 hours Maximum        7 days
<b>Volatile organic Compound (VOC)</b>	170 gm/ltr (EPA Method 24)
<b>Storage Life</b>	12 months minimum @ 30°C if stored in a dry sealed container at shaded condition away from heat source and ignition
<b>Dry Heat Resistance</b>	Up to 120°C (Intermittent)

## Uses

Suitable as topcoat 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 overs 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 <sup>ST</sup> COAT	2 <sup>ND</sup> COAT	3 <sup>RD</sup> COAT	4 <sup>TH</sup> COAT
Steel	Epigard Zinc Rich / Tuffkote Zilicate Primer	EPIGARD XL SHB FINISH	EPIGARD XL SHB FINISH	Shalithane Finish
- Do -	Epigard Zinc Phosphate Primer	Epigard Zinc Phosphate Primer	EPIGARD XL SHB FINISH	EPIGARD XL SHB FINISH
- Do -	Epiplus 556	EPIGARD XL SHB FINISH	EPIGARD XL SHB FINISH	-
Concrete Surface	Epigard HP Off White Primer	EPIGARD XL SHB FINISH	EPIGARD XL SHB 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

11 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.*