



**SHALIMAR  
PAINTS**

# TUFFKOTE

## PROTECTIVE COATINGS

### EPIGARD ZINC PHOSPHATE PRIMER

Data Sheet No. SPL/PMG/2019100002

A two component polyamide cured, epoxy anticorrosive primer containing Zinc phosphate pigment. The red version contains red oxide of iron apart from zinc phosphate. The primer gives excellent adhesion to steel. It is compatible with a wide range of topcoats.

#### Product Information

<b>Color</b>	Grey / Red
<b>Finish</b>	Matt to Eggshell
<b>Flash Point</b>	Above 23°C
<b>Mixing Ratio (By Volume)</b>	Base : Accelerator 3 : 1
<b>Volume Solids</b>	42 ± 2 %
<b>Recommended dry film thickness</b>	30 - 35 microns
<b>Corresponding wet film thickness</b>	75 - 85 microns
<b>Theoretical Spreading Rate</b>	14.0 – 12.0 Sq.m/ltr
<b>Drying time @ 30°C &amp; RH -50</b>	Surface dry 1- 2 hours Handle dry 6 - 8 hours Hard dry 10-12 hours Full cure 7 days
<b>Interval before Over- coating</b>	Minimum 18 hours Maximum Indefinite
<b>Volatile organic Compound (VOC)</b>	490 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)

#### 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

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 Power projects ,Refineries, Metal and Engineering industries like areas of tank exteriors, equipments, pipelines, structural steel etc.

## 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 phosphate Primer	Epigard HB MIO	Epigard Finish/ Epigard finish/Epigard XL HB finish/ Shalithane Finish	Epigard Finish/ Epigard Finish/Epigard XL HB Finish/ Shalithane Finish
- Do -	Epigard Zinc phosphate Primer	Bipigard CTE XL Black / 580 HB CTE	Bipigard CTE XL Black / 580 HB CTE	-
- Do -	Epigard Zinc phosphate Primer	Epigard Zinc Phosphate Primer	Epigard TL HB Finish	Epigard TL HB Finish

## 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.

## 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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