



**SHALIMAR
PAINTS**

TUFFKOTE

PROTECTIVE COATINGS

EPIPLUS 556 HB COATING

Data Sheet No. SPL/PMG/20191000781

A two pack polyamidoamine cured modified epoxy high build mastic surface tolerant mastic coating designed for application on manually cleaned steel surface. The product can be applied over most of the tightly adhering aged coatings and recommended as maintenance primer with suitable top coats.

Product Information

Color	Aluminium / Brown / Grey
Finish	Eggshell to Semigloss
Flash Point	Above 23°C
Mixing Ratio (By Volume)	Base : Accelerator 3 : 1
Volume Solids	80 ± 3 %
Recommended dry film thickness	100 - 125 microns
Corresponding wet film thickness	125 - 155 microns
Theoretical Spreading Rate	8.0 – 6.4 Sq.m/ltr
Drying time @ 30°C	Touch dry 4 - 6 hours Handle dry 18 - 24 hours Full cure 7 days
Interval before Over-coating	Minimum 24 hours Maximum Indefinite
Volatile organic Compound (VOC)	170 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

Maintenance painting for corrosive Fertilizer plants, Chemical factories, Refineries, Petrochemical units, Railway Bridges and inaccessible areas of complex structure.

Surface Preparation

Steel Surface

All surfaces 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.

This product is recommended to apply over Sa 1 abrasive cleaning and also hand/power tool cleaning to St2 (ISO 8501-1:1988).

This product can be applied on the aged coating after removing of loose coating.

For damage area rectification please contact the Technical team of Shalimar Paints.

Application Details

Method of Application

Brush / Roller / Airless Spray/ Air Spray

Notes on Airless Spray

Tip Range	21 – 29 thou.
Total Output Fluid	2100-2500 psi.
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	Epiplus 556 HB Coating	Epigard XL HB MIO/ Epigard HB MIO	Epigard XL HB Finish/ Epigard Finish	-
- Do -	- do -	Epigard XL HB MIO /Epigard HB MIO	Epigard XL HB Finish/ Epigard Finish	Shalithane Finish/Shalithane HB Finish/ Shalithane RC HB Finish
- Do -	- do -	Bipigard CTE XL / Bipigard 580 HB CTE	Bipigard CTE XL / Bipigard 580 HB CTE	-

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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