



**SHALIMAR
PAINTS**

TUFFKOTE

PROTECTIVE COATINGS

EPIGARD 988

Data Sheet No. SPL/PMG/2019100033

A specially designed two pack polyamide cured epoxy tie coat over Zinc Silicate, other Zinc primed surface and other old coated primer. It can also be used as a holding primer over freshly blasted steel. The primer gives excellent adhesion to steel. It is compatible with a wide range of topcoats and thus forms highly efficient protective schemes for corrosive, coastal and chemical environments.

Product Information

Color	Red oxide	
Finish	Matt to eggshell	
Flash Point	Above 23°C	
Mixing Ratio (By Volume)	Base: Accelerator 4 : 1	
Volume Solids	47 ± 2 %	
Recommended dry film thickness	35 - 50 microns	
Corresponding wet film thickness	75 – 105 microns	
Theoretical Spreading Rate	13.4 – 9.4 Sq.m/ltr	
Drying time @ 30°C & RH -50	Surface Dry	1– 2 hours
	Handle Dry	6 – 8 hours
	Full curing	7 days
Interval before Over-coating @ 30°C & RH -50	Minimum	18 hours
	Maximum	Indefinite
Volatile Organic Compound (VOC)	465 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 150°C (Intermittent)	

Surface Preparation

Steel Surfaces

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 8504:1992.

It is always recommended to apply recommended primer coat before application of this product. Ensure surfaces to be coated is dried and followed over-coating interval and if required sufficiently roughened if necessary by emery paper. This product can be applied over Hand & Power tool cleaning to St2 & St3.

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

Application Details

Method of Application

Airless Spray

Notes on Airless Spray

Tip Range	21 – 25 thou.
Total Output	2500 – 3500 psi.
Fluid Pressure	(176 - 246 kg/sq.cm.)
Pot Life	3-4 hours
Thinner	Thinner 6756

For Air Spray please contact the Technical team of Shalimar Paints.

Uses

Mainly used as a tie coat over zinc primed surface in heavy duty coating systems for Onshore and Offshore applications.

Typical System Selection Guide

SURFACE	1 ST COAT	2 ND COAT	3 RD COAT	4 th Coat
Steel	Epigard zinc rich primer / Tuffkote silicate CGC	Epigard 988	Epigard Finish/Shalithane Finish	Epigard Finish / Shalithane Finish
- Do -	Epigard zinc rich primer / Tuffkote silicate CGC	Epigard 988	Bipigard CTE XL / Bipigard 580 HB CTE	Bipigard CTE XL / Bipigard 580 HB CTE
- Do -	- do -	- do -	Shalithane HB Finish	Shalithane HB Finish

Chemical Resistance Guide (with suitable top coat)

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