



**SHALIMAR
PAINTS**

TUFFKOTE

PROTECTIVE COATINGS

SHALITHANE HBN FINISH

Data Sheet No. SPL/PMG/2019100068

A two pack glossy polyurethane cured with aliphatic polyisocyanate top coat with excellent protection properties in industrial corrosive environment. This coating has excellent toughness.

Product Information

Color	Selected Range
Finish	Matt to Satin
Flash Point	Above 23°C
Mixing Ratio (By Volume)	Base : Accelerator 10 : 1
Volume Solids	55 ± 3%
Recommended dry film thickness	40 – 60 microns
Corresponding wet film thickness	73 - 109 microns
Theoretical Spreading Rate	13.75 – 9.1 Sq.m/ltr
Drying time @ 30°C	Surface dry 2 – 2.5 Hours Hand Dry 8 - 12 Hours Hard Dry 14-18 Hours Full cure 7 Days
Interval before Over- coating	Minimum 14 Hours Maximum 5 Days
Volatile organic Compound (VOC)	390 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)

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 over-coating interval and if required sufficiently roughened by emery paper.

This product can be applied 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 / Airless Spray/Air 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	PU Thinner

Notes on Air Spray

Nozzle Orifice – 0.8 mm to 1.2 mm
Nozzle Pressure – 0.3-0.4 Mpa

Uses

Suitable as topcoat at Oil Refineries, Fertiliser Plants, Petrochemical Units, Marine Installations, Chemical Plants, Transportation Industries, Power Plants, Rail coach & Chemical wagon exteriors, Offshore Structures in mild corrosive environment.

Typical System Selection Guide

SURFACE	1 ST COAT	2 ND COAT	3 RD COAT	4 TH COAT
Steel	Epigard Zinc Rich Primer /Tuffkote Zilicate	Epigard HB MIO Brown /Grey or Epigard XL HBN MIO Brown /Grey	Shalithane HBN Finish	Shalithane HBN Finish
- Do -	Epigard Zinc Phosphate Primer/Epigard HBN primer red/grey	Epigard HB MIO Brown /Grey or Epigard XL HBN MIO Brown /Grey	- do -	- do -
- Do -	Epiplus 556	Shalithane HBN Finish	- do -	- do -

Chemical Resistance Guide (with suitable top coat)

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

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 potlife
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.