



**SHALIMAR  
PAINTS**

# TUFFKOTE

## PROTECTIVE COATINGS

### SINGLE PACK EPOXY ZINC RICH PRIMER

Data Sheet No. SPL/PMG/2019100094

A Single pack epoxy primer containing metallic zinc pigment (more than 90% Zinc on pigmentation) render excellent protection to Ductile iron pipes. It provides cathodic protection also gives good resistance to under film creeping corrosion at damaged areas. It is compatible with lots of topcoats. This also complies with the composition and performance requirements of SSPC Paint 20 Level 1.

#### Product Information

<b>Color</b>	Grey
<b>Finish</b>	Matt
<b>Flash Point</b>	Above 23°C
<b>Volume Solids</b>	38 ± 3 %
<b>Recommended dry film thickness</b>	70 -90 microns
<b>Corresponding wet film thickness</b>	185 - 240 microns
<b>Theoretical Spreading Rate</b>	5.4 – 4.2 Sq.m /ltr
<b>Drying time @ 30°C &amp; RH -50</b>	Touch dry 10 minutes Handle dry 4 - 12 hours Full cure 7 days
<b>Interval before Over-coating</b>	Minimum – 18 hours Maximum – Indefinite
<b>Volatile organic Compound (VOC)</b>	535 gms/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 300°C (Intermittent)
<b>Limitations</b>	Being Zinc based the coating is not resistant to acid and alkali solutions

#### 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

Spray/ Brush for small areas only.

##### Notes on Airless Spray

Tip Range	17 - 26 thou.
Total Output Fluid	2500 - 3000 psi.
Pressure	(176 - 210 kg/sq.cm.)
Pot Life	3 - 5 hours
Thinner	Thinner 6756

#### Uses

Suitable as primer for the socket of Ductile pipe.

## Typical System Selection Guide

SURFACE	1 <sup>ST</sup> COAT	2 <sup>ND</sup> COAT
Steel	Single pack zinc rich epoxy primer	Shalitol HB Bitumen

## Chemical Resistance Guide (with suitable top coat)

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

## Pack Size

5 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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