



**SHALIMAR
PAINTS**

TUFFKOTE

PROTECTIVE COATINGS

TUFFKOTE HB ZINC PHOSPHATE PRIMER

Data Sheet No. SPL/PMG/2019100109

A high performance anticorrosive primer based on modified phenolic alkyd medium and Zinc Phosphate pigment. The primer gives satisfactory performance on mild steel surface. It is compatible with a wide range of topcoats.

Product Information

Color	Grey/Red
Finish	Matt
Flash Point	Above 30°C
Volume Solids	46 ± 2 %
Recommended dry film thickness	40 – 50 microns
Corresponding wet film thickness	87 – 108 microns
Theoretical Spreading Rate	11.5 – 9.2 Sq.m/ltr
Volatile Organic Compound (VOC)	470 gm/ltr (EPA Method 24)
Drying time @ 30°C	Touch dry 2 – 4 Hours
	Hard Dry 16 –18 Hours
Interval before Over-coating	Minimum 10 Hours
	Maximum Indefinite
Storage Life	12 months minimum at 30°C if stored in a dry sealed container at shaded condition away from heat source and ignition
Dry Heat Resistance	Up to 100°C (Intermittent)

Uses

Suitable as Primer coat for industrial exposure including Structural steel, External Tankages, equipment's above ground pipelines, Cranes, Machinery & Mining Equipments at Industrial corrosive environment

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

Air Spray/Airless Spray / Brush / Roller

Notes on Airless Spray

Tip Range	17 - 21 thou.
Total Output	2100 – 2800 psi.
Fluid Pressure	(147- 196 kg/sq.cm.)
Thinner	Thinner 6751

Notes on Air Spray

Nozzle Orifice – 0.8 mm to 1.8 mm
Nozzle Pressure – 0.3-0.4 Mpa

TUFFKOTE HB ZINC PHOSPHATE PRIMER

Typical System Selection Guide

SURFACE	1 ST COAT	2 ND COAT	3 RD COAT	4 TH COAT
Steel	Tuffkote HB Zinc Phosphate Primer	Tuffkote HB MIO	Lustrol HR Aluminium/Tuffkote Phenolic Modified	Lustrol HR Aluminium/Tuffkote Phenolic Modified
- Do -	do	Tuffkote HB MIO	Tuffkote Phenolic Modified	Tuffkote Phenolic Modified

Chemical Resistance Guide (with suitable top coat)

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

1,4 & 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. 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.
5. Use of thinners other than supplied or approved by Shalimar may adversely affect product performance
6. Drying is dependent on temperature, relative humidity and thickness; ranges is given for considering those parameters
7. 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
8. 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.