



**SHALIMAR
PAINTS**

TUFFKOTE

PROTECTIVE COATINGS

TUFFKOTE ST HB SYNTHETIC ENAMEL

Data Sheet No. SPL/PMG/2019100170

It is an industrial single pack alkyd based synthetic enamel. This is designed essentially for applications on steel Substrate. It is fast drying ,provides corrosion resistance and also acts as a primer cum topcoat in modified alkyd system in single coat system.

PRODUCT INFORMATION

Color	Selected Range
Finish	High Glossy
Flash Point	Above 30°C
Volume Solids	50 ± 2 %
Recommended dry film thickness	50 - 60 microns
Corresponding wet film thickness	100 – 120 microns
Theoretical Spreading Rate	10.00 – 8.33 Sq.metre/litre
Drying time	Surface Dry 2 Hours Hard Dry 8-12 Hours
Interval before Over-coating	Minimum 12 Hours Maximum Depends on conditions
Storage Life	Upto 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.
Dry Heat Resistance	Up to 120°C (Intermittent)
Limitations	In common with all epoxies, this product may chalk on exposure. Discolouration also occurs under certain exposure conditions, but this is not detrimental to coating performance.
Volatile Organic Compound	410 grams/litre(as per EPA method)

SURFACE PREPARATION

Steel Surface

Degrease and blast clean to SA 2 ½ grade minimum of Swedish specification SIS - 05 -5900 - 1967. If blast cleaning is not practical make full use of mechanical tools along with manual cleaning and wire brushing to remove loose rust / scale to St 2 or St 3 grade of.

For Damage area rectification contact the Technical team of Shalimar Paints Limited

APPLICATION DETAILS

Method of Application

Brush / Airless Spray.
Airless spray recommended for uniform and high film build.

Notes on Airless Spray

Tip Range	17-21 thou.
Total Output Fluid Pressure	2500-3000 psi. (176 – 211 kg/sq.cm)
Thinner	Tuffkote SPL Thinner

USES

Maintenance painting for Drilling Rigs and Platforms Fertilizer Plants, Chemical Factories, Refineries, Petrochemical units, Railway Bridges, Marine & Port Installations.

SYSTEM SELECTION GUIDE

SURFACE	1 ST COAT	2 ND COAT	3 RD COAT	4 TH COAT
Steel	TUFFKOTE ST HB SYNTHETIC ENAMEL	TUFFKOTE ST HB SYNTHETIC ENAMEL	---	---
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CHEMICAL RESISTANCE GUIDE (WITH SUITABLE TOP COAT)

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

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

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.