



**SHALIMAR
PAINTS**



TUFFKOTE

PROTECTIVE COATINGS

BLASTEEL ZILIPATE

DATA SHEET NO. 2006-002

A self curing inorganic Zinc Ethyl Silicate shop primer for the protection of steel during fabrication and assembly. It renders long term weathering protection combining with good cutting and welding performance. It is compatible with a wide range of topcoats.

Product Information

Colour	Green
Finish	Matt
Flash Point	Above 23° C
Mixing Ratio	Base : Accelerator 1 : 1 (by volume)
Volume Solids	24% approximately
Recommended dry film thickness	20 microns per coat
Corresponding wet film thickness	83 microns
Theoretical Spreading Rate	12.0 Sq. metre per litre
Drying time	Touch dry - within 15 minutes depending upon ambient temperature and ventilation Full cure - 7 days
Interval before Overcoating	Minimum - 24 hours Maximum - Indefinite
Storage life	Upto 6 months so long as the material is stored in sealed containers under standard warehouse storage condition. Avoid contamination of moisture during storage.
Dry Heat Resistance	Upto 200° C (Intermittent)
Precaution	For curing relative humidity should not be lower than 40 %.

Surface Preparation

Steel Surfaces:

Degrease and blast clean to Sa 2½ grade minimum of Swedish specification SIS - 05 -5900-1967. No other mode of surface preparation is acceptable. Surface profile not to exceed 75 microns. Surface should be perfectly clean and dry before applying Blasteel Ziliplate.

Painting over weathered Zinc primer:

On weathering a white deposit of zinc salt may appear on the surface. These are to be removed by water scrubbing, sand / grit sweeping etc. before overcoating.

Application Details

Method of Application:

Conventional / Airless Spray.

Mixed paint to be kept stirred during application to avoid any pigment settlement and should be strained through 80 - 100 mesh sieve before application to avoid clogging of spray nozzle. Use plastic container for mixing base and accelerator.

Notes on Airless Spray: Tip

Range: 18 - 24 thou. total output
Fluid Pressure: 1000 - 2000 psi.
(70 - 140 kg/sq.cm.)
Pot Life: 3 - 4 hours.
Thinner: Thinner 6761

Uses

Shop Primer / Preconstruction Primer in high performance coating system which protects surfaces in: Hydro - electric units, Fertilizer units, Oil refineries, Gas plants, Mining and Machinery units.

System Selection Guide

SURFACE	Steel	Steel	Steel	Steel
1st COAT	Blasteel Ziliplate	Blasteel Ziliplate	Blasteel Ziliplate	Blasteel Ziliplate
2nd COAT	Epigard 4 Zinc Phosphate Primer / Epigard HB MIO	Epigard XL HB 533 / TL HB 533 Finish	Bipigard CTE XL Black / Brown	Chlorokote HB MIO
3rd COAT	Epigard 4 Finish/ Shalithane Finish/ Epithane HB Finish	Epigard XL HB 533 / TL HB 533 Finish	Bipigard CTE XL Black / Brown	Chlorokote Finish/ Chlorokote HB Finish
4th COAT	Epigard 4 Finish/ Shalithane Finish/ Epithane HB Finish	-	-	Chlorokote Finish/ Chlorokote HB Finish

Chemical Resistance Guide (With Suitable Top Coat)

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

- NOTES**
1. This cancels all previous literature on this product and is subject to revision without notice.
 2. Use off mixed paint within stipulated pot life period.
 3. The Primer must be fully cured and free from residual solvents before overcoating, which normally takes 24 hours but time may be extended if relative humidity is below 80%. While overcoating a mist coat should first be applied to avoid bubbling problem, which appears due to air entrapment.
 4. Zinc Ethyl Silicate Coatings cure by reaction with moisture and may be applied at high humidity provided the surface itself is free from condensation.
 5. Use of thinners other than supplied or approved by Shalimar may adversely affect product performance and void product warranty whether express or implied.
 6. Ensure weld seams, flux and spatters are removed / ground down and primed to avoid corrosion.

Health and Safety

Please refer to the separate safety data sheet available with detailed information.



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