



A two pack polyamide cured, epoxy primer containing zinc chromate pigment. It has excellent adhesion to steel or suitably treated light alloys or galvanised surfaces. It cures to a tough and highly rust preventive coat. The red version contains red oxide of iron apart from zinc chromate.

Product Information

Colour	Yellow / Red oxide
Finish	Matt to Eggshell
Flash Point	Above 20° C
Mixing Ratio	Base : Accelerator 3 : 1 (by volume)
Volume Solids	41% approximately
Recommended dry film thickness	30 - 35 microns per coat
Corresponding wet film thickness	73 - 85 microns
Theoretical Spreading Rate	13.7 - 11.7 Sq. metre per litre
Drying time	Surface dry 2 - 3 hours. Handleable 4 - 6 hours Full cure - 7 days
Interval before Overcoating	Minimum - 18 hours Maximum - 7 days
Storage life	Upto 12 months so long as the material is stored in sealed containers under standard warehouse storage condition.
Dry Heat Resistance	Upto 150° C (Intermittent)

Surface Preparation

Steel Surfaces:

Degrease and blast clean to Sa 2½ 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 Swedish specification. Surface should be perfectly clean and dry before applying. Epigard 4 Zinc Chromate Primer.

Application Details

Method of Application:

Brush / Roller / Spray.

Notes on Airless Spray: Tip

Range : 15 - 21 thou.

Total output

Fluid Pressure: 2500 - 3000 psi.

(176 - 210 kg/sq.cm.)

Pot life: 4 - 8 hours.

Thinner: Thinner 6756

Uses

As primer for marine and chemical environment as in Pulp and paper mills, Refineries, Petrochemicals, Fertilizer units, Metal and Engineering industries.

System Selection Guide

SURFACE	Steel	Steel	Steel	Steel	Steel
1st COAT	Epigard 4 Zinc Chromate Primer Yellow / Red	Epigard 4 Zinc Chromate Primer Yellow / Red	Epigard 4 Zinc Chromate Primer Yellow / Red	Epigard 4 Zinc Chromate Primer Yellow / Red	Epigard 4 Zinc Chromate Primer Yellow / Red
2nd COAT	Epigard HB MIO Brown / Grey	Bipigard CTE XL Black / Bipigard 580 HB CTE Black	Epigard 4 Z C P	Epigard XL HB 533 Finish	Chlorokote HB MIO Brown / Grey
3rd COAT	Epigard 4 / Shalithane / Epithane HB Finish	Bipigard CTE XL Black / Bipigard 580 HB CTE Black	Epigard 4 / Shalithane / Epithane HB Finish	Epigard XL HB 533 Finish	Chlorokote HB
4th COAT	Epigard 4 / Shalithane / Epithane HB Finish	-	Epigard 4 / Shalithane / Epithane HB Finish	Chlorokote HB	Chlorokote HB

Chemical Resistance Guide

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

- NOTES**
1. This cancels all previous literature on this product and is subject to revision without notice.
 2. Do not apply when temperature falls below 10°C or rises above 50°C and when relative humidity rises above 90%. Do not apply during rain, fog or mist.
 3. Use off mixed paint within stipulated pot life period.
 4. Use of thinners other than supplied or approved by Shalimar may adversely affect product performance and void product warranty whether express or implied.

Health and Safety

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

Precaution

Provide adequate ventilation during application and drying. For proper curing of film, ambient temperature should not be lower than 10° C.



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