



**SHALIMAR
PAINTS**



TUFFKOTE

PROTECTIVE COATINGS

EPISHIELD ST GLASS FLAKE
EPOXY COATING

DATA SHEET NO. 2006-045

A two pack low VOC high build mastic surface tolerant epoxy coating reinforced with chemically inert glass flake for application on manually cleaned steel surface for enhanced durability and corrosion resistance of steel structures in all corrosive environment including splash zone areas of offshore structures. This product can be applied over most of the tightly adhering aged coatings and concrete surface. It is widely used as maintenance primer and selfpriming finish.

Product Information

Colour	Brown / Dark Grey (Arbitrary)
Finish	Semiglossy
Flash Point	Above 20° C
Mixing Ratio	Base : Accelerator 2 : 1 (by volume)
Volume Solids	90% approximately
Recommended dry film thickness	200 - 300 microns per coat.
Corresponding wet film thickness	200 - 300 microns
Theoretical Spreading Rate	4.5 - 3.0 Sq.metre per litre
Drying time	Touch dry - 3 - 4 hours Hard dry - 18 hours Full curing - 7 days
Interval before Overcoating	Minimum - 18 hours Maximum - depends on conditions
Storage life	Upto 9 months so long as the material is stored in sealed containers under standard warehouse storage conditions.
Dry Heat Resistance	Upto 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.

Uses

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

Surface Preparation

Steel Surfaces:

Remove grease oil etc by solvent wiping and water-soluble contaminants by fresh water hosing. Blast clean to Sa 2½ grade minimum of Swedish specification SIS - 05 - 5900 - 1967.

If blast cleaning is not practical make full use of hand or power tools to remove loose rust / scale to St 2 or St 3 grade of Swedish specification SIS - 05 - 5900 - 1967. Avoid polishing the steel surface.

Surface should be clean and dry before application of Epishield ST Glass Flake Epoxy Coating.

Concrete Surfaces:

For new concrete surface: Ensure that the surface is cured for minimum 2 months. Remove laitence, loose surface powder by light sand blasting. If blast cleaning is not feasible, roughen the surface by acid etching with 10% Hydrochloric Acid solution followed by thorough freshwater hosing to remove any residual acid. The surface should be perfectly dry and clean before applying Epishield ST Glass Flake Epoxy Coating.

For old concrete surface: Remove grease, oil etc by solvent wiping. Remove water-soluble contaminants by fresh water hosing. Roughen the surface by acid etching, if light sand blasting is not feasible. The surface should be perfectly dry and clean before application of Epishield ST Glass Flake Epoxy Coating.

Application Details

Method of Application:

Brush / Airless spray.

Airless spray recommended to uniform and high film build.

Notes on Airless Spray:

Tip Range: 31 - 37 thou

Total out put fluid pressure-

2500 - 3200 psi

(176 - 255 kg/sq.cm)

Pot Life:

2 - 3 hours

Thinner:

Thinner 6756

System Selection Guide

SURFACE	Steel	Steel	Steel	Concrete Surface
1st COAT	Epishield ST Glass Flake Epoxy Coating	Epishield ST Glass Flake Epoxy Coating	Epishield ST Glass Flake Epoxy Coating	Epishield ST Glass Flake Epoxy Coating
2nd COAT	Epishield ST Glass Flake Epoxy Coating	Epigard TL HB 533 / XL HB 533 Finish	Bipigard CTE / Bipigard 580 HB CTE Black	Epishield ST Glass Flake Epoxy Coating
3rd COAT	-	Epithane HB / Shalithane finish	Bipigard CTE / Bipigard 580 HB CTE Black	Epithane HB / Shalithane finish
4th COAT	-	Epithane HB / Shalithane finish	-	-

Chemical Resistance Guide

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

- 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. Consult Shalimar Tuffkote Division if overcoating is not done within stipulated period.
 5. Thinning upto 15% may be necessary depending on Site conditions. Use of thinners other than supplied or approved by Shalimar may adversely affect product performance and void products 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. If in doubt regarding the suitability of this product please consult Tuffkote Protective Coating Division.



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