



**SHALIMAR
PAINTS**



TUFFKOTE

PROTECTIVE COATINGS

**TUFFKOTE HIGH BUILD
BITU BLACK**

DATA SHEET NO. 2006-065

A high build anti-corrosive black paint based on a special type bitumen medium containing phenolic resins with inert pigmentation. This ultimately cures to a tough abrasion-resistant coating having excellent water resistance and also resistance to mild acid, alkali & chemicals. It is suitable for protection of barrage gates, penstocks, coal bunkers, pipelines, structures inside chemical factories, underframes of railway coaches and lorries, marine installations, concrete jetties, pilings etc.

Product Information

Colour	Black
Finish	Eggshell to Semigloss
Flash Point	Above 30°C
Volume Solids	56% approximately
Recommended dry film thickness	75 - 100 microns per coat.
Corresponding wet film thickness	134 - 179 microns
Theoretical Spreading Rate	7.5 - 5.6 Sq. metre per litre
Drying time	Surface dry - 4 - 6 hours Hard dry - 24 - 48 hours Full Curing - 7 - 10 days
Interval before Overcoating	Minimum - 24 hours In certain humid conditions 2 - 3 days drying may be required before overcoating.
Dry Heat Resistance	Upto 120°C (intermittent)
Storage life	Upto 9 months so long as the material is stored in sealed containers under standard warehouse storage conditions.

Surface Preparation

STEEL SURFACES:

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 Swedish specification. Surface should be perfectly clean and dry before applying appropriate primer.

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 appropriate primer.

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 applying appropriate primer.

Application Details

Method of Application:

Brush / Roller / Airless Spray.

Airless spray recommended for uniform and high film build.

Notes on Airless spray:

Tip Range - 21 - 26 thou

Total Out put fluid pressure -

3000 - 3500 psi

(211 - 246 kg/sq.cm)

Thinner:

Thinner 6753

Uses

Pulp & Paper Mills, Fertilizer Plants, Hydro-electric Units, Gas Plants, Barrage Gates, Dock & Harbour Installations Cooling Towers.

System Selection Guide

SURFACE	Steel	Steel	Concrete Surfaces
1st COAT	Tuffkote Anti-Brine Aluminium	Tuffkote HBZP Primer / Tuffkote ROZC Primer / Shaliprime Universal Primer Red	Tuffkote HB Bitu Black (thin coat)
2nd COAT	Tuffkote Anti-Brine Aluminium	Tuffkote HB Bitu Black	Tuffkote HB Bitu Black
3rd COAT	Tuffkote HB Bitu Black	Tuffkote HB Bitu Black	Tuffkote HB Bitu Black
4th COAT	Tuffkote HB Bitu Black	-	-

Chemical Resistance Guide

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

Health and Safety

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

Precaution

Arrange efficient ventilation for painting in confined spaces.



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