



**SHALIMAR
PAINTS**

TUFFKOTE

PROTECTIVE COATINGS

BIPIGARD ST CTE BLACK

Data Sheet No. SPL/PMG/2019100137

A two component surface tolerant high build coal tar epoxy paint suitable for application on manually cleaned steel surface and tightly adhering aged coating. The product performs extremely well in marine environment, partial or intermittent immersion in salt or fresh water. It stands corrosive conditions in soil immersion and also certain acidic and alkaline environments with or without cathodic protection..

Product Information

Color	Black
Finish	Eggshell
Flash Point	Above 20°C
Mixing Ratio (By Volume)	Base : Accelerator 3 : 1
Volume Solids	65±3%
Recommended dry film thickness	100 - 125 microns
Corresponding wet film thickness	154 - 192 microns
Theoretical Spreading Rate	6.5 – 5.2 Sq.m/ltr
Drying time	Surface dry 5 - 10 hours Handleable 24 hours Full cure 7 days
Interval before Over-coating	Minimum 24 hours Maximum 7 days
VOC	255 gm/ltr (EPA Method 24)
Storage Life	Up to 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	The finish chalks on outdoor exposure although protective properties of the film remain practically unaffected

Uses

In coating steel / concrete for Oil Refineries, Fertilizer plants, Petrochemical Units, Chemical Plants, Power Plants etc.

Surface Preparation

Steel Surface

Surface must be clean, dry & free from contamination. Prior to paint application all surfaces should be assessed and treated in accordance with ISO 8504:2000. Abrasive blast clean to Sa 2½ is recommended. If Abrasive blast cleaning is not possible it is recommended to hand tool/ power tool cleaning up St2 or St3 before application of this this product.

Concrete Substrate

Ensure that the surface is cured for minimum 28 Days. Remove laitance, 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 this coat.

For damage area rectification please contact the Technical team of Shalimar Paints Limited

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 Output	2700 - 3500 psi.
Fluid Pressure	(190 - 246 kg/sq.cm.)
Pot Life	2 – 4 hours
Thinner	Thinner 6756

System Selection Guide

SURFACE	1 ST COAT	2 ND COAT	3 RD COAT
Steel	Bipigard ST CTE Black	Bipigard ST CTE Black	Bipigard ST CTE Black
- Do -	Bipigard ST CTE Black	Bipigard ST CTE Black	-
Concrete Surface	Bipigard ST CTE Black	Bipigard ST CTE Black	-

Chemical Resistance Guide (with suitable top coat)

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

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- consult Shalimar Paints Limited representative

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 points.
3. Mixing with mechanical agitator is strongly recommended
4. 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.
5. Use of thinners other than supplied or approved by Shalimar may adversely affect product performance
6. Drying is dependent on temperature, relative humidity and thickness; ranges is given for considering those parameters
7. 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
8. Request for details information of surface preparation, paint application on the recommended coating system

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