



**SHALIMAR
PAINTS**

TUFFKOTE

PROTECTIVE COATINGS

EPIGARD 4 HB ZINC RICH PRIMER

Data Sheet No. SPL/PMG/20191000541

A two pack polyamide cured epoxy primer containing metallic zinc pigment . It exhibits excellent corrosion protection and complies with the composition and performance requirements of SSPC Paint 20 Level 2. It is ideally suited as primer for high corrosive area when it is coated with suitable intermediate and topcoat

Product Information

Color	Grey
Finish	Matt
Flash Point	Above 23°C
Mixing Ratio (By Volume)	Base : Accelerator 3 : 1
Volume Solids	55 ± 3 %
Recommended dry film thickness	65 - 85 microns
Corresponding wet film thickness	118 – 154 microns
Theoretical Spreading Rate	8.46– 6.47 Sq.m / ltr
Drying time @ 30°C & RH -50	Touch dry 30 minutes Handle dry 4 - 6 hours Full cure 7 days
Interval before Over- coating	Minimum 18 hours Maximum Indefinite
Volatile organic Compound (VOC)	390 gms/ltr (EPA Method 24)
Storage Life	6 months minimum @ 30°C if stored in a dry sealed container at shaded condition away from heat source and ignition
Dry Heat Resistance	Up to 300°C (Intermittent)
Limitations	Being Zinc based the coating is not resistant to acid and alkali solutions

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 strongly recommended.

For Damage area rectification contact the Technical team of Shalimar Paints Limited

Application Details

Method of Application

Conventional spray / Airless spray
Brush for small areas.

Notes on Airless Spray

Tip Range	17 - 26 thou.
Total Output Fluid	2500 - 3000 psi.
Pressure	(176 - 210 kg/sq.cm.)
Pot Life	3 - 5 hours
Thinner	Thinner 6756

Notes on Air Spray

Nozzle Orifice – 2.0 mm to 3 mm
Nozzle Pressure – 0.3-0.4 Mpa

Uses

Suitable as primer coat for heavy duty systems for Structural Steel, Pipelines, interior and exterior of storage tanks for Fertilizer plants, Refineries & Petrochemical units, Chemical units, Offshore Platforms, Power Plants etc for high corrosive area.

Typical System Selection Guide

SURFACE	1 ST COAT	2 ND COAT	3 RD COAT	4 TH COAT
Steel	Epigard 4 HB Zinc Rich Primer	Epigard HB MIO	Epigard Finish / Shalithane Finish	Epigard Finish / Shalithane Finish
- Do -	- do -	Bipigard CTE XL / Bipigard 580 HB CTE	Bipigard CTE XL / Bipigard 580 HB CTE	-

Chemical Resistance Guide (with suitable top coat)

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

Pack Size

20 litres - For available pack size contact local representative of Shalimar Paints Limited

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

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