BERGER Protecton PROTECTIVE COATINGS

Epilux 610 HB Primer

SURFACE PREPARATION

Steel: Round off all rough welds, sharp edges and remove weld spatter. Remove grease, oil and other contaminants in accordance with SSPC SP1. Rinse surface thoroughly with clean water to remove acids or alkali contaminants. Abrasive blast to a minimum of SSPC SP10 to a surface profile of 35-40 microns. Remove all dust by brushing or vacuum cleaning.

APPLICATION

Stir base throughly and then mix two parts base and one part catalyst by volume to uniform consistency. Allow the mixture to mature for 20 minutes and stir again before application and during use.
Brush : Apply preferably without thinning.
Air-Spray: Add maximum up to 15% Thinner 844 depending on site conditions. Use any standard equipment at an atomising pressure of 3.5 to 4.9 Kg/cm^2
Airless Spray : Apply preferably without thinning. However, upto 5% Thinner 844 may be added if absolutely essential depending on conditions. Use any standard equipment having pump ratio 30 :1, Tip size 0.38 to 0.43mm. Tip pressure 110 - 160 Kg/cm^2.

TYPICAL PAINTING SPECIFICATIONS

Surface	1st Coat	2nd Coat	3rd Coat	4th Coat
New Steel	Zinc Anode 304 MZ	Epilux 610 HB Primer	Epilux 4 HB Epoxy Finish	Bergerthane PU Glossy Finish
New Steel	Epilux 610 HB Primer	Epilux155 HB MIO/ Epilux 4 HB MIO	Epilux 4 HB / Epilux 155 HB Enamel	Bergerthane PU Glossy Finish
New Steel	Epilux 610 HB Primer	Epilux 78 HBTL	Epilux 78 HBTL	
New Steel	Epilux 610 HB Primer	Linosol HB MIO Coating	Linosol CR Paint	Linosol CR Paint
New Steel	Epilux 610 HB Primer	Epilux 5 CTE/ Epilux 555 CTE	Epilux 5 CTE/ Epilux 555 CTE	

Notes :

1. Use off the mixed paint within the stipulated pot life period.
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. Always apply the paint when the surface temperature is 3 °C higher than the dew point temperature.
4. Brushes and spray equipment should be cleaned with Thinner 844 otherwise equipment is likely to be damaged.

Health & Safety : Please refer to the separate Safety Data Sheet available with detailed information.

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BERGER PAINTS INDIA LIMITED Berger House,129 Park Street, Kolkata 700017
Phone : (033) 2229 9724 (5 lines) / 249 9754 (4 lines) **Fax :** 91-33-2249 9729 / 2249 9009
protectonhelpdesk@bergerindia.com :: www.bergerpaints.com

BERGER Protecton PROTECTIVE COATINGS

Epilux 610 HB Primer

USES

The primer possesses a history of success in various fertilizer, refineries, chemical and other plants applied in diverse areas of tank exteriors, equipment, pipelines structural steel etc..

SCOPE

A two pack anticorrosive epoxy primer for use on steel surfaces. The primer is ideally designed for offering superior performance in highly corrosive chemical and coastal environments. Also used over Inorganic Zinc Silicate as a tie coat in a coating system. It can be overcoated with epoxy, chlororubber and polyurethane top coats.

PRODUCT DATA

Type : Two Pack, Epoxy Polyamine Primer

Composition : Catalysed Epoxy resin with Redoxide and Zinc Phosphate pigments

Volume Solids: 60 ± 2%

Mixing Ratio : Base : Catalyst – 3:1 by volume

Pot Life : 6 to 8 hrs @ 30°C

Application : Brush, Air/ Airless Spray

Recommended DFT : 35 - 50 µ per coat

Corresponding WFT : 58 - 83 µ per coat

Theoretical Spreading Rate : 12.0- 17.1 m^2/ltr

Drying Time : @30°C and 50% RH

TOUCH	: 30 mts
HARD	:8 hours

Curing Time : 7 days

Overcoating Interval :

MIN	: 8 - 12 hours
MAX	:10 days

Flash Point : Above 28° C

Colour : Redoxide

Finish : Smooth

Packing : 20 Ltrs.

Thinner/Cleaner : Thinner 844

Storage Life : Upto twelve months as long as the sealed containers are kept under cover in a dry place under normal temperature conditions.

RESISTANCE GUIDE

Chemical Resistance :

EXPOSURE	SPLASH & SPILLAGE	MILD FUMES / OUTDOOR RESISTANCE
Acids	Good	Good
Alkalis	Good	Good
Solvent	Very Good	Very Good
Salt	Very Good	Very Good
Water	Very Good	Very Good

Temperature Resistance :

continuous:	93°C maximum
intermittent:	120°C maximum

Weatherability : V Good in coating system

Flexibility : Good

Abrasion Resistance : Fair

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