



# BERGER Protecton PROTECTIVE COATINGS

## Epilux 4 High Build Epoxy Finish

### USES

Recommended for use on steel structurals and tank exterior of fertilizer plants, chemical units, refineries, petrochemicals, power generation units or onshore installation.

### SCOPE

A two pack High Build Epoxy finish with excellent performance when exposed to a wide range of corrosive chemicals and marine/industrial environments.

### PRODUCT DATA

**Type :** Two Pack epoxy cured with Polyamide resin

**Composition :** Catalysed epoxy resin suitably pigmented

**Mixing Ratio :** Base : Catalyst – 10 : 1 by volume

**Pot Life :** 6–8 hours

**Application :** Brush or Airless Spray

**Recommended DFT :** 90–110 microns per coat

**Recommended WFT :** 143–173 microns per coat

**Theoretical Spreading Rate :** 5.7–7.0 Sq. Mtr./Ltr.

**Drying Time :**

TOUCH : 3–4 hours  
HANDLE : 8–10 hours  
HARD : Overnight

**Curing Time :** 6–7 days

**Overcoating Interval :**

MIN : Overnight  
MAX : 5 days

**Flash Point :** Above 22° C

**Colour :** Assorted shades

**Finish :** Egg–shell

**Packing :** 11 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 :**

EXPOSURES	SPLASH & SPILLAGE	MILD FUMES / OUTDOOR RESISTANCE
Acids	Good	Very Good
Alkalis	Good	Very Good
Solvents	Good	Good
Salt	Very Good	Very Good
Water	Very Good	Very Good

**Temperature Resistance :**

Continuous : 93° C  
Intermittent : 120° C

**Weatherability :** Good in combination with a suitable inhibitive primer

**Flexibility :** Good

**Abrasion Resistance :** Very Good

**SURFACE PREPARATION**

Remove grease, oil and other contaminants preferably by using Bison Degreasing Solvent. Blast clean to a minimum Sa 2 1/2 Swedish Standard SIS 05 5900. For severe corrosive conditions, blast clean to Sa 3 with a surface profile not exceeding 65 microns. If blasting is not practical, make full use of mechanical tools alongwith manual chipping and wire brushing to remove loose rust and scale to Sa 2 1/2 Swedish Standard SIS 05 5900. Excessive burnishing of steel is to be avoided. Thoroughly dust down all surfaces. Best results can be achieved if the manually cleaned surface is primed with Protectomastic - Self Priming Surface Tolerant Coating.

The surface should be clean and dry before application of appropriate primer coat.

**APPLICATION**

Stir the base thoroughly and then mix ten parts of base and one part of catalyst to uniform consistency. Allow the mixture to mature for 30 minutes and stir again before and during application.

**Brush :** Add upto 5% Thinner 844 if required during application.

**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 40 : 1. Tip size 0.43–0.53 mm. Tip pressure 110–160 Kg/cm<sup>2</sup>.

**TYPICAL PAINTING SPECIFICATIONS**

Surface	1st Coat	2nd Coat	3rd Coat	4th Coat
Steel	Zinc Anode 304 or Epilux 4 Z/R Primer	Epilux 4 HB Epoxy Finish	Epilux 4 HB Epoxy Finish	
-do-	Epilux 610 or Epilux 13 Primer	Epilux 610 or Epilux 13 Primer	-do-	Epilux 4 HB Epoxy Finish
-do-	Protectomastic	Epilux 4 HB MIO	-do-	-do-

**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. 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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**DATA SHEET No. : 122/01**  
**Issue Date : Mar. 04**

**BERGER PAINTS INDIA LIMITED**