



## Epilux Durebild FRE Coating

### USES

Ideal for application over floating tank roof exterior, jetty pilings, bridge underdecks and other installation where water and chemical resistance are required. The product is suitable for chemicals, fertilizers, petrochemicals, refineries and corrosive industries in both maintenance and new construction situation.

### SCOPE

A high build high solids epoxy mastic coating with superior surface wetting properties for use over hand and power tool cleaned surface. Exhibits excellent resistance to weather, water and chemical environments. The product can be applied over wide range of prepared, well adhering and aged coating types.

#### PRODUCT DATA

**Type** : Two pack, epoxy primer cum finish  
**Composition** : Catalysed epoxy resin suitably pigmented  
**Volume Solids**: 85 ± 3 %  
**Volatile Organic Content**: ≤130 gms/ltr  
**Mixing Ratio** : Base : Catalyst - 4 : 1 by volume  
**Pot Life** : 3 hrs @ 25°C  
**Application** : Brush & Airless Spray  
**Recommended DFT** : 100 - 175 μ per coat  
**Corresponding WFT** : 118 - 206 μ per coat  
**Theoretical Spreading Rate** : 4.9 - 8.5 m<sup>2</sup>/Ltr/Coat  
**Drying Time**: @50% RH  
 Air Temp @25°C

TOUCH:	6 hrs
HANDLE :	12 hrs
HARD:	18 hrs

**Curing Time** : 7 days minimum  
**Overcoating Interval** : @ 50% RH  
 Air Temp @25°C

MIN:	18 hrs
MAX:	1 months

**Flash Point** : Above 22° C (mixed paint)  
**Colour** : White and Grey  
**Thinner** : Thinner 844  
**Packing** : 20 Ltrs.  
**Finish** : Smooth & Semi glossy

**Storage Life** : Upto nine 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	Very Good	Excellent
Solvent	Very Good	Excellent
Salt	Excellent	Excellent
Water	Excellent	Excellent

##### Temperature Resistance :

Continuous	: 100 <sup>0</sup> C
Intermittent	: 120 <sup>0</sup> C

**Flexibility** : Very Good

**Abrasion Resistance** : Excellent

**SURFACE PREPARATION**

Round off all rough welds, sharp edges and remove weld spatter. Rinse surface thoroughly with clean water to remove acids or alkali contaminants as well as to remove grease, oil and other contaminants in accordance with SSPC SP1. Make full use of mechanical tools alongwith manual chipping and wire brushing to remove loose rust to SSPC SP2 or SP3 for Rust Grade C or D in new steel or in E for coated steel; else for Rust Grade A, B, G, H abrasive blasting is required as per SSPC SP 10 for application of the primer. For severe corrosive conditions, blast clean to SSPC SP5 Special care must be taken on weld areas to remove flux and spatter; welds should be ground back to avoid pockets. Thoroughly dust down all surfaces. The surface should be clean and dry before application of primer coat and the subsequent coats. Excessive burnishing of steel has to be avoided while working with power tools.

**APPLICATION**

Stir the components throughly and then mix the base and catalyst in recommended proportion to uniform consistency. Allow it to mature for 15 minutes and stir again before use and during application.

Brush : Apply preferably without thinning. However, if required during application, add upto 5% Thinner 844. Brushing is recommended for touching up small areas and for stripe coat only.

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 45:1. Tip size : 0.43 - 0.53 mm. Tip Pressure : 180 - 220 Kg/cm<sup>2</sup>.

**TYPICAL PAINTING SPECIFICATIONS**

Surface	1st Coat	2nd Coat	3rd Coat
Steel	Zinc Anode 304 HZ Coating	Epilux Durebild FRE Coating	Epilux Durebild FRE Coating
Steel	Epilux Durebild FRE Coating	Epilux Durebild FRE Coating	BR PU High Gloss Enamel
Concete	Epilux Durebild FRE (thinned)	Epilux Durebild FRE Coating	Epilux Durebild FRE Coating

**Precaution :**

1. Use off the mixed paint within the stipulated pot life period.
2. Do not apply when temperature falls below 5° C or when it rises above 50° C and when relative humidity rises above 85%. Do not apply during rain, fog or mist.
3. Application characters are likely to get affected when temperatures are below 10°C. Extended drying and curing time needs to be allowed.
4. Always apply the paint when the dew point is 3°C higher than the substrate temperature.
5. 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.

**DISCLAIMER**

The information contained within this Data Sheet is based on information believed to be reliable at the time of its preparation. The Company will not be liable for loss or damage howsoever caused including liability for negligence, which may be suffered by the user of the data contained herein. It is the users' responsibility to conduct all necessary tests to confirm the suitability of any product or system for their intended use. No guarantee of results is implied since conditions of use are beyond our control.

**DS # ORC 006-rev02**  
**Issue Date : Sept 2022**