



Epilux HB DTM Coating

USES

A quick drying two pack high build epoxy primer cum finish coating suitable for application on well prepared mild steel for moderate atmospheres. An ideal coating for equipment, pipeline structurals in power plants as well as steel plant.

SCOPE

A low VOC quick drying DTM (direct to metal) epoxy coating for application on steel structures that are exposed to moderate corrosive, inland atmospheric conditions. It is overcoatable with epoxy, polyurethane and synthetic enamel top coats if required.

PRODUCT DATA

Type : Two pack Epoxy DTM coating

Composition : Epoxy /Specially designed modified polyamide resin/ inert pigments

Volume Solids: 80 ± 4% **VOC:** 172 gms/lt

Mixing Ratio : Base: Catalyst: 6:1 by volume

Pot Life : 1 - 3 Hours

Application : Brush and Spray

Recommended DFT : 75 - 200 µ per coat

Recommended WFT: 94 - 250 µ per coat

Theoretical Spreading Rate : 4.1 – 10.9 m²/Ltr/coat

Drying Time : @30°C

TOUCH : 45 - 60 min

HANDLE : 4 - 6 hours

HARD : 10 - 12 hours

Overcoating Interval :

Min : 10 hours

Max : 1 week

Flash Point : Above 25° C

Colour : Assorted shades

Packing : 21 Ltrs.

Thinner/Cleaner : Thinner 844

Finish: Smooth and 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	Very Good	Very Good
Alkalis	Very Good	Very Good
Solvents	Good	Good
Salt	Very Good	Very Good
Water	Very Good	Very Good

*not recommended for immersion

Temperature Resistance :

Continuous : 93 ° C

Intermittent : 120 ° C

Weatherability: Good

Abrasion Resistance: Moderate

SURFACE PREPARATION

Remove grease, oil and other contaminants preferably by using Solvent Cleaning to SSPC SP1. Abrasive blast clean to a minimum of SSPC SP10 (Sa2.5) with a surface profile not exceeding 50 microns. Excessive burnishing of steel is to be avoided. Thoroughly dust down all surfaces. Special care must be taken on weld areas to remove flux and spatter; welds should be ground back to avoid pockets. The prepared surface should be clean and dry and coated before it gets contaminated.

APPLICATION

Mix the contents thoroughly before and during use. Stripe coat is recommended on welded areas and on edges.

Brush : Apply preferably without thinning. If required, add upto 5% Thinner 844 depending on conditions.

Conventional Spray : Add upto 10-20% Thinner 844. Use any standard equipment at an atomising pressure of 4.2-4.9 Kg/cm².

Airless spray: Add upto 5-15% Thinner 844 if required. Use any standard equipment having pump ratio 30:1. Tip size 0.28.0.38 mm; tip pressure 110-160 kg / cm².

TYPICAL PAINTING SPECIFICATIONS

Surface	1st Coat	2nd Coat
Mild Steel	Epilux HB DTM Coating	(optional) Epilux HB DTM Coating or Bergerthane Finish

Notes :

1. 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.
2. Kindly ensure to apply the coating when the substrate temperature is 3° C more than the dew point temperature
3. Ensure to apply a uniform build of paint free of pin-holes or holidays to avoid premature failures.

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

DISCLAIMER

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