



Epilux STL PI Coating

USES

An ideal coating for food grade solvent free pipe line internal surface; suitable for potable water.

SCOPE

A quick setting high performance solventless pipe coating suitable for sustained immersion in water. Epilux STL PI Coating possesses superb corrosion resistance and can withstand both potable and saline water.

PRODUCT DATA

Type : Two Pack Epoxy Pipe Coating

Composition : Catalysed epoxy resin suitably pigmented.

Volume Solids: 98 ± 2%

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

Pot Life: 30 minutes at ambient conditions.

Application: Airless Spray, Brush for touch up

Recommended DFT: 200 - 500 µ per coat.

Recommended WFT: 204 - 510 µ per coat.

Spreading Rate : 2.0 - 5.0 m² / Ltr./coat

Drying Time : @ 30°C and 60% RH

TOUCH : Within 2 hours

HANDLE : 6 hours

HARD : 10 hours

Curing Time : 7 days minimum

Overcoating Interval :

MIN : 10 hours.

MAX : 48 hours.

Colour : Assorted

Finish : Smooth and Glossy

Packing : 20 Ltrs.

Thinner/Cleaner : Thinner 844

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	IMMERSION
Acid	Good
Alkali	Good
Solvent	Good
Salt	Very Good
Water	Very Good

Temperature Resistance :

Continuous: : 120°C

Hot Water : 50°C

Abrasion Resistance : Very Good

Flexibility : Moderate

DATA SHEET No. : 419

Issue Date : Oct 2016

SURFACE PREPARATION

Steel: 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. Abrasive blast to standard SSPC SP5 to a surface profile of 50 – 75 microns. Remove all dust by brushing or vacuum cleaning.

Concrete : Remove all laitance, from release, grease and mould. Brush off blast with ilmenite or garnet as per SSPC SP13. Remove all dust by vacuum cleaning. Fill any large exposed voids.

APPLICATION

Stir the contents of each can thoroughly with broad flat stirrer using a slow speed mechanical stirrer. Mix the contents of both packs together thoroughly for at least 3 minutes. Ensure the clean-up solvent is available before commencing application. Use mixed material immediately after mixing.

Brush / Roller : Suitable for small area only. Brushing is ideally used for weld joints and edges as a stripe coat.

Airless Spray : Plural Component Airless Units : Units capable of 2:1 volume metering and heating such as binks, graco and others using a 60:1 pump ratio with a fluid tip of 21-26 thou (0.53-0.66 mm) 3 ¼ Twist tip or adjustable tip (Titan) with an air supply of 690 – 830 kPa (100-120 p.s.i.) and a line size of 12 mm ID.

Pre-mix Airless Application : Standard airless spray equipment such as Graco, Binks or other using a 60:1 pump ratio with a fluid tip of 21 – 26 thou (0.53 – 0.66 mm) or adjustable tip and an air supply of 690 – 830 kPa (100 – 120 p.s.i) and a line size of 12 mm ID. Apply material immediately after mixing and clean equipment immediately after use.

TYPICAL PAINTING SPECIFICATIONS

Surface	1st Coat	2nd Coat	3rd Coat
Steel	Epilux FRX AC Primer	Epilux STL PI Coating	Epilux STL PI Coating
Steel	Epilux STL PI Coating	Epilux STL PI Coating	
Concrete	Epilux 4 Clear	Epilux STL PI Coating	Epilux STL PI Coating

Precaution :

1. Do not apply in conditions outside the parameters stated in this document .
2. Freshly mixed material must not be added to any previously mixed lots.
3. Do not apply in temperature below 10°C or above 50°C.
4. Moisture level 5% should not be exceeded in concrete.
5. Steel Surface temperature should be 3°C higher than dew point temperature
6. Relative humidity should be less than 85%.

Storage Store in a cool and dry area under shed

Handling As with any chemical, ingestion, inhalation and prolonged or repeated skin contact should be avoided by good occupational work practice. Eye protection approved to AS 1337 should be worn where there is a risk of splashes entering the eyes. Always wash hands before smoking, eating, drinking or using the toilet.

Using Use with good ventilation and avoid inhalation of spray mists and fumes. If there is risk of inhalation of spray mists, wear combined organic vapour / particulate respirator. When spray painting, users should comply with the provisions of the respective State Spray Painting Regulations.

Flammability Fight fire with foam, CO₂, dry chemical power, on burning will emit toxic fumes.

Welding Avoid inhalation of fumes if welding surfaces coated with this paint. Grind off coating before welding.

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.

**Data Sheet No. :
419
Issue Date :
Oct 2016**