



EPILUX 610 HBLD PRIMER COATING

USES

An epoxy high build primer meant for application in both projects and maintenance requirements on structural steel, pipelines, equipments, tanks in diverse industrial, chemical and marine environments. It is suitable for use as a primer in Fertilizer plants, Refineries, Petrochemicals, Pharmaceuticals and other industries.

SCOPE

A specially designed high build anticorrosive primer which cures to a hard and tough film offering excellent anticorrosive property. The product possesses high corrosion resistance as well as excellent water impermeability. It can be overcoated with epoxy or polyurethane top coats.

PRODUCT DATA

Type : Two Pack, cured with Polyamide

Composition : Catalysed epoxy resin with redoxide and zinc phosphate anticorrosive pigments

Mixing Ratio : Base : Catalyst - 10:1 by volume

Application : Brush or Airless spray

Pot Life : 4 to 6 hours @ 27 ± 3°C

Recommended DFT : 80 - 100 microns per coat

Corresponding WFT : 133 - 167 microns per coat

Theoretical Spreading Rate : 6.0 – 7.5 sqmt/ltr/coat

Drying Time :

TOUCH : 2 Hours

HANDLE : 8 Hours

HARD : Overnight

Curing Time : 7 days

Overcoating Interval :

MIN : Overnight

MAX : seven days

Flash Point : Above 250 °C

Colour : redoxide

Finish : Matt

Packing : 11 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	Splash and spillage	Mild Fumes/outdoor resistance
Acids	Good	Good
Alkalis	Good Very	Good Very
Solvents	Good Very	Good Very
Salt	good Very	good Very
Water	Good	Good

Temperature Resistance :

Continuous: 93°C

Intermittent: 120°C

Weatherability: Very Good with suitable top coat

Flexibility : Good

Abrasion Resistance : Good

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SURFACE PREPARATION

Steel : Remove grease, oil and other contaminants preferably by using a degreasing solvent. Abrasive blast clean to a minimum Sa 2.5 Swedish Standards SIS 05 5900. For severe corrosive conditions, abrasive blast to Sa3 with a surface profile not exceeding 55 microns. The surface should be clean and dry before application of Epilux 610 HBLD Primer Coating.

APPLICATION

Stir the base thoroughly and then mix ten parts of base and one part of catalyst by volume to uniform consistency. Allow the mixture to mature for 30 minutes and stir again before use and during application. **Brush** - Apply without thinning.

Spray : With Conventional spray, maximum of 15% thinner may be added and maintain atomizing pressure of 3.5 to 4.9 Kg/cm². In case of 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 0.38 - 0.48 mm. Tip Pressure 140 - 165 Kg/cm².

TYPICAL PAINTING SPECIFICATIONS

Surface	1st Coat	2nd Coat	3rd Coat	4th coat
Steel	Epilux 610 HBLD Primer Coating	Epilux HB MIO Coatings	Epilux 4 CR Enamel / Epilux 155 HB / Bergerthane Finish	Epilux 4 CR Enamel or Epilux 155 HB or Bergerthane Finish
Steel	Epilux 610 HBLD Primer Coating	Epilux 950 Super HB/ Epilux Durebild FRE Coating	Epilux 950 Super HB/ Epilux Durebild FRE Coating	
-do-	-do-	Epilux HB MIO Coating	Epilux 5 CTE / Epilux 555 CTE	Epilux 5 CTE / Epilux 555 CTE

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% or 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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