



Epilux 610 Primer

USES

Epilux 610 Primer possesses a history of success in fertilizer, refineries, chemical and other plants applied in diverse areas- tanks, equipment, pipelines, structural steel etc.,

SCOPE

A two pack anticorrosive epoxy primer for use on steel surfaces. The primer is ideally designed for offering superior performance in highly corrosive chemical and coastal environments. It can be overcoated with epoxy, chlororubber and polyurethane top coats.

PRODUCT DATA

Type : Two Pack, Epoxy Polyamide Primer

Composition : Catalysed Epoxy resin with Redoxide and Zinc Phosphate pigments

Volume Solids: 42 ± 2%

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

Pot Life : 5 to 6 hrs @ 30°C

Application : Brush, Air/ Airless Spray

Recommended DFT : 25 - 35 μ per coat

Corresponding WFT : 60 - 83 μ per coat

Theoretical Spreading Rate : 12.0 - 16.8 m²/ltr

Drying Time :

TOUCH : within 1 hr

HANDLE : 4-6 hours

HARD : 10- 12 hours

Curing Time : 7 days

Overcoating Interval :

MIN : 10 hours

MAX : 4 weeks

Flash Point : Above 25° C

Colour : Redoxide, Grey

Finish : Matt

Packing : 20 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 :

EXPOSURE	SPLASH & SPILLAGE	MILD FUMES / OUTDOOR RESISTANCE
Acids	Good	Good
Alkalis	Good	Good
Solvent	Very Good	Very Good
Salt	Very Good	Very Good
Water	Very Good	Very Good

Temperature Resistance :

continuous: 93°C maximum

intermittent: 120°C maximum

Weatherability : Very Good with suitable top coat

Flexibility : Good

Abrasion Resistance : Fair

DATA SHEET No. : 40-rev01

Issue Date : Oct 2016

SURFACE PREPARATION

Steel: Round off all rough welds, sharp edges and remove weld spatter. Remove grease, oil and other contaminants in accordance with SSPC SP1. Rinse surface thoroughly with clean water to remove acids or alkali contaminants. Abrasive blast to a minimum of SSPC SP10 to a surface profile of 25 - 35 microns. Remove all dust by brushing or vacuum cleaning.

APPLICATION

Stir base thoroughly and then mix two parts base and one part catalyst by volume to uniform consistency. Allow the mixture to mature for 20 minutes and stir again before application and during use.

Brush : Apply preferably without thinning.

Air-Spray: Add maximum up to 15% Thinner 844 depending on site conditions. Use any standard equipment at an atomising pressure of 3.5 to 4.9 Kg/cm²

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 30 :1, Tip size 0.38 to 0.43mm. Tip pressure 110 - 160 Kg/cm².

TYPICAL PAINTING SPECIFICATIONS

Surface	1st Coat	2nd Coat	3rd Coat	4th Coat
New Steel	Epilux 610 Primer	Epilux 4 HB MIO/ Epilux 155 HB MIO	Epilux 4 CR Enamel	Epilux 4 CR Enamel
New Steel	Epilux 610 Primer	Epilux 155 or Epilux 4 HB or Bergerthane	Epilux 155 or Epilux 4 HB or Bergerthane	
New Steel	Epilux 610 Primer	Epilux 5 CTE/ Epilux 555 CTE	Epilux 5 CTE/ Epilux 555 CTE	
Galvanised Iron & Aluminium	Degrease and abrade the surface. Apply a coat of Bison wash primer followed by any of the above systems.			

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. Always apply the paint when the dew point is 3°C higher than the substrate temperature.
4. 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.

Data Sheet # 40-rev01
Issue Date: Oct 2016