

EPI LUX 218

PROTECTIVE COATING

High-Build Epoxy Undercoat/ Finish

PRODUCT DESCRIPTION

A high-build epoxy polyamide coating with outstanding chemical resistance. The product is formulated using high quality inert pigments.

- It can be applied direct to concrete or also as a build coat for structural steel work in aggressive environments.
- Excellent resistance to fresh and salt water.
- High film build in one coat.
- Low water permeability. Good solvent and chemical resistance.

DESIGNED USE

- High build epoxy for the protection of steel and concrete.
- Suitable for application to pipelines, harbor and shore installation, tanks.
- Suitable as intermediate for upto C4 Environment as per ISO12944 Part 2 along with suitable Topcoats.

PHYSICAL DATA

Properties	Value
Volume solids (Based on ASTM D 2697)	56 % + 2 %
DFT range	75-150 microns
Typical dry film thickness	125 microns
Equivalent wet film thickness	223 microns
Theoretical spreading rate	4.5 m ² /litre @ 125 microns dft
Colour	Selected shade range
VOC "as supplied" (Based on US-EPA 24)	385 gms/ltr
Gloss level	Low sheen

APPLICATION DETAILS

METHOD OF APPLICATION

Airless Spray:

This is the recommended method of application. The Thinner percentage may be varying depends upon the line and atmospheric conditions.

Tip Size: 0.43 - 0.53 mm (0.017 - 0.021 in)

Pressure: 110 - 160 kg/cm² (1600 – 2300 psi)

Conventional Spray:

This is also a suitable method of application. The Thinner percentage may be varying depends upon the line and atmospheric conditions.

Tip Size: 1.80 - 2.20 mm (0.071 - 0.087 in)

Pressure: 2.75 - 3.45 kg/cm² (40 - 50 psi)

Brush or Roller:

May be used for intricate shapes or small area or touch-up. However, additional coats may be required to achieve the recommended film thickness. This method of application is recommended for stripe coating welds, edges, rivets etc.

Drying Time

Surface Temperature	Touch Dry	Hard Dry	Re coating Interval		Pot Life
			Min.	Max.	
20°C	2 Hrs	14 Hrs	10 Hrs	7 Days	6 Hrs
30°C	1 Hrs	7 Hrs	6 Hrs	7 Days	4 Hrs
40°C	40 Min	4 Hrs	3 Hrs	7 Days	2 Hrs

To obtain the drying time stated, it is important to maintain sufficient ventilation during application, drying and curing. If the maximum overcoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.

Properties	Value
No. of components	Two

Properties	Value
Mixing ratio (by volume)	3 parts Base to 1 part Hardener Mix until to get homogeneous mix. Allow mixed paint to rest for several minutes before use to allow air bubbles to escape.
Application conditions	Do not apply this product if the relative humidity exceeds 85% or if the substrate temperature is within 3°C of the dew point

ADDITIONAL INFORMATION

Properties	Value
Thinner / Cleaning solvent	Solvalux 7-45 / Berger Tool cleaner
Storage instruction	Store in dry, shaded conditions away from sources of heat and ignition. Containers must be kept tightly closed and upright position.
Flash point	Mixed 30°C
Shelf life @ 23°C	For base & Hardener 24 months from the date of manufacture

Packing

Unit Size	Part A			Part B		
	Vol.	Pack	Weight (typical)	Vol.	Pack	Weight (typical)
20lt	15 Lt	20 Lt	24 Kg	5 Lt	5 Lt	4.45 Kg

SURFACE PREPARATION

All surfaces to be coated should be clean, dry, and free from contamination. Prior to paint application all surfaces should be assessed and treated in accordance with ISO 8504:2000. Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning

Primed Surfaces: Epilux 218 should always be applied over a recommended anti-corrosive coating scheme. The primer surface should be dry and free from all contamination and Epilux 218 must be applied within the overcoating intervals specified (consult the relevant product data sheet).

Primed Surfaces - Metallic Zinc: Ensure zinc primers are fully cured before overcoating. Ensure that the surface of the primer is clean, dry and free from contamination and zinc salts before application of Epilux 218.

Galvanized Steel: High pressure washing is recommended as zinc salts formed may be difficult to remove. Do not use detergents. Use stiff brushes, alternatively Sweep blast the surface with a non-metallic abrasive to a sharp, dense, and uniform profile giving a dull appearance. Apply Epilux/ Epimastic range suitable primers before application of Epilux 218.

Non-Ferrous Surfaces: When substrate is aluminium or light alloy, the surface should be solvent cleaned according to SSPC-SP1 and then either etched chemically, or physically by light blast cleaning. It is important to follow application of LUXAPRIME 1500 with a paint system appropriate to the painting of aluminium.

Concrete: Should be at least 28 days old or have a moisture content of less than 5% before proceeding with epoxy primer application. Laitance and deposits on new concrete surface are preferably removed by light grit/ shot blasting, mechanical scarifying or grinding to achieve an open textured surface. EPILUX 218 may be applied directly to the clean sound concrete provided the first coat is thinned up to 20% Solvalux 7-45.

PRODUCT USE RESTRICTIONS

- Epilux 218 will have delayed curing if temperature falls below 10°C.
- Dry heat resistant 120°C (Continuous) 140°C (Intermittent).
- As common with all Epoxy products, this product also will tend to discolor and chalk on exposure to direct sunlight.

SYSTEMS COMPATIBILITY

- The following under coat are recommended: Epilux primers, Zincode 620/330, LUXAPRIME 1500.
- The following Top coat are recommended: Luxathane 5160 and Robbiathane Topcoats.
- For alternative system, consult Asian Paints Berger representative.

SAFETY PRECAUTIONS

- Avoid contact with the skin and eyes. Wear suitable protective clothing such as overalls, goggles, dust masks and gloves. Use a barrier cream.
- Ensure that there is adequate ventilation in the area where the product is being applied. Do not breathe vapor or spray.
- This product is flammable. Keep away from sources of ignition. Do not smoke. Take precautionary measures against static discharge. In case of fire – blanket flames with foam, carbon dioxide or dry chemicals.
- Refer to SDS for further information.

FIRST AID

- Eyes: In the event of accidental splashes, flush eyes with water immediately and obtain medical advice.
- Skin: Wash skin thoroughly with soap and water or approved industrial cleaner.

- Do not use solvent or thinners.
- Inhalation: Remove to fresh air, loosen collar and keep patient rested.
- Ingestion: In case of accidental ingestion, do not induce vomiting. Obtain immediate medical attention.

DISCLAIMER

The information provided on this data sheet is not intended to be complete and is provided as general advice only. It is the responsibility of the user to ensure that the product is suitable for the purpose for which he wishes to use it. As we have no control over the treatment of the product, the standard of surface preparation of the substrate, or other factors affecting the use of this product, we are not responsible for its performance nor would we accept any liability whatsoever or howsoever arising from the use of this product unless specifically agreed to in writing by us. The information contained in this data sheet may be modified by us from time to time, and without notice, in the light of our experience and continuous product development.