

EPI LUX 70

PROTECTIVE COATING

Universal Epoxy Primer

PRODUCT DESCRIPTION

A two-component Epoxy based universal primer contain zinc phosphate anticorrosive pigment for a wide range of anti-corrosive coatings systems.

- Excellent adhesion to Mild steel, Galvanized Iron, Stainless steel, aluminum, concrete etc.
- Good recoat-ability and curing in wide range of climatic conditions.
- Good Chemical and water resistance.
- Suitable for variety of ferrous & nonferrous metals.

DESIGNED USE

- Anti-corrosive blast primer for tank exteriors, structural steelwork, chemical plant pipelines and cranes.
- Epilux 70, in combination with suitable paint system, offers excellent protection in various atmospheric environments.

PHYSICAL DATA

Properties	Value
Volume solids (Based on ASTM D 2697)	57 % + 2 %
DFT range	50-200 microns
Typical dry film thickness	75 microns
Equivalent wet film thickness	130 microns
Theoretical spreading rate	7.6 m ² /litre @ 75 microns dft
Colour	Grey /Red
VOC "as supplied" (Based on US-EPA 24)	392 gms/ltr
Gloss level	Matt

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: 0.38 – 0.48 mm (0.015 - 0.019 in)

Pressure: 125 - 160 kg/cm² (1800 – 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	4 Hrs	12 Hrs	10 Hrs	7 Days	6 Hrs
30°C	3 Hrs	8 Hrs	6 Hrs	7 Days	4 Hrs
40°C	1 ½ Hrs	6 Hrs	4 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)	4 parts Base to 1 part Hardener (by volume): 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 < 29°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	16 lt	20 lt	25.6 kg	4 lt	5 lt	3.52
5lt	4lt	4lt	6.4 kg	1 lt	1 lt	0.88 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.

Carbon steel: Abrasive blast clean to a minimum of Sa2½ (ISO 8501-1:2007) or SSPC-SP10. Surface defects revealed by the blast cleaning process should be ground, filled, or treated in the appropriate manner. A surface profile of 35-50 microns is recommended. May be applied to surfaces prepared to Sa2 (ISO 8501-1:2007) or SSPC-SP6.

Stainless Steel: Abrasive sweep blasting cleaning to achieve a surface profile using non-metallic abrasive media which is suitable to achieve an anchoring surface profile depending on service condition according to ISO 8501-1:2007.

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.

Aluminium: Remove any oil and grease by fresh water washing with a suitable detergent followed by fresh water rinsing to remove remaining salts and other contaminations. Depending on service condition, proceed by abrasive sweeping. Weathered anodized aluminum shall be sweep blasted until the oxide layer has been removed.

Fiberglass (GRP): Wipe the surface with a strong solvent or wash with water using a suitable detergent to remove any remains of mold release agents. Sand the surface with coarse sandpaper or sweep blast with a small size, non-metallic abrasive.

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.

Shop primed steel: Sweep blasted or alternatively blasted to Sa 2 (ISO 8501-1) of at least 70 % of the surface.

PRODUCT USE RESTRICTIONS

- Epilux 70 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 mid coat are recommended: Epilux and Epimastic series mid coat.
- 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.