



Epilux Durebild FRE Coating

Two Pack, Epoxy Primer cum Finish

Issue Date : Feb 2025

Product Description

A high build high solids epoxy mastic coating with superior surface wetting properties for use over hand and power tool cleaned surface. Exhibits excellent resistance to weather, water and chemical environments. The product can be applied over wide range of prepared, well adhering and aged coating types.

Usage Areas

Ideal for application over floating tank roof exterior, jetty pilings, bridge underdecks and other installation where water and chemical resistance are required. The product is suitable for chemicals, fertilizers, petrochemicals, refineries and corrosive industries in both maintenance and new construction situation.

Product Data

Composition	Catalysed Epoxy Resin suitably pigmented
Volume Solids	85 ± 3 %
VOC	130 gms/ltr
Mixing Ratio	Base : Catalyst :: 4:1 (V/V)
Application Method	Brush & Airless Spray
Recommended DFT	100 - 175 µ per coat
Corresponding WFT	118 - 206 µ per coat
Theoretical Spreading Rate	4.9 to 8.5 m ² /Ltr/Coat
Colour	White & Grey
Finish	Smooth & Semi glossy

Practical Coverage : Dependent on-site condition and transfer losses due to substrate design, profile, wind, heights, application method, painter's skill etc.

Pot Life

10°C	15°C	25°C	40°C
5 hrs	3 hrs	2 hrs	1 hrs





Epilux Durebild FRE Coating

Two Pack, Epoxy Primer cum Finish

Typical Coating Systems	Systems compatibility can be provided on request to the Technical Service Team		
	Coats	Generic Systems	Compatible Products
	Primer	Inorganic Zinc, Epoxy FRE	Zinc Anode 304 HZ Coating, Epilux Durebild FRE Coating
	Mid Coat	Epoxy FRE	Epilux Durebild FRE Coating
	Top Coat	Epoxy FRE, Polyurethane	Epilux Durebild FRE Coating, BR PU High Gloss Enamel

Pack size		UOM	Part A	Part B	Total
	Volume	Lt/Kg	16 ltr	4 ltr	20 ltr

Storage	The paints must be in its sealed original containers and be kept under cover in a dry place with ambient conditions inside closed room until use. The curing agent is sensitive to moisture and hence relative humidity within the room should be maintained preferably at $\leq 55\%$. Stacking should not be more than 3 drums/ cartons one above other. DO NOT expose to direct rain/ sunlight. Any deviation to the defined storage condition shall have a negative effect on the shelf life.
---------	--

Shelf life	<p>Up to 12 months as long as the sealed original containers are kept under cover in a dry place under normal temperature conditions until use.</p> <p>Note :</p> <ol style="list-style-type: none"> Storage life @23°C will be extended up to 24 months. Storage at elevated temperatures may reduce shelf life; and hence never exceed maximum room temperature of 40°C. Storage life, thereafter, subject to re-inspection; consult tech-service. It may be noted that higher volume solid material will tend to soft settling on long term storage, and it can made to a normal homogeneous consistency by use of a slow speed 200-400 rpm power stirrer particularly in the PART A (BASE) container; and this soft settling is not considered as a failure of keeping properties.
------------	--

Flash Point	Part A	Part B	Mixed Paint
	22°C	22°C	22°C

Health & Safety	Please refer to the separate Safety Data Sheet available with detailed information.
-----------------	---





Epilux Durebild FRE Coating

Two Pack, Epoxy Primer cum Finish

APPLICATION GUIDELINE

Substrate	Mild Steel.	
Surface preparation	<p>Mild 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. Make full use of mechanical tools alongwith manual chipping and wire brushing to remove loose rust to SSPC SP2 or SP3 for Rust Grade C or D in new steel or in E for coated steel; else for Rust Grade A, B, G, H abrasive blasting is required as per SSPC SP 10 for application of the primer. For severe corrosive conditions, blast clean to SSPC SP5 Special care must be taken on weld areas to remove flux and spatter; welds should be ground back to avoid pockets. Thoroughly dust down all surfaces. The surface should be clean and dry before application of primer coat and the subsequent coats. Excessive burnishing of steel has to be avoided while working with power tools.</p>	
Atmospheric Condition	Ventilation	Suitable air engineering systems, which will ensure reduction of air contaminants and thatto further help regulate the temperature and humidity of the working environment.
	Dew Point	Ensure surface temperature to be more than 3°C over the dew point temperature.
	Humidity	Do not apply when relative humidity rises above 85%.
Mixing	<p>Stir the base thoroughly and then mix base to a homogenous liquid and then add recommended part of catalyst to uniform consistency. Allow the mixture to mature for 15 minutes and stir again before and during application.</p> <p>NOTE : Stir the base thoroughly and then mix base to a homogenous liquid and then add recommended part of catalyst to uniform consistency. Allow the mixture to mature for 15 minutes and stir again before and during application.</p>	
Thinner	Thinner 844	





Epilux Durebild FRE Coating

Two Pack, Epoxy Primer cum Finish

Application	<p>Stir the components thoroughly and then mix the base and catalyst in recommended proportion to uniform consistency. Allow it to mature for 15 minutes and stir again before use and during application.</p> <p>Brush : Apply preferably without thinning. However, if required during application, add upto 5% Thinner 844. Brushing is recommended for touching up small areas and for stripe coat only.</p> <p>Airless Spray : Add maximum upto 5% Thinner 844 if absolutely essential. Use any standard equipment with pump ratio 55:1 and a fluid tip of 17-21 though (0.43-0.53) and air supply of 80-100 psi.</p> <p>Tip size : 0.43 - 0.53 mm. Tip Pressure : 180 - 220 Kg/cm².</p>			
Work Stoppage	<p>Ensure to use the mixed paint within pot life as there are no methods to increase working pot life. Keep the working tools and tips free of drying and clogging. Always use fresh material and never add-up to previous mixed paints.</p>			
Clean Up	<p>Clean all equipment immediately after use with thinner 844. It is good working practices to flush or clean all the spray equipment periodically. All the surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations.</p>			
Drying Time	Temperature	Touch dry	Handle dry	Hard dry
	10°C	14 hrs	24 hrs	30 hrs
	23°C	8 hrs	14 hrs	20 hrs
	30°C	4 hrs	10 hrs	14 hrs
	40°C	3 hrs	6 hrs	10 hrs
Over Coating Intervals		@23°C		@30°C
	MIN	20 hrs		14 hrs
	MAX	1 month		1 month





Epilux Durebild FRE Coating

Two Pack, Epoxy Primer cum Finish

Curing Time	<p>7 days</p> <p>NOTE : Drying and Curing times are determined under controlled temperatures and at relative humidity below 85%, for the NDFT of the product.</p>
Inspection	<p>Refer SSPC PA2 guidelines for measurement of DFT.</p> <p>Do not conduct any destructive test like peel off/ pull off & high voltage Holiday test unless and otherwise mandatory in the specification.</p> <p>Consult Technical Service team for preparation of QAP (Quality Assurance plan).</p>
Repair Methodology	<p>Clean off loose paints, debris, contaminants and ensure spot repair with available tools as practiced in hand/ power tool cleaning using wire brush/buffing, emery/feathering to smoothen the edges of impaired areas. Use appropriate touch up primer followed by recommended coating system, allowing due over coating interval time to area of 2-3 inches in excess of the spot repaired portion.</p>
Product Characteristics	<ul style="list-style-type: none"> • Epilux FRX Anticorrosive Coating exhibits very good resistance to Acids when exposed to splashes, spills and good when exposed to mild fumes. • Excellent resistance to Solvents & Alkalis when exposed to mild fumes and very good when exposed to splashes, spills. • Excellent resistance to Salt & Water when exposed to splashes, spills and mild fumes. • The temperature resistance is 100°C for continuous use and 120°C for intermittent use. • The material exhibits excellent abrasion resistance.
Disclaimer	<p>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.</p>