



EPI LUX 78 HBTL

Two Pack Epoxy Tank Liner

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Product Description

A high build high performance tank liner specially designed for sustained immersion service. A self priming coating, this product possesses excellent solvent, chemical and saline water resistance. The product is ideal for storage of Petroleum Hydrocarabon cargoes including ATF, as well as potable water.

Usage Areas

Recommended for use as a tank lining (both mild steel and concrete) in Fertilizer, Refineries, Petrochemicals, Heavy Chemicals and other Plants. The product passes MIBK Resistance Test.

Product Data

Composition	Aromatic Amine Adduct cured Epoxy Resin suitably pigmented
Volume Solids	62±2%
VOC	327 gms / ltr
Mixing Ratio	Base : Catalyst - 4 : 1 by volume
Application Method	Airless or Conventional Spray (Brush for touch up)
Recommended DFT	100 - 150 microns per coat
Recommended WFT	161 - 242 µ per coat
Theoretical Spreading Rate	4.1 - 6.2 m ² /ltr
Colour	White, Light Grey & Dark Grey
Finish	Matt to Egg Shell Gloss

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
	7 hrs	6 hrs	4 hrs	2 hrs





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Typical Coating Systems	Systems compatibility can be provided on request to the Technical Service Team		
	Coats	Generic Systems	Compatible Products
	Primer	Epoxy Primer	For Steel : Epilux FRX AC Coating / Epilux 13 HB / Zinc Anode 304 / Epilux 65 ZR For Concrete : Epilux 4 Clear / Epilux 78 HBTL (thin)
	Mid Coat	Epoxy Tank Lining	Epilux 78 HBTL
	Top Coat	Epoxy Tank Lining	Epilux 78 HBTL

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.
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Shelf life	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. Note : - 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.
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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.
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APPLICATION GUIDELINE

Substrate	Steel, Concrete	
Surface preparation	Steel : Remove grease, oil and other contaminants preferably by Solvent cleaning to SSPC SP1. Abrasive Blast clean to a minimum of SSPC SP10. For severe corrosive conditions, blast to SSPC SP5 with a surface profile not exceeding 55- 65 microns. The surface should be clean and dry before application of Epilux 78 HBTL or appropriate primer coat. Concrete : New Concrete : Ensure that the concrete is cured for a minimum of three months. The surface is to be made rough and free from laitance and other contaminants by sand sweeping. Old Concrete : Remove all salt deposits from the surface by water jet washing. Light sweep blast the surface to remove all loosely bound coatings and roughening of firmly adhering coatings to ensure anchorage with recommended system. Ensure all dust / other particles are fully removed by suction or air blast and the surface is fully clean and dry before application of paint. In non-critical area where blasting is not possible, water jet washing and hard wire brushing are minimum requisites.	
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	Stir the base thoroughly and then mix base to a homogenous mixture and then add recommended part of catalyst to uniform consistency. NOTE : DO NOT ADD THINNER beyond recommendation as it will reduce mixed VS calling for revised WFT calculations as well as challenges on flow properties.	
Thinner	Thinner 844	





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Application	Allow the mixture to mature for 30 minutes and stir again before application and during use. Brush : Add upto 5% Thinner 844 during application. Conventional Spray : Normally not recommended for application at high thickness. However, application by conventional spray by pressure pot gun can be done using upto 15% Thinner 844. Use any standard pressure pot equipment at an atomising pressure of 3.7 - 4.9 Kg / cm². Airless Spray : Apply preferably without thinning. However, if required add upto 5% Thinner 844. Use any standard equipment with pump ratio 55 : 1. Tip Size : 0.43 - 0.48 mm. Tip Pressure : 110 - 160 Kg/Sq cm.			
Work Stoppage	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.			
Clean Up	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.			
Drying Time	Temperature	Touch Dry	Handle Dry	Hard Dry
	10°C	16 hrs	18 hrs	24 hrs
	23°C	6 hrs	10 hrs	20 hrs
	30°C	3 hrs	6 hrs	12 hrs
	40°C	2 hrs	4 hrs	8 hrs
Over Coating Intervals		@23°C		@30°C
	MIN	10 days		4 hrs
	MAX	15 days		5 days





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Curing Time	5 days NOTE : Drying and Curing times are determined under controlled temperatures and at relative humidity below 85%, for the NDFT of the product.
Inspection	Refer SSPC PA2 guidelines for measurement of DFT. Do not conduct any destructive test like peel off/ pull off & high voltage Holiday test unless and otherwise mandatory in the specification. Consult Technical Service team for preparation of QAP (Quality Assurance plan).
Repair Methodology	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.
Product Characteristics	• Conforms to food grade- approval certificate from CFTRI, Mysore available as per USFDA test 21 CFR 175-300. Based on VALSPAR/ MOBIL, USA technology and is equivalent to High Build Epoxy 78 series. • EPILUX 78 HBTL exhibits excellent resistance to immersion in Alkalis, Solvents, Salt (up to 80°C), and Water, making it suitable for chemically aggressive environments. • It offers moderate flexibility, ensuring decent performance under structural movement. • Abrasion resistance is very good, enhancing durability in high-wear conditions.
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.