BERGER PROTECTON
PROTECTIVE COATINGS DIVISION

Epilux HB DTM Coating

Two Pack Epoxy DTM Coating

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Product Description

A low VOC quick drying DTM (direct to metal) epoxy coating for application on steel structures that are exposed to moderate corrosive, inland atmospheric conditions. It is overcoatable with Epoxy, Polyurethane and Synthetic Enamel Top Coats if required.

Usage Areas

A quick drying two pack high build epoxy primer cum finish coating suitable for application on well prepared mild steel for moderate atmospheres. An ideal coating for equipment, pipeline structurals in power plants as well as steel plant.

Product Data

Composition	Epoxy / Specially designed modified Polyamide Resin / Inert Pigments
Volume Solids	78 ± 3%
VOC	190 - 215 gm/ltr
Mixing Ratio	Base : Catalyst :: 6 : 1 by volume
Application Method	Brush and Spray
Recommended DFT	75 - 180 µ per coat
Recommended WFT	96 - 231 µ per coat
Theoretical Spreading Rate	4.3 - 10.4 m^2/ltr/coat
Colour	Assorted shades
Finish	Smooth and 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
7 hrs	5 hrs	3 hrs	1 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 DTM	Epilux HB DTM Coating
Mid Coat	Epoxy DTM	Epilux HB DTM Coating
Top Coat	Polyurethane (optional)	Bergerthane Finish

Pack size

	UOM	Part A	Part B	Total
Volume	Lt/Kg	18 ltr	3 ltr	21 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 ≤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

Up to 9 months as long as the sealed original containers are kept under cover in a dry place under normal temperature conditions until use.

Note :

1. Storage life @23°C will be extended up to 18 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.
2. 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
28°C	23°C	28°C

Health & Safety

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

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APPLICATION GUIDELINE

Substrate	Mild Steel	
Surface preparation	**Mild Steel :** Remove grease, oil and other contaminants preferably by using Solvent Cleaning to SSPC SP1. Abrasive blast clean to a minimum of SSPC SP10 (Sa2.5) with a surface profile not exceeding 50 microns. Excessive burnishing of steel is to be avoided. Thoroughly dust down all surfaces. Special care must be taken on weld areas to remove flux and spatter; welds should be ground back to avoid pockets. The prepared surface should be clean and dry and coated before it gets contaminated.	
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

Mix the contents thoroughly before and during use. Stripe coat is recommended on welded areas and on edges

Brush : Apply preferably without thinning. If required, add upto 5% Thinner 844 depending on conditions.

Conventional Spray : : Add upto 10-20% Thinner 844. Use any standard equipment at an atomising pressure of 4.2-4.9 Kg/cm^2.

Airless Spray : Add upto 5-15% Thinner 844 if required. Use any standard equipment having pump ratio 30:1.

Tip size 0.28.0.38. **Tip pressure** 110-160 kg / cm^2.

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	3 hrs	12 hrs	24 hrs
23°C	105 mins	8 hrs	16 hrs
30°C	90 mins	7 hrs	14 hrs
40°C	75 mins	6 hrs	12 hrs

Over Coating Intervals

MIN	11 hrs
MAX	1 Week

Curing Time

7 days

NOTE : Drying and Curing times are determined under controlled temperatures and at relative humidity below 85%, for the NDFT of the product.

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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	• Epilux HB DTM Coating shows good resistance to Solvents under Splash, Spillage, and Mild Fumes exposure. • It shows very good resistance to Acids, Alkalis, Salt and Water under Splash, Spillage, and Mild Fumes exposure.
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.