



# BP HB DTM Coating

## Single Pack High Build Synthetic Monocoat

Issue Date : September 2025

### Product Description

A low VOC quick drying DTM (direct to metal) coating for application on steel structures that are exposed to mild to moderate corrosive, inland atmospheric conditions.

### Usage Areas

A single pack high build primer cum finish coating suitable for application on well prepared mild steel for mild and moderate atmospheres.

### Product Data

|                            |                                    |
|----------------------------|------------------------------------|
| Composition                | Alkyd Resin suitably pigmented     |
| Volume Solids              | 64 ± 2%                            |
| VOC                        | 300 - 315 gm/ltr                   |
| Application Method         | Brush and Spray                    |
| Recommended DFT            | 75 - 125 µ per coat                |
| Recommended WFT            | 117 - 188 µ per coat               |
| Theoretical Spreading Rate | 5.3 - 8.5 m <sup>2</sup> /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.





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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   | Alkyd DTM        | BP HB DTM Coating        |
|                         | Mid Coat   | Alkyd DTM        | BP HB DTM Coating        |
|                         | Top Coat   | Alkyd (Optional) | Berger Torpedo QD Enamel |

|           |        |       |        |        |        |
|-----------|--------|-------|--------|--------|--------|
| Pack size |        | UOM   | Part A | Part B | Total  |
|           | Volume | Lt/Kg | 20 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 9 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"> <li>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.</li> <li>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.</li> </ol> |
|------------|---|

|             |        |        |             |
|-------------|--------|--------|-------------|
| Flash Point | Part A | Part B | Mixed Paint |
|             | 28°C   | 28°C   | 28°C        |

|                 |   |
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| 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   | 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 35-50 microns. Only in terms of steel with rust grade 3 and 4 if blasting is not practical, then use of mechanical tools alongwith manual chipping and wire brushing to remove loose rust and contaminants to SSPC SP2/SP3. Excessive burnishing of steel is to be avoided. Thoroughly dust down all surfaces. The surface should be clean and dry before application of Paint.   |   |
| 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.<br>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 853 or T50  |   |
| Application           | <p>Mix the contents thoroughly before and during use. Stripe coat is recommended on welded areas and on edges</p> <p><b>Brush :</b> Apply preferably without thinning. If required, add upto 5% Thinner 853 depending on conditions.</p> <p><b>Conventional Spray :</b> Add upto 10% Thinner 853. Use any standard equipment at an atomising pressure of 4.2-4.9 Kg/cm<sup>2</sup>.</p> <p><b>Airless Spray :</b> Add upto 20% Thinner T50/ 853 (subject to environmental condition) if required. Use any standard equipment having pump ratio 30:1. Tip size 0.28.0.38 mm; tip pressure 110-160 kg / cm<sup>2</sup>.</p> |   |





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|------------------------|--|-----------|------------|----------|
| 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 853 or T50. 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   | 120 mins  | 8 hour     | 24 hrs   |
|                        | 23°C   | 70 mins   | 5 hrs      | 14 hrs   |
|                        | 30°C   | 60 mins   | 4 hrs      | 12 hrs   |
|                        | 40°C   | 50 mins   | 3 hrs      | 10 hrs   |
| Over Coating Intervals | MIN  | 10 hrs    |            |          |
|                        | MAX  | 4 weeks   |            |          |
| Curing Time            | 7 days<br><br>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.<br>Do not conduct any destructive test like peel off/ pull off & high voltage Holiday test unless and otherwise mandatory in the specification.<br>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. |           |            |          |





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| <b>Product Characteristics</b> | <ul style="list-style-type: none"> <li>• BP HB DTM Coating has fair resistance to alkalis and solvents under splash, spillage, and mild fumes or outdoor exposure.</li> <li>• It provides very good resistance to acids under splash, spillage, and mild fumes or outdoor exposure.</li> <li>• It offers good resistance to salt and water under splash, spillage, and mild fumes or outdoor exposure.</li> <li>• The coating is not recommended for immersion.</li> </ul>   |
| <b>Disclaimer</b>              | <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> |