

EPILUX TIE COAT

Epoxy Tie Coat

**PRODUCT
DESCRIPTION**

A two pack epoxy coating used as tie coat especially on Zinc Silicate primer.

DESIGNED USE

- Used as an intermediate coat with good abrasion resistance.
- EPILUX TIE COAT may be over coated with Berger's single and two pack coating.
- Suitable as tie coat for upto C5 Environment as per ISO12944 Part 2 along with suitable intermediate and topcoats

PHYSICAL DATA

VOLUME SOLIDS (Based on ASTM D2697)	47 % $\pm$ 2 %
TYPICAL DRY FILM THICKNESS	50 microns
WET FILM THICKNESS	106 microns
THEORETICAL COVERAGE	9.4 m ² /litre @ 50 microns DFT
VOC "As Supplied" (Based on ASTM D3960)	470 gms/ltr
COLOUR	Grey/ Red Oxide
FINISH	Slight Sheen

**APPLICATION
DETAILS****METHOD OF APPLICATION :****AIRLESS SPRAY**

This is the recommended method of application:
Maximum 5% Thinner may be added.
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.
Maximum 20% Thinner may be added
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 difficult shapes or touch-up.
However, additional coats may be required to achieve the recommended film thickness.

DRYING TIME:

Surface Temperature	Touch Dry	Hard Dry	Over coating Interval		Pot Life
			Minimum	Maximum	
15°C	3 Hrs	6 Hrs	20 Hrs	Indefinite	16 Hrs
25°C	2 Hrs	3 Hrs	18 Hrs	Indefinite	6 Hrs
35°C	1 Hr	2 Hrs	10 Hrs	Indefinite	4 Hrs
45°C	40 mins	1½ Hrs	8 Hrs	Indefinite	2 Hrs

NO. OF COMPONENTS Two

Mixing Ratio 4 parts Base to 1 Part Hardener (by volume)

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**

Thinner / Cleaning solvent	Solvalux 7-45
Storage Instruction	Store in a cool shaded dry area
Flash Point	Mixed 30°C
Packaging	5 liters & 20 liters
Shelf Life	12 months from the date of manufacture.

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**SURFACE
PREPARATION**

- This product should be applied to surface that has been blast cleaned. It has to be applied on top of EPILUX or ZINCANODE Primers.
- Remove all wax, oil and grease by solvent cleaning in accordance with the guidelines given by SSPC-SPI.
- Where necessary remove weld spatter and round off all rough weld seams and sharp edges to a smooth surface.
- Abrasive blast clean to a minimum standard of Sa 2 ½ Swedish Standard SIS 05 59 00 or ISO 8501-1 : 1988
- Any surface defects revealed by blast cleaning should be ground, filled or treated in a suitable manner.
- An average surface profile of 50 microns is acceptable, but this average should not exceed 75 microns.
- After blasting, remove dust from the surface.
- The surface to be coated must also be clean and dry.
- If applied over Zinc silicate ensure that the surface is fully cured and free from zinc salts prior to painting.

**PRODUCT USE
RESTRICTIONS**

- EPILUX TIE COAT will not cure below 10°C.
- Dry heat resistance up to 120°C.
- As common with all Epoxy products, this product also will tend to discolour and chalk on exposure to direct sunlight.
- May also be applied between 25 and 60 Microns DFT.
- Contact Berger Representative for suggesting suitable paint system.

**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 MSDS 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.