SAKSHI TUF 460 (COAL TAR EPOXY)

DATA SHEET

DESCRIPTION

SAKSHI TUF 460 is a two component polyamide cured coal Tar epoxy coating

PRINCIPAL CHARACTERISTICS

- Excellent water resistance
- Excellent corrosion resistance
- Can be used in a wide variety of immersion conditions
- Excellent anticorrosive coating for underwater area, water ballast tanks, bilges etc
- Can be used for RCC structures, bridges, piles, conveyors, structural steel etc

COLOURS AND GLOSS

Black, Brown – Egg shell

BASIC DATA

Volume solids	65 ± 2%
Recommended Dry Film Thickness	75 - 125 microns (115-192 microns wet)
Theoretical Spreading Rate	6.5 m^2/l, at 100µm DFT (154 microns wet)
Surface dry @ 30 ^{0}C	4 hours
Hard dry @ 30 ^{0}C	18 hours
Over coating interval	Min 18 hours Max -5 days
Flash point	Part A 27°c; Part B >101°c; Mixed 30°c
Product weight	1.4kg/litre
VOC	392g/ltr (calculated

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RECOMMENDED SUBSTRATE SUBSTRATE CONDITIONS AND TEMPERATURES

- Steel blast cleaned to ISO – Sa2.5
- Existing coal tar epoxy coating : sufficiently roughened and free from any contamination
- Steel with approved zinc silicate shop primer – sweep blasted to SPSS - Ss or power tool cleaned to SPSS – Pt3
- Substrate temperature should be at least 3°C above dew point and maximum relative humidity should be 85%

INSTRUCTIONS FOR USE

Mixing Ratio by volume: Base to Hardener: 4:1

- The temperature of the mixed base and hardener should preferably be above 15°C, otherwise extra solvent may be required to obtain application viscosity
- Too much solvent results in reduced sag resistance and slower cure
- Thinner should be added after mixing the components

INDUCTION TIME

None

POT LIFE

4 hours at 30°C

AIRLESS SPRAY

Recommended Thinner	SAKSHI THINNER 400
Volume of Thinner	0-5% depending on required thickness and application conditions
Nozzle Orifice	Approx. 0.021
Nozzle Pressure	Approx. 150 bar; 2130 psi

AIR SPRAY

Recommended Thinner	SAKSHI THINNER 400
Volume of Thinner	0-5% depending on required thickness and application conditions
Nozzle Orifice	1.5 – 3.00 mm
Nozzle Pressure	Approx. 3 -4 bar; 43-57 psi

BRUSH/ROLLER

Only for touch up and spot repair
Use appropriate size China bristle brush.

Recommended Thinner	SAKSHI THINNER 400
Volume of Thinner	0-5 %

CLEANING SOLVENT

SAKSHI THINNER 400

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SAFETY PRECAUTIONS

This is a solvent based paint and care should be taken to avoid inhalation of spray mist or vapour as well as contact between the wet paint and exposed skin and eyes.

ADDITIONAL DATA

Film Thickness and Spreading Rate

Theoretical spreading rate m^2/l	8.67	6.5	5.2
Dft in µm	75	100	125

Maximum DFT when brushing (touch up and spot repair) 50µm

For EXLTUF Over coating table for DFT up to 100 µm

Substrate Temperature	20°C	30°C	40°C
Minimum interval	24 Hrs	18 Hrs	14Hrs
Maximum Interval	10 days	5 days	4 days

- Surface should be dry and free from contamination
- When over coated with other paints tar bleeding will occur

SYSTEM COMPATIBILITY : primers and no Intermediates are recommended for SAKSHI TUF 460 and over coated with SAKSHI TUF 460 itself.

PACK SIZE 20 LTR 10LTR,& 4 LTR

SHELF LIFE 12 months minimum at 30°C (86°F). Store in dry, shaded conditions away from sources of heat and ignition. Protect from frost.