

DATA SHEET

PRODUCT DESCRIPTION

SAKSHI GARD 610 is a low VOC, two component, high build Surface tolerant epoxy maintenance coating.

PRINCIPAL CHARACTERISTICS

SAKSHI GARD 610 is a surface tolerant coating for compromised surface preparation.

General Purpose Epoxy high build coat in Protective coating system for steel structures exposed to atmospheric land or marine conditions.

SAKSHI GARD 610 suited as a maintenance coating for offshore and onshore steel structures.

SAKSHI GARD 610 compatible with various aged coatings.

SAKSHI GARD 610 overcoat able with most types of coatings.

Aluminium pigmented version of SAKSHI GARD 610 gives extra corrosion resistance.

COLOURS AND GLOSS

Range - Semi Gloss (Aluminium is egg shell)

BASIC DATA

Volume solids

82 ± 3 % (depends on colour)

Recommended Dry Film Thickness

100 – 200 microns (122-244 microns wet)

Theoretical Spreading Rate

8.2 m²/l, for 100 µm DFT

Practical Spreading Rate

Allow appropriate loss factors

Surface dry @ 30 °C

3 hours

Hard dry @ 30 °C

12 hours

Over coating interval

Min 12 hours

Max - 1month

Flash Point

Base 36°C, Hardener 56°C, Mix 33°C

VOC

175 g/l

Product Weight

1.6kg/l

Working Pot life @30 °C

1hour 30minutes.

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RECOMMENDED SUBSTRATE

The performance of this product will depend upon the degree of surface preparation.

SUBSTRATE CONDITIONS AND TEMPERATURES

The surface to be coated should be clean, dry and free from contamination.

Accumulated dirt and soluble salts must be removed.

Abrasive Blast Cleaning

For immersion service and for atmospheric exposure best performance will be achieved when SAKSHI GARD 610 is applied to surfaces prepared to a minimum of Sa2½ (ISO 8501-1:1988) or SSPC-SP6.

A surface profile of 50-75 microns (2-3 mils) is recommended.

Hand or Power Tool Preparation

Hand or power tool clean to a minimum St2 (ISO 8501-1:1988) or SSPC-SP2.

Aged Coatings

SAKSHI GARD 610 is suitable for over coating intact, aged alkyd, epoxy and polyurethane systems.

However, this product is not recommended where thermoplastic coatings such as chlorinated rubbers and vinyls have previously been used.

Level of sheen and surface finish is dependent on application method. Avoid using a mixture of application methods whenever possible.

In common with all epoxies SAKSHI GARD 610 will chalk and discolour on exterior exposure.

Premature exposure to ponding water will cause a colour change, especially in dark colours.

Surface temperature must always be a minimum of 3°C (5°F) above dew point.

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 both components.

APPLICATION

Mixing - Material is supplied as a Base and Curing Agent in two containers as a unit. Always mix a complete unit in the proportions supplied.

Once the unit has been mixed it must be used within the working pot life specified. Use power agitator for mixing Base (Part A) with a Curing Agent (Part B)

APPLICATION

Mix Ratio

6 Parts of base: 1 Part of Curing Agent (by volume)

AIRLESS SPRAY:

In one coat maximum film thickness can be achieved by Airless spray.

Recommended Thinner
Volume of Thinner

SAKSHI THINNER 400
0-5% depending on required thickness and application conditions.

Nozzle Orifice
Nozzle Pressure

Approx. 0.45 – 0.58 mm (18 – 23 thou)
Approx. 176 kg / cm²; 2500 psi

AIR SPRAY

Application by air spray may require a multiple coats to attain
Maximum film thickness.

Recommended Thinner
Volume of Thinner

SAKSHI THINNER 400
Use suitable proprietary equipment. Thinning may be required.

BRUSH/ROLLER

Only for touch up and spot repair

Recommended Thinner
Volume of Thinner

SAKSHI THINNER 400
May be necessary at low temperatures,

CLEANING SOLVENT

SAKSHI THINNER 400

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

Systems Compatibility

SAKSHI GARD 610 will normally be applied to correctly prepared Steel substrates. However, it can be used over suitably primed Surfaces. Suitable primers are:

SAKSHI GARD 410, SAKSHIGARD 415

Where a cosmetically acceptable topcoat is required the following Products are recommended:

SAKSHIGARD 421, SAKSHIGARD 425, SAKSHIGARD 430
SAKSHI THANE 510, SAKSHI THANE 525, SAKSHI THANE 530

PACK SIZE

20 LTR, 10 LTR & 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.

LIMITATION OF LIABILITY

The information in this data sheet is based upon laboratory tests we believe to be accurate and is intended for guidance only. All recommendations or suggestions relating to the use of the products made by **SAKSHI COATING PVT. LTD.** whether in technical documentation or in response to a specific enquiry, or otherwise, are based on data which to the best of our knowledge are reliable. The products and information are designed for users having requisite knowledge and industrial skills and it is the end-user's responsibility to determine the suitability of the product for its intended use.

SAKSHI COATING PVT. LTD. has no control over either the quality or condition of the substrate, or the many factors affecting the use and application of the product. **SAKSHI COATING PVT. LTD.** does therefore not accept any liability arising from loss, damage or injury resulting from such use or the contents of this data sheet.

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