

DATA SHEET

DESCRIPTION	SAKSHI LINE 450 high performances, highly cross linked two component Epoxy Phenol Novolac coating with excellent heat, Chemical and Solvent resistance.
PRINCIPAL CHARACTERISTICS	SAKSHI LINE 450 is suitable to use for the internal lining of chemical and crude oil storage tank and process vessels in petrochemical plants. Heat resistance up to 125°C. SAKSHI LINE 450 having excellent Chemical and solvent resistance Provides good resistance to aromatic and aliphatic solvents. SAKSHI LINE 450 to achieve its full chemical resistance properties, after full curing
COLOURS AND GLOSS	Limited range and Gloss level not applicable
BASIC DATA	
Volume solids	65 ±2%
Recommended Dry Film Thickness	85 -125 microns (127-187microns) wet
Theoretical Spreading Rate	6.5 m ² /l, at 100 microns DFT
Surface dry @ 30 °C	4 hours
Hard dry @ 30 °C	16 hours
Over coating interval	Min 16 hours Max - 7 days
Flash Point	Part A 26°C; Part B 48°C, Mixed 24°C
Product weight	1.80± 0.03 kg/litre
VOC	286g/lit (calculated)

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RECOMMENDED SUBSTRATE SUBSTRATE CONDITIONS AND TEMPERATURES

- Steel blast cleaned to SSPC SP10 or Sa 2 ½ (ISO 8501–1:2007)
- All surfaces to be coated should be clean, dry and free from Contamination.
- Oil and greases should be removed as per SSPC-SP1 solvent Cleaning.
- Remove weld spatter and smooth weld seams and sharp edges
- A sharp, angular surface profile of 50-75 microns is recommended.
- 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 6:1

- 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

POT LIFE

1.5 hours at 30 ° C

AIRLESS SPRAY:

Recommended Thinner
Volume of Thinner

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

Nozzle Orifice
Nozzle Pressure

Approx. 0.43 – 0.53 mm (17– 21thou)
Approx. 176 kg/ cm²(2503 psi)

AIR SPRAY

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

BRUSH/ROLLER

Recommended Thinner
Volume of Thinner

Only for touch up and spot repair (50-75 microns) can be achieved
SAKSHI THINNER 400
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	7.65	6.50	5.20
Dft in µm	85	100	125

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

Over coating table for DFT up to 125 µm:

Substrate Temperature	20°C	30°C	40°C
Minimum interval	20 Hrs	16 Hrs	14 hours
Maximum Interval	5 days	3 days	3 days

SYSTEM COMPATIBILITY

: **SAKSHI LINE 450** is self-priming can be applied directly to the Substrate and can be over coated with itself.
No other primers and top coats are recommended for this Product.

PACK SIZE

20ltr, 10Ltr and 4ltr

SHELF LIFE

12months 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. **Date-JAN. 2019**