

## DATA SHEET

### DESCRIPTION

SAKSHI GARD 410 is a two component polyamide cured epoxy anti - corrosive primer for metal and concrete substrates.

### PRINCIPAL CHARACTERISTICS

- SAKSHI GARD 410 is a general purpose epoxy primer for steel and concrete surfaces.
- SAKSHI GARD 410 Can be recoated with various two pack and conventional coatings.
- SAKSHI GARD 410 is provides a tough, flexibility and excellent abrasion and corrosion resistance coating.
- SAKSHI GARD 410 is a quick drying and easy to apply by both spray and brush.
- For use at both new construction and maintenance.

### COLOURS AND GLOSS

Red, Grey&Yellow – Matt

### BASIC DATA

Volume solids	48 ± 2%
Recommended Dry Film Thickness	40 - 50 microns
Theoretical Spreading Rate	16 m <sup>2</sup> /l at 30 microns DFT
Surface dry @ 30 °C	45 Minutes
Hard dry @ 30 °C	16 hours
Over coating interval	Min 16hours Max - extended
Flash Point	Part A 26°C, Part B 25°C, Mixed 26°C
Product weight	1.41 kg/ltr
VOC	559g/lt(calculated)

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### RECOMMENDED SUBSTRATE SUBSTRATE CONDITIONS AND TEMPERATURES

- Steel blast cleaned to ISO – Sa2.5(ISO 8501–1:1998)
- 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

3 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. 0.38 – 0.53 mm (15 – 21thou)  
Approx. 150 kg / cm<sup>2</sup>; 2130 psi

### AIR SPRAY

Recommended Thinner  
Volume of Thinner

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  
SAKSHI THINNER 400  
0-5 % As per requirement

### 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

## Film Thickness and Spreading Rate

Theoretical spreading rate m <sup>2</sup> /l	12.00	9.60
Dft in µm	40	50

Maximum dft when brushing (touch up and spot repair) 40µm

## Over coating table for DFT up to 50 µm

Substrate Temperature	20°C	30°C	40°C
Minimum interval	20Hrs	16 Hrs	12 Hrs
Maximum Interval	Extended	Extended	Extended

- Surface should be dry and free from contamination

## SYSTEM COMPATIBILITY

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The following top coats are recommended for SAKSHI GARD 410:  
All Epoxy and PU top coats

## PACK SIZE

20 LTR SAKSHI GARD 410 Base 16 LTR in a 20 LTR container  
SAKSHI GARD 410 Hardener, 4 LTR in a 4LTR container

## 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. **Date-JAN. 2019**