SAKSHI GARD 410 (EPOXY ANTICORROSIVE PRIMER)

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^2/l at 30 microns DFT
Surface dry @ 30 ^{0}C	45 Minutes
Hard dry @ 30 ^{0}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)

DATA SHEET

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: SAKSHI THINNER 400

Volume of Thinner: 0-5% depending on required thickness and application conditions

Nozzle Orifice: Approx. 0.38 – 0.53 mm (15 – 21thou)

Nozzle Pressure: Approx. 150 kg / cm ^{2}; 2130 psi

AIR SPRAY

Recommended Thinner: SAKSHI THINNER 400

Volume of Thinner: Use suitable proprietary equipment. Thinning may be required.

BRUSH/ROLLER

Only for touch up and spot repair

Recommended Thinner: SAKSHI THINNER 400

Volume of Thinner: 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^2/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 : The following top coats are recommended for SAKSHI GARD 410:
All Epoxy and PU top coats

PACK SIZE 20 LTR SAKSHI GARD 410 Base16 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.