

DATA SHEET

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| DESCRIPTION | SAKSHI TUF 460 is a two component polyamide cured coal Tar epoxy coating |
| PRINCIPAL CHARACTERISTICS | <ul style="list-style-type: none">- 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 °C | 4 hours |
| Hard dry @ 30 °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
Volume of Thinner
Nozzle Orifice
Nozzle Pressure

SAKSHI THINNER 400
0-5% depending on required thickness and application conditions
Approx. 0.021
Approx. 150 bar; 2130 psi

AIR SPRAY

Recommended Thinner
Volume of Thinner
Nozzle Orifice
Nozzle Pressure

SAKSHI THINNER 400
0-5% depending on required thickness and application conditions
1.5 – 3.00 mm
Approx. 3 -4 bar; 43-57 psi

BRUSH/ROLLER

Recommended Thinner
Volume of Thinner

Only for touch up and spot repair
Use appropriate size China bristle brush.
SAKSHI THINNER 400
0-5 %

CLEANING SOLVENT

SAKSHI THINNER 400



DATA SHEET**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**

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|--|------|-----|-----|
| 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.

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, 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.

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