



## EPOXY HIGH BUILD

This product has exceptional film build and sag resistant properties, and is specially designed for use by airless spray to give economic application in very thick film i.e. upto 250-300 microns (10-12 Mils) per coat. Its main use is as the intermediate coat in an Epoxy High build protective system, where maximum chemical and abrasion resistance properties are required. It has good chemical, water and solvent resistance and can be used as a low-gloss, high-build finish coat for external and internal use.

### PHYSICAL CHARACTERISTICS OF WET PAINT

<b>(Typical colour-Black Brown will vary)</b>		
<b>Pigment composition</b>	Titanium dioxide, mineral extenders	
<b>Pigment %</b>	50%	
<b>Binder type</b>	Epoxy resin/amine adduct	
<b>Binder %</b>	22%	
<b>Thinner composition</b>	Aromatic hydrocarbons/ketones	
<b>Thinner%</b>	27%	
<b>Volume solids%</b>	53%	
<b>Specific gravity of mixed paint</b>	1.46	
<b>Base: Activator ratio by volume</b>	11.5:1	
<b>Pot life</b>	At 20° C	6 hours
	At 10° C	22 hours

### PHYSICAL CHARACTERISTICS OF DRY FILM

<b>Drying time of Standard thickness</b>	At 30° C	10 Hours	
	At 20° C	18 hours	
	At 10° C	23 hours	
<b>Curing time before use</b>	At 30° C	3 days	
	At 20° C	4 days	

	At 10° C	7 days	
<b>N.B. - Epoxy curing</b>	The curing of Epoxy resin-based coating is temperature dependent. It is seriously retarded below 5°C (41°F).		
<b>Recoating times</b>		<b>Minimum</b>	<b>Maximum</b>
	At 30° C	6 hours	2 days
	At 20° C	20 hours	3 days
	At 10° C	21 hours	5 days
<b>Standard thickness</b>	<b>Wet Paint</b>	240-280 microns (9.6-11.2 Mils)	
	<b>Dry film</b>	125-150 microns (5-6 mils)	
<b>Theoretical coverage on smooth surfaces</b>	3.53-1.21 M2/Litre (19.0-23 sq.yds./imp.gln.2.90 M2/kg.		

## APPLICATION

<b>Brush/roller</b>	Not recommended
<b>Conventional spray</b>	Not recommended
<b>Airless spray</b>	
<b>Thinner addition by volume</b>	Upto 5%
<b>Recommended thinner</b>	Epoxy thinner

## SURFACE PREPARATION

Epoxy Bildcote is normally applied over Zinc Rich Primer Two-Pack, Epoxy Zinc Phosphate Primer Two-Pack, Epoxy Protective Primer Two-Pack. The protective primer must be clean, sound and firmly adhering. (Polyvinyl butyral shop primers should not be used under conditions of continuous immersion or in conjunction with cathodic protection). The removal of contamination must include washing with fresh water to remove soluble salts.

## PAINT SYSTEM

One or two coats Epoxy Bildcote to a minimum thickness of 200 Microns (8 Mils) followed by Epoxy Finish if required. When used as a self-finish the minimum dry film thickness must be 250 Microns (10 Mils).

## Pack size

**Base** - 20 liters  
**Activator** - 4 liters

## CONTACT :

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