

PRODUCT SPECIFICATIONS

Product Description

A two component, polyamide cured high build epoxy coating specially formulated as an intermediate cum finish coat.

Design Feature

- An intermediate or finish coat for the protection of structural steel in marine and other aggressive environments.
- Excellent anti-corrosive barrier properties.
- Low permeability to moisture.
- Good abrasion resistance.
- Resistant to spillage or splashes of mild chemicals.
- Recommended for use on slip resistant concrete floorings.

Physical Characteristics

Recommended Application Data		Wet [µm]	Dry [µm]	m²/l
Theoretical Coverage		208	125	4.80
Volume Solids	:	60% (based on ASTM D2697)		
Dry Film Thickness Range	:	75 µm to 200 µm		
Flash Point	:	28 °C		
Finish	:	Low Sheen		
Colour Range	:	Standard		
Standard Packing Size	:	5 L Set (3.75 L Base : 1.25 L Hardener) 20 L Set (15 L Base : 5 L Hardener)		
Mix Ratio (by volume)	:	3 Base : 1 Hardener		

Application Method

AIRLESS SPRAY	:	Tip Size	:	0.53 – 0.58 mm (21 – 23 thou)
Recommended method of application	:	Pressure	:	110 – 160 kg/cm² (1600 – 2300 psi)
CONVENTIONAL AIR SPRAY	:	May be used. May require additional dilution to achieve good atomisation.		
BRUSH OR ROLLER	:	May be used. However, additional coats may be required to achieve the recommended film thickness. Suitable for stripe coating, weld-seams, edges, corners, rivets, etc.		

Drying & Curing Time

Substrate Temperature	Touch Dry	Hard Dry	Overcoating Interval		Pot Life
			Min.	Max.	
15 °C	6 hours	24 hours	24 hours	Indefinite	12 hours
25 °C	3 hours	12 hours	12 hours	Indefinite	6 hours
35 °C	2 hours	8 hours	8 hours	Indefinite	3 hours

Useful Information

THINNER	:	SOLVALUX 7-45 or 7-33 (Maximum 10% addition)
CLEANER	:	SOLVALUX 7-77
STORAGE	:	Store in a cool dry shaded area.
SHELF LIFE AT 25 °C	:	24 months when stored as prescribed in the MSDS.

**Surface
Preparation**

The service life span and the service performance of EPILUX 218 are directly related to the degree of surface preparation.

STEEL

- EPILUX 218 should be applied to a surface that has been blast cleaned and suitably primed (e.g. with EPILUX 610).
- Ensure that the surface to be over-coated is clean, dry, free from dust, grease, oil, or any other surface contaminants. Fresh water wash to remove all soluble salts.
- The underlying system should be intact, sound and undamaged. Damaged areas should be prepared to specified standard (e.g. SA 2½ or SSPC-SP6 abrasive blasting or SSPCSP- 11 power tool cleaning) and patch primed prior to the application of Epilux 218.
- Always ensure that the maximum over-coating time for the primer / build coat should not exceeded prior to application.

CONCRETE

- Ensure that the surface is sound. Remove laitence by thorough wire-brushing, acid etching or sweep blasting. Blowholes and other defects should be filled with Solventless Epoxy Filler. Thin the first coat of EPILUX 218 by 20% for direct application to concrete.

ALUMINIUM

- Abrade using wet-or-dry paper and degrease with SOLVALUX 7-45. Apply LUXAPRIME 1501. Apply EPILUX 218 immediately after the minimum over coating time of the primer to prevent recontamination.

To avoid condensation of moisture onto substrate prior to coating application, relative humidity should not exceed 85% and substrate temperature should be more than 3°C above Dew Point.

**Suitable
Primers**

Epilux 68, Epilux 610, Epilux 78, Epilux 171, Epilux 800, Zincanode 685, Zincanode 668, Zincanode 300, Zincanode 330, Epimastic 3000HS, Epimastic 3100, Epimastic 5100 Luxaprime 1501, Luxaprime 1801

**Suitable
Overcoats**

Luxol 5000, Epilux 218, Luxathane 5075, Luxathane 5150HS, Luxathane 5000 HB, Epilux 4

Notes

- The coating specifications given above are typical. For specific recommendations to suit individual applications please refer to your Berger Paints representative.
- Common to all epoxies this product will experience chalking on prolonged exposure to sunlight. However, this phenomenon is not detrimental to coating performance.
- Exposure to very low temperatures, high humidity or water ponding during and/or immediately after application may result in incomplete cure and/or discolouration that may compromise subsequent intercoat adhesion.

**Safety
Precaution**

- Avoid contact with eyes and skin. Wear suitable protective clothing such as overalls, goggles, dust mask and gloves. Use barrier cream.
- Ensure that there is adequate ventilation in the area where the product is being applied.
- Do not breathe in vapour or spray mist.
- This product is flammable. Keep away from sources of ignition. Do not smoke.
- Take precautionary measures against static discharge.
- In case of fire, blanket flames with foam, carbon dioxide or dry chemicals.

First Aid

- Eyes** : In the event of accidental splashes, flush eyes with warm water immediately and seek medical advice.
- Skin** : Wash skin thoroughly with soap and water or approved industrial cleaner. Do Not Use solvents or thinners.
- Inhalation** : Remove to fresh air, loosen collar and keep patient rested.
- Ingestion** : In case of accidental ingestion, DO NOT INDUCE VOMITING. Obtain immediate medical attention.

For further safety information, please refer to our **Material Safety Data Sheet (MSDS)**

The information provided on this data sheet is not intended to be complete and is provided as general advice only. It is the responsibility of the user to ensure that the product is suitable for the purpose for which he wishes to use it. As we have no control over the treatment of the product, the standard of surface preparation of the substrate, or other factors affecting the use of this product, we are not responsible for its performance nor would we accept any liability whatsoever or howsoever arising from the use of this product unless specifically agreed to in writing by us. The information contained in this data sheet may be modified by us from time to time, and without notice, in the light of our experience and continuous product development.

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