



# Protective & Marine Coatings

# MACROPOXY® 646 FAST CURE EPOXY

PART A  
PART B

B58-600  
B58V600

SERIES  
HARDENER

Revised: October 19, 2016

## PRODUCT INFORMATION

4.53

### PRODUCT DESCRIPTION

**MACROPOXY 646 FAST CURE EPOXY** is a high solids, high build, fast drying, polyamide epoxy designed to protect steel and concrete in industrial exposures. Ideal for maintenance painting and fabrication shop applications. The high solids content ensures adequate protection of sharp edges, corners, and welds. This product can be applied directly to marginally prepared steel surfaces.

- Low VOC
- Low odor
- Outstanding application properties
- Meets Class A requirements for Slip Coefficient, 0.36 @ 6 mils / 150 microns dft (Mill White only)
- Chemical resistant
- Abrasion resistant

### PRODUCT CHARACTERISTICS

|                                      |  |
|--------------------------------------|--|
| <b>Finish:</b>                       | Semi-Gloss   |
| <b>Color:</b>                        | Mill White, Black and a wide range of colors available through tinting |
| <b>Volume Solids:</b>                | 72% ± 2%, mixed, Mill White  |
| <b>Weight Solids:</b>                | 85% ± 2%, mixed, Mill White  |
| <b>VOC (EPA Method 24):</b><br>mixed | Unreduced: <250 g/L; 2.08 lb/gal<br>Reduced 10%: <300 g/L; 2.50 lb/gal |
| <b>Mix Ratio:</b>                    | 1:1 by volume  |

### Recommended Spreading Rate per coat:

|  | Minimum            | Maximum            |
|--|--------------------|--------------------|
| <b>Wet mils (microns)</b>  | <b>7.0</b> (175)   | <b>13.5</b> (338)  |
| <b>Dry mils (microns)</b>  | <b>5.0*</b> (125)  | <b>10.0*</b> (250) |
| <b>~Coverage sq ft/gal (m<sup>2</sup>/L)</b>                                     | <b>116</b> (2.8)   | <b>232</b> (5.7)   |
| <b>Theoretical coverage sq ft/gal (m<sup>2</sup>/L) @ 1 mil / 25 microns dft</b> | <b>1152</b> (28.2) |                    |

\*May be applied at 3.0-10.0 mils (75-250 microns) dft in a multi-coat system. Refer to Recommended Systems and Performance Tips Sections.

*NOTE: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.*

### Drying Schedule @ 7.0 mils wet (175 microns):

|                   | @ 35°F/1.7°C | @ 77°F/25°C<br>50% RH | @ 100°F/38°C |
|-------------------|--------------|-----------------------|--------------|
| <b>To touch:</b>  | 4-5 hours    | 2 hours               | 1.5 hours    |
| <b>To handle:</b> | 48 hours     | 8 hours               | 4.5 hours    |
| <b>To recoat:</b> |              |                       |              |
| <b>minimum:</b>   | 48 hours     | 8 hours               | 4.5 hours    |
| <b>maximum:</b>   | 1 year       | 1 year                | 1 year       |
| <b>To cure:</b>   |              |                       |              |
| <b>Service:</b>   | 10 days      | 7 days                | 4 days       |
| <b>Immersion:</b> | 14 days      | 7 days                | 4 days       |

*If maximum recoat time is exceeded, abrade surface before recoating. Drying time is temperature, humidity, and film thickness dependent. Paint temperature must be at least 40°F (4.5°C) minimum.*

|                       |            |            |            |
|-----------------------|------------|------------|------------|
| <b>Pot Life:</b>      | 10 hours   | 4 hours    | 2 hours    |
| <b>Sweat-in-time:</b> | 30 minutes | 30 minutes | 15 minutes |

### When used as an intermediate coat as part of a multi-coat system:

#### Drying Schedule @ 5.0 mils wet (125 microns):

|                   | @ 35°F/1.7°C | @ 77°F/25°C<br>50% RH | @ 100°F/38°C |
|-------------------|--------------|-----------------------|--------------|
| <b>To touch:</b>  | 3 hours      | 1 hour                | 1 hour       |
| <b>To handle:</b> | 48 hours     | 4 hours               | 2 hours      |
| <b>To recoat:</b> |              |                       |              |
| <b>minimum:</b>   | 16 hours     | 4 hours               | 2 hours      |
| <b>maximum:</b>   | 1 year       | 1 year                | 1 year       |

### PRODUCT CHARACTERISTICS (CONT'D)

|                          |   |
|--------------------------|---|
| <b>Shelf Life:</b>       | 36 months, unopened<br>Store indoors at 40°F (4.5°C) to 110°F (43°C). |
| <b>Flash Point:</b>      | 91°F (33°C), TCC, mixed   |
| <b>Reducer/Clean Up:</b> | Reducer, R7K15  |
| <b>In California:</b>    | Reducer R7K111 or Oxsol 100   |

### PERFORMANCE CHARACTERISTICS

**Substrate\*:** Steel

**Surface Preparation\*:** SSPC-SP10/NACE 2

**System Tested\*:**

1 ct. Macropoxy 646 Fast Cure @ 6.0 mils (150 microns) dft  
\*unless otherwise noted below

| Test Name                                     | Test Method   | Results   |
|---|---|---|
| <b>Abrasion Resistance</b>                    | ASTM D4060, CS17 wheel, 1000 cycles, 1 kg load                              | 84 mg loss  |
| <b>Accelerated Weathering-QUV<sup>1</sup></b> | ASTM D4587, QUV-A, 12,000 hours   | Passes  |
| <b>Adhesion</b>                               | ASTM D4541  | 1,037 psi   |
| <b>Corrosion Weathering<sup>1</sup></b>       | ASTM D5894, 36 cycles, 12,000 hours   | Rating 10 per ASTM D714 for blistering; Rating 9 per ASTM D610 per rusting    |
| <b>Nuclear Decontamination</b>                | ASTM D4256/ANSI N 5.12  | 99% Water Wash; 95% Overall   |
| <b>Direct Impact Resistance<sup>2</sup></b>   | ASTM D2794 Modified   | **120 in. lb.   |
| <b>Dry Heat Resistance</b>                    | ASTM D2485  | 250°F (121°C)   |
| <b>Exterior Durability</b>                    | 1 year at 45° South   | Excellent, chalks   |
| <b>Flexibility</b>                            | ASTM D522, 180° bend, 3/4" mandrel  | Passes  |
| <b>Fuel Contribution</b>                      | NFPA 259  | 5764 btu/lb   |
| <b>Humidity Resistance</b>                    | ASTM D4585, 6000 hours  | No blistering, cracking, or rusting   |
| <b>Immersion</b>                              | 1 year fresh and salt water   | Passes, no rusting, blistering, or loss of adhesion                           |
| <b>Radiation Tolerance</b>                    | ASTM D4082 / ANSI 5.12  | Pass at 21 mils (525 microns)   |
| <b>Pencil Hardness</b>                        | ASTM D3363  | 3H  |
| <b>Salt Fog Resistance<sup>1</sup></b>        | ASTM B117, 6,500 hours  | Rating 10 per ASTM D610 for rusting; Rating 9 per ASTM D1654 for corrosion    |
| <b>Slip Coefficient, Mill White*</b>          | AISC Specification for Structural Joints Using ASTM A325 or ASTM A490 Bolts | Class A, 0.36   |
| <b>Surface Burning</b>                        | ASTM E84/NFPA 255   | Flame Spread Index 20; Smoke Development Index 35 (at 18 mils or 450 microns) |
| <b>Water Vapor Permeance</b>                  | ASTM D1653, Method B  | 1.16 US perms   |

Epoxy coatings may darken or discolor following application and curing.

\*Refer to Slip Certification document

\*\* Performed on 1/16 inch blasted steel

**Footnotes:**

<sup>1</sup> Zinc Clad II Plus Primer

<sup>2</sup> Two coats of Macropoxy 646 Fast Cure Epoxy

### DISCLAIMER

The information and recommendations set forth in this Product Data Sheet are based upon tests conducted by or on behalf of The Sherwin-Williams Company. Such information and recommendations set forth herein are subject to change and pertain to the product offered at the time of publication. Consult your Sherwin-Williams representative to obtain the most recent Product Data Information and Application Bulletin.



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## PRODUCT INFORMATION

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### RECOMMENDED USES

- Marine applications
- Fabrication shops
- Pulp and paper mills
- Power plants
- Offshore platforms
- Nuclear Power Plants
- Nuclear fabrication shops
- Mill White and Black are acceptable for immersion use for salt water and fresh water, not acceptable for potable water
- Suitable for use in USDA inspected facilities
- Acceptable for use in Canadian Food Processing facilities, categories: D1, D2, D3 (Confirm acceptance of specific part numbers/rexes with your SW Sales Representative)
- Conforms to AWWA D102 OCS #5
- Conforms to MPI # 108
- This product meets specific design requirements for non-safety related nuclear plant applications in Level II, III and Balance of Plant, and DOE nuclear facilities\*.
- \* Nuclear qualifications are NRC license specific to the facility.
- Suitable for use in the Mining & Minerals Industry
- Acceptable for use over and/or under Loxon S1 and Loxon H1 Caulking

### RECOMMENDED SYSTEMS

|  |                                      | Dry Film Thickness / ct. |           |
|--|--------------------------------------|--------------------------|-----------|
|  |                                      | Mils                     | (Microns) |
| <b>Immersion and atmospheric:</b>  |                                      |                          |           |
| <b>Steel:</b>  |                                      |                          |           |
| 2 cts.   | Macropoxy 646 Fast Cure Epoxy        | 5.0-10.0                 | (125-250) |
| <b>Concrete/Masonry, smooth:</b>   |                                      |                          |           |
| 2 cts.   | Macropoxy 646 Fast Cure Epoxy        | 5.0-10.0                 | (125-250) |
| <b>Concrete Block:</b>   |                                      |                          |           |
| 1 ct.  | Kem Cati-Coat HS Epoxy Filler/Sealer | 10.0-20.0                | (250-500) |
| <i>as needed to fill voids and provide a continuous substrate.</i>   |                                      |                          |           |
| 2 cts.   | Macropoxy 646 Fast Cure Epoxy        | 5.0-10.0                 | (125-250) |
| <b>Atmospheric:</b>  |                                      |                          |           |
| <b>Steel:</b>  |                                      |                          |           |
| (Shop applied system, new construction, AWWA D102, can also be used at 3 mils / 75 microns minimum dft when used as an intermediate coat as part of a multi-coat system) |                                      |                          |           |
| 1 ct.  | Macropoxy 646 Fast Cure Epoxy        | 3.0-6.0                  | (75-150)  |
| 1-2 cts.   | of recommended topcoat               |                          |           |
| <b>Steel:</b>  |                                      |                          |           |
| 1 ct.  | Recoatable Epoxy Primer              | 4.0-6.0                  | (100-150) |
| 2 cts.   | Macropoxy 646 Fast Cure Epoxy        | 5.0-10.0                 | (125-250) |
| <b>Steel:</b>  |                                      |                          |           |
| 1 ct.  | Macropoxy 646 Fast Cure Epoxy        | 5.0-10.0                 | (125-250) |
| 1-2 cts.   | Acrolon 218 Polyurethane             | 3.0-6.0                  | (75-150)  |
|  | or Hi-Solids Polyurethane            | 3.0-5.0                  | (75-125)  |
|  | or SherThane 2K Urethane             | 2.0-4.0                  | (50-100)  |
|  | or Hydrogloss                        | 2.0-4.0                  | (50-100)  |
| <b>Steel:</b>  |                                      |                          |           |
| 2 cts.   | Macropoxy 646 Fast Cure Epoxy        | 5.0-10.0                 | (125-250) |
| 1-2 cts.   | Tile-Clad HS Epoxy                   | 2.5-4.0                  | (63-100)  |
| <b>Steel:</b>  |                                      |                          |           |
| 1 ct.  | Zinc Clad II Plus                    | 2.0-4.0                  | (50-100)  |
| 1 ct.  | Macropoxy 646 Fast Cure Epoxy        | 3.0-10.0                 | (75-250)  |
| 1-2 cts.   | Acrolon 218 Polyurethane             | 3.0-6.0                  | (75-150)  |
| <b>Steel:</b>  |                                      |                          |           |
| 1 ct.  | Zinc Clad III HS                     | 3.0-5.0                  | (75-125)  |
|  | or Zinc Clad IV                      | 3.0-5.0                  | (75-125)  |
| 1 ct.  | Macropoxy 646 Fast Cure Epoxy        | 3.0-10.0                 | (75-250)  |
| 1-2 cts.   | Acrolon 218 Polyurethane             | 3.0-6.0                  | (75-150)  |
| <b>Aluminum:</b>   |                                      |                          |           |
| 2 cts.   | Macropoxy 646 Fast Cure Epoxy        | 2.0-4.0                  | (50-100)  |
| <b>Galvanizing:</b>  |                                      |                          |           |
| 2 cts.   | Macropoxy 646 Fast Cure Epoxy        | 2.0-4.0                  | (50-100)  |
| <b>FIRETEX M89/02, M90, M90/02, and M93/02:</b>  |                                      |                          |           |
| <b>Steel &amp; Galvanized Substrates being primed for FIRETEX only:</b>  |                                      |                          |           |
| 1 ct.  | Macropoxy 646 Fast Cure Epoxy        | 2.0-5.0                  | (50-125)  |

The systems listed above are representative of the product's use, other systems may be appropriate.

### SURFACE PREPARATION

Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.

Refer to product Application Bulletin for detailed surface preparation information.

Minimum recommended surface preparation:

Iron & Steel

Atmospheric: SSPC-SP2/3 or SSPC-SP WJ-2/NACE WJ-2L  
Immersion: SSPC-SP10/NACE 2, 2-3 mil (50-75 micron) profile or SSPC-SP WJ-3/NACE WJ-3L

Aluminum:

SSPC-SP1

Galvanizing: SSPC-SP1; See Surface Preparations section on page 3 for application of FIRETEX intumescent coating systems

Concrete & Masonry

Atmospheric: SSPC-SP13/NACE 6, or ICRI No. 310.2R, CSP 1-3

Immersion: SSPC-SP13/NACE 6-4.3.1 or 4.3.2, or

ICRI No. 310.2R, CSP 2-4

#### Surface Preparation Standards

| Condition of Surface | ISO 8501-1<br>BS7079:A1 | SSPC   | NACE |
|----------------------|-------------------------|--------|------|
| White Metal          | Sa 3                    | SP 5   | 1    |
| Near White Metal     | Sa 2.5                  | SP 10  | 2    |
| Commercial Blast     | Sa 2                    | SP 6   | 3    |
| Brush-Off Blast      | Sa 1                    | SP 7   | 4    |
| Hand Tool Cleaning   | C St 2                  | SP 2   | -    |
| Pitted & Rusted      | D St 2                  | SP 2   | -    |
| Rusted               | C St 3                  | SP 3   | -    |
| Power Tool Cleaning  | Pitted & Rusted         | D St 3 | SP 3 |

### TINTING

Tint Part A with Maxitones at 150% strength. Five minutes minimum mixing on a mechanical shaker is required for complete mixing of color.

Tinting is not recommended for immersion service.

### APPLICATION CONDITIONS

Temperature: 35°F (1.7°C) minimum, 120°F (49°C) maximum (air and surface)  
40°F (4.5°C) minimum, 120°F (49°C) maximum (material)  
At least 5°F (2.8°C) above dew point

Relative humidity: 85% maximum

Refer to product Application Bulletin for detailed application information.

### ORDERING INFORMATION

Packaging:  
Part A: 1 gallon (3.78L) and 5 gallon (18.9L) containers  
Part B: 1 gallon (3.78L) and 5 gallon (18.9L) containers

Weight: 12.9 ± 0.2 lb/gal ; 1.55 Kg/L  
mixed, may vary by color

### SAFETY PRECAUTIONS

Refer to the MSDS sheet before use.

Published technical data and instructions are subject to change without notice. Contact your Sherwin-Williams representative for additional technical data and instructions.

### WARRANTY

The Sherwin-Williams Company warrants our products to be free of manufacturing defects in accord with applicable Sherwin-Williams quality control procedures. Liability for products proven defective, if any, is limited to replacement of the defective product or the refund of the purchase price paid for the defective product as determined by Sherwin-Williams. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY SHERWIN-WILLIAMS, EXPRESSED OR IMPLIED, STATUTORY, BY OPERATION OF LAW OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.



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## APPLICATION BULLETIN

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### SURFACE PREPARATIONS

Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.

#### Iron & Steel, Atmospheric Service:

Minimum surface preparation is Hand Tool Clean per SSPC-SP2. Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1. For better performance, use Commercial Blast Cleaning per SSPC-SP6/NACE 3, blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (2 mils / 50 microns). Prime any bare steel within 8 hours or before flash rusting occurs.

#### Iron & Steel, Immersion Service:

Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1. Minimum surface preparation is Near White Metal Blast Cleaning per SSPC-SP10/NACE 2. Blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (2-3 mils / 50-75 microns). Remove all weld spatter and round all sharp edges by grinding. Prime any bare steel the same day as it is cleaned.

#### Aluminum

Remove all oil, grease, dirt, oxide and other foreign material by Solvent Cleaning per SSPC-SP1.

#### Galvanized Steel

Allow to weather a minimum of six months prior to coating. Solvent Clean per SSPC-SP1 (recommended solvent is VM&P Naphtha). When weathering is not possible, or the surface has been treated with chromates or silicates, first Solvent Clean per SSPC-SP1 and apply a test patch. Allow paint to dry at least one week before testing adhesion. If adhesion is poor, brush blasting per SSPC-SP7 is necessary to remove these treatments. Rusty galvanizing requires a minimum of Hand Tool Cleaning per SSPC-SP2, prime the area the same day as cleaned. In preparing galvanized steel substrates for the application of FIRE-TEX intumescent coating systems, Surface Preparation Specification SSPC-SP 16 must be followed obtaining a surface profile of minimum 1.5 mils (38 microns). Optimum surface profile will not exceed 2.0 mils (50 microns).

#### Concrete and Masonry

For surface preparation, refer to SSPC-SP13/NACE 6, or ICRI No. 310.2R, CSP 1-3. Surfaces should be thoroughly clean and dry. Concrete and mortar must be cured at least 28 days @ 75°F (24°C). Remove all loose mortar and foreign material. Surface must be free of laitance, concrete dust, dirt, form release agents, moisture curing membranes, loose cement and hardeners. Fill bug holes, air pockets and other voids with Steel-Seam FT910.

#### Concrete, Immersion Service:

For surface preparation, refer to SSPC-SP13/NACE 6, Section 4.3.1 or 1.3.2 or ICRI No. 310.2R, CSP 2-4.

#### Follow the standard methods listed below when applicable:

ASTM D4258 Standard Practice for Cleaning Concrete.  
ASTM D4259 Standard Practice for Abrading Concrete.  
ASTM D4260 Standard Practice for Etching Concrete.  
ASTM F1869 Standard Test Method for Measuring Moisture Vapor Emission Rate of Concrete.  
SSPC-SP 13/Nace 6 Surface Preparation of Concrete.  
ICRI No. 310.2R Concrete Surface Preparation.

#### Previously Painted Surfaces

If in sound condition, clean the surface of all foreign material. Smooth, hard or glossy coatings and surfaces should be dulled by abrading the surface. Apply a test area, allowing paint to dry one week before testing adhesion. If adhesion is poor, or if this product attacks the previous finish, removal of the previous coating may be necessary. If paint is peeling or badly weathered, clean surface to sound substrate and treat as a new surface as above.

#### Surface Preparation Standards

| Condition of Surface | ISO 8501-1<br>BS7079:A1 | SSPC   | NACE |
|----------------------|-------------------------|--------|------|
| White Metal          | Sa 3                    | SP 5   | 1    |
| Near White Metal     | Sa 2.5                  | SP 10  | 2    |
| Commercial Blast     | Sa 2                    | SP 6   | 3    |
| Brush-Off Blast      | Sa 1                    | SP 7   | 4    |
| Hand Tool Cleaning   | Rusted                  | C St 2 | SP 2 |
|                      | Pitted & Rusted         | D St 2 | SP 2 |
| Power Tool Cleaning  | Rusted                  | C St 3 | SP 3 |
|                      | Pitted & Rusted         | D St 3 | SP 3 |

### APPLICATION CONDITIONS

|                    |   |
|--------------------|---|
| Temperature:       | 35°F (1.7°C) minimum, 120°F (49°C) maximum (air and surface)<br>40°F (4.5°C) minimum, 120°F (49°C) maximum (material)<br>At least 5°F (2.8°C) above dew point |
| Relative humidity: | 85% maximum   |

### APPLICATION EQUIPMENT

The following is a guide. Changes in pressures and tip sizes may be needed for proper spray characteristics. Always purge spray equipment before use with listed reducer. Any reduction must be compliant with existing VOC regulations and compatible with the existing environmental and application conditions.

Reducer/Clean Up ..... Reducer R7K15  
In California..... Reducer R7K111

#### Airless Spray

|                |                               |
|----------------|-------------------------------|
| Pump.....      | 30:1                          |
| Pressure.....  | 2800 - 3000 psi               |
| Hose.....      | 1/4" ID                       |
| Tip .....      | .017" - .023"                 |
| Filter.....    | 60 mesh                       |
| Reduction..... | As needed up to 10% by volume |

#### Conventional Spray

|                                      |                               |
|--------------------------------------|-------------------------------|
| Gun .....                            | DeVilbiss MBC-510             |
| Fluid Tip .....                      | E                             |
| Air Nozzle.....                      | 704                           |
| Atomization Pressure.....            | 60-65 psi                     |
| Fluid Pressure.....                  | 10-20 psi                     |
| Reduction.....                       | As needed up to 10% by volume |
| Requires oil and moisture separators |                               |

#### Brush

|                |                                    |
|----------------|------------------------------------|
| Brush.....     | Nylon/Polyester or Natural Bristle |
| Reduction..... | As needed up to 10% by volume      |

#### Roller

|                |  |
|----------------|--|
| Cover .....    | 3/8" woven with solvent resistant core |
| Reduction..... | As needed up to 10% by volume          |

#### Plural Component Spray ... Acceptable

Refer to April 2010 Technical Bulletin - "Application Guidelines for Macroxy 646 Fast Cure Epoxy & Recoatable Epoxy Primer Utilizing Plural Component Equipment"  
If specific application equipment is not listed above, equivalent equipment may be substituted.





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### APPLICATION PROCEDURES

Surface preparation must be completed as indicated.

Mix contents of each component thoroughly with low speed power agitation. Make certain no pigment remains on the bottom of the can. Then combine one part by volume of Part A with one part by volume of Part B. Thoroughly agitate the mixture with power agitation. Allow the material to sweat-in as indicated prior to application. Re-stir before using.

If reducer solvent is used, add only after both components have been thoroughly mixed, after sweat-in.

Apply paint at the recommended film thickness and spreading rate as indicated below:

#### Recommended Spreading Rate per coat:

|   | Minimum     | Maximum     |
|---|-------------|-------------|
| Wet mils (microns)  | 7.0 (175)   | 13.5 (338)  |
| Dry mils (microns)  | 5.0* (125)  | 10.0* (250) |
| ~Coverage sq ft/gal (m <sup>2</sup> /L)                                     | 116 (2.8)   | 232 (5.7)   |
| Theoretical coverage sq ft/gal (m <sup>2</sup> /L) @ 1 mil / 25 microns dft | 1152 (28.2) |             |

\*May be applied at 3.0-10.0 mils (75-250 microns) dft in a multi-coat system. Refer to Recommended Systems and Performance Tips Sections.

NOTE: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.

#### Drying Schedule @ 7.0 mils wet (175 microns):

|            | @ 35°F/1.7°C | @ 77°F/25°C<br>50% RH | @ 100°F/38°C |
|------------|--------------|-----------------------|--------------|
| To touch:  | 4-5 hours    | 2 hours               | 1.5 hours    |
| To handle: | 48 hours     | 8 hours               | 4.5 hours    |
| To recoat: |              |                       |              |
| minimum:   | 48 hours     | 8 hours               | 4.5 hours    |
| maximum:   | 1 year       | 1 year                | 1 year       |
| To cure:   |              |                       |              |
| Service:   | 10 days      | 7 days                | 4 days       |
| Immersion: | 14 days      | 7 days                | 4 days       |

If maximum recoat time is exceeded, abrade surface before recoating.

Drying time is temperature, humidity, and film thickness dependent.

Paint temperature must be at least 40°F (4.5°C) minimum.

|                |            |            |            |
|----------------|------------|------------|------------|
| Pot Life:      | 10 hours   | 4 hours    | 2 hours    |
| Sweat-in-time: | 30 minutes | 30 minutes | 15 minutes |

#### When used as an intermediate coat as part of a multi-coat system:

##### Drying Schedule @ 5.0 mils wet (125 microns):

|            | @ 35°F/1.7°C | @ 77°F/25°C<br>50% RH | @ 100°F/38°C |
|------------|--------------|-----------------------|--------------|
| To touch:  | 3 hours      | 1 hour                | 1 hour       |
| To handle: | 48 hours     | 4 hours               | 2 hours      |
| To recoat: |              |                       |              |
| minimum:   | 16 hours     | 4 hours               | 2 hours      |
| maximum:   | 1 year       | 1 year                | 1 year       |

Application of coating above maximum or below minimum recommended spreading rate may adversely affect coating performance.

### CLEAN UP INSTRUCTIONS

Clean spills and spatters immediately with Reducer R7K15. Clean tools immediately after use with Reducer R7K15. In California use Reducer R7K111. Follow manufacturer's safety recommendations when using any solvent.

### PERFORMANCE TIPS

Stripe coat all crevices, welds, and sharp angles to prevent early failure in these areas.

When using spray application, use a 50% overlap with each pass of the gun to avoid holidays, bare areas, and pinholes. If necessary, cross spray at a right angle.

Spreading rates are calculated on volume solids and do not include an application loss factor due to surface profile, roughness or porosity of the surface, skill and technique of the applicator, method of application, various surface irregularities, material lost during mixing, spillage, overthinning, climatic conditions, and excessive film build.

Excessive reduction of material can affect film build, appearance, and adhesion.

Do not mix previously catalyzed material with new.

Do not apply the material beyond recommended pot life.

In order to avoid blockage of spray equipment, clean equipment before use or before periods of extended downtime with Reducer R7K15. In California use Reducer R7K111.

Tinting is not recommended for immersion service.

Use only Mill White and Black for immersion service.

Insufficient ventilation, incomplete mixing, miscatalyzation, and external heaters may cause premature yellowing.

Excessive film build, poor ventilation, and cool temperatures may cause solvent entrapment and premature coating failure.

Quik-Kick Epoxy Accelerator is acceptable for use. See data page 4.99 for details.

When coating over aluminum and galvanizing, recommended dft is 2-4 mils (50-100 microns).

Acceptable for Concrete Floors.

Can be used as a metalizing sealer. Consult Technical Bulletin - Sealers for Thermal Spray Metalizing, or your local Sherwin-Williams representative.

Refer to Product Information sheet for additional performance characteristics and properties.

### SAFETY PRECAUTIONS

Refer to the MSDS sheet before use.

Published technical data and instructions are subject to change without notice. Contact your Sherwin-Williams representative for additional technical data and instructions.

### DISCLAIMER

The information and recommendations set forth in this Product Data Sheet are based upon tests conducted by or on behalf of The Sherwin-Williams Company. Such information and recommendations set forth herein are subject to change and pertain to the product offered at the time of publication. Consult your Sherwin-Williams representative to obtain the most recent Product Data Information and Application Bulletin.

### WARRANTY

The Sherwin-Williams Company warrants our products to be free of manufacturing defects in accord with applicable Sherwin-Williams quality control procedures. Liability for products proven defective, if any, is limited to replacement of the defective product or the refund of the purchase price paid for the defective product as determined by Sherwin-Williams. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY SHERWIN-WILLIAMS, EXPRESSED OR IMPLIED, STATUTORY, BY OPERATION OF LAW OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.