



Protective & Marine Coatings

MACROPOXY 860 EPOXY POLYAMINE

PART A **B58-C1SERIES**
PART B **B58VC0001**
PART B **B58VC0002**

Revised 08/12

PRODUCT DESCRIPTION

MACROPOXY 860, is a high build, two component epoxy polyamine product. It has excellent physical properties such as adhesion, toughness, abrasion resistance, etc. As well as chemical resistance to salt water, fresh water, oils, etc.

It's suitable for most area of industrial field and provides:

- Good application properties
- Chemical resistant
- Low odor
- Universal adhesion and protection

PRODUCT CHARACTERISTICS

Gloss: Semi-gloss
Colors: Red Oxide, light grey, silver grey, mill white
Volume solids: 82%±2%
Mixing ratio: Part A:Part B = 6:1 (by Volume)
 Part A:Part B = 3:1 (by Volume, winter type)
VOC: 196 g/L

Recommended Spreading Rate per coat:

	Minimum	Maximum
Wet mils microns	91	366
Dry mils microns	75	300
Theoretical Coverage	16.4m ² /L@50 microns dft.	

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

Drying Schedule @ 150 microns wet

	15°C	25°C 50% RH	35°C
To touch:	5 hours	3.5 hours	2.5 hours
To handle:	16 hours	10 hours	8 hours
To cure:	10 days	7 days	5 days
To recoat :			
minimum:	16 hours	10 hours	8 hours
maximum:	30 days	30 days	30 days

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

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

Pot Life: 7.5 hours 3.5 hours 2 hours
Sweat-In-Time: 30 minutes 20 minutes 15 minutes

Drying Schedule @ 150 microns wet (winter type)

	-5°C	0°C 50%RH	5°C	15°C
To touch:	24 hours	16 hours	12 hours	5 hours
To handle:	48 hours	24 hours	16 hours	10 hours
To cure:	14 days	10 days	7 days	5 days
To recoat :				
minimum:	48 hours	24 hours	16 hours	10 hours
maximum:	30 days	30 days	30 days	30 days
Pot Life:	1.5 hours	1.5 hours	1.0 hour	1.0 hour
Sweat-In-Time:	10 minutes	10 minutes	5 minutes	5 minutes

Note: if the temperature is below 10°C, please use MACROPOXY 860 winter type.

Shelf Life: 36 months, unopened, containers at 25°C
Flash Point: 33°C, Closed Cup, mixed
Reducer/Clean Up: R7K15, R8KE1

RECOMMENDED USES

MACROPOXY 860 is suitable for use in both new construction and industrial maintenance situations.

- Fabrication shops
- Refineries
- Marine applications
- Offshore platforms
- Water treatment plants
- Chemical plants
- Power plants
- Pulp and paper mills

APPLICATION CONDITIONS

Temperature: -5°C minimum, 43°C maximum
(air, surface and material)

Relative humidity: 100% maximum

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.

Minimum recommended surface preparation:

- * Iron and Steel
 Atmospheric: SSPC-SP2/3 /St 2/3 (ISO8501- 1:2007)
 Immersion: SSPC-SP10/NACE 2 Sa2 ½ (ISO8501- 1:2007) ,
 50-75 microns profile

- * Concrete/Masonry, cured, clean, dry and sound.
 Atmospheric: SSPC-SP13/NACE 6
 Immersion: SSPC-SP13/NACE 6-4.3.1 or 4.3.2

- * Aluminum: SSPC-SP1
- * Galvanizing: SSPC-SP1

Macropoxy 860 is tolerant to hydroblasted.
 Hydroblasting: WJ-2M (SSPC SP12 – VIS4(I) / NACE N°5 - N°7)

Surface Preparation Standards

Condition of Surface	ISO 8501-1 BS7079:A1	Swedish Std. SIS055900	SSPC	NACE
White Metal	Sa 3	Sa 3	SP 5	1
Near White Metal	Sa 2.5	Sa 2.5	SP 10	2
Commercial Blast	Sa 2	Sa 2	SP 6	3
Brush-Off Blast	Sa 1	Sa 1	SP 7	4
Hand Tool	Rusted	C St 2	SP 2	-
Cleaning	Pitted & Rusted	D St 2	SP 2	-
Power Tool	Rusted	C St 3	SP 3	-
Cleaning	Pitted & Rusted	D St 3	SP 3	-



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PRODUCT INFORMATION

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 R7KS10, R7K15, R7KW15
More option of reducer, please contact Sherwin-Williams local representative for details.

Airless Spray

Pump..... 45:1 minimum
Pressure 15 Mpa minimum
Hose 9.5mm ID
Tip 0.027" - 0.035"(0.68-0.89mm)
Filter none
Reduction as needed up to 10% by volume

Conventional Spray

Gun Binks 95
Fluid Nozzle 66
Air Nozzle 68 PB
Atomization Pressure 0.5 MPA
Fluid Pressure 0.2 MPA
Reduction as needed up to 10% by volume

Keep pressure pot at level of applicator to avoid blocking of fluid line due to weight of material. Blow back coating in fluid line at intermittent shutdowns, but continue agitation at pressure pot.

Brush

Brush Nylon/Polyester Natural Bristle
Reduction not recommended

Roller

Brush 3/8"-1/2" woven with phenolic core
Reduction not recommended

If specific application equipment is not listed above, equivalent equipment may be substituted.

ORDERING INFORMATION

Package:
Part A : 17.1 Litres in 20L pail
Part B : 2.9 Litres in 4L pail
Package(winter type):
Part A : 15 Litres in 20L pail
Part B : 5 Litres in 5L pail

For more package detail, please contact local Sherwin-Williams Customer Service Center.

TINTING

Tint Part A with colorants to achieve wide range of colors.

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.

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