



# Protective & Marine Coatings

# MACROPOXY™ M182 EPOXY PRIMER

FORMERLY KNOWN AS RESISTEX M182

Revised 03/2016 Issue 7

## PRODUCT INFORMATION

### PRODUCT DESCRIPTION

A single pack epoxy anti-corrosive primer

### RECOMMENDED USE

An oil resisting primer for application onto ferrous substrates

### RECOMMENDED APPLICATION METHODS

Airless Spray  
Conventional Spray  
Brush  
Dip/Flow

Recommended Cleanser Thinner: No 5

### PRODUCT CHARACTERISTICS

Flash Point: 32°C

% Solids by Volume: 28 ± 1% (ASTM-D2697-91)

Colour Availability: Grey

#### VOC

676 gms/litre determined practically in accordance with UK Regulations PG6/23

729 gms/litre calculated from formulation to satisfy EC Solvent Emissions Directive

603 gms/kilo content by weight from formulation, to satisfy EC Solvent Emissions Directive

### RECOMMENDED THICKNESS

Dry film thickness	Wet film thickness	Theoretical coverage
25 microns	90 microns	11.1 m <sup>2</sup> /ltr*

\* This figure makes no allowance for surface profile, uneven application, overspray or losses in containers and equipment. Film thickness will vary depending on actual use and specification.

### PRACTICAL APPLICATION RATES - MICRONS PER COAT

	Airless Spray	Conventional Spray	Brush	Dip/Flow
Dry	25*	25	15	See note overleaf
Wet	90	90	54	

\* Maximum sag tolerance typically 125 µm wet (35µm dry) by airless spray.

### AVERAGE DRYING TIMES

	@ 15°C	@ 23°C
To touch:	2 hours	1 hour
To recoat:	18 hours	12 hours
To handle:	18 hours	12 hours

*These figures are given as a guide only. Factors such as air movement and humidity must also be considered.*

### PACKAGE

Single component material

Pack Size: 5 litre units

Weight: 1.17 kg/litre

Shelf Life: 2 years from date of manufacture or 'Use By' date where specified.



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#### ***SURFACE PREPARATION***

Blast clean to Sa2½ BS EN ISO 8501-1:2007. Average surface profile in the range 30-50 microns.

Ensure surfaces to be coated are clean, dry and free from all surface contamination.

#### ***APPLICATION EQUIPMENT***

##### **Airless Spray**

Nozzle Size	:	0.38mm (15 thou)
Fan Angle	:	80°
Operating Pressure	:	140kg/cm² (2000 psi)

The airless spray details given above are intended as a guide only. Details such as fluid hose length and diameter, paint temperature and job shape and size all have an effect on the spray tip and operating pressure chosen. However, the operating pressure should be the lowest possible consistent with satisfactory atomisation. As conditions will vary from job to job, it is the applicators' responsibility to ensure that the equipment in use has been set up to give the best results. If in doubt Sherwin-Williams should be consulted.

##### **Conventional Spray**

Nozzle Size	:	1.27mm (50 thou)
Atomising Pressure	:	3.5kg/cm² (50 psi)
Fluid Pressure	:	0.7kg/cm² (10 psi)

The details of atomising pressure, fluid pressure and nozzle size are given as a guide. It may be found that slight variations of pressure will provide optimum atomisation in some circumstances according to the set up in use. Atomising air pressure depends on the air cap in use and the fluid pressure depends on the length of line and direction of feed i.e. horizontal or vertical.

##### **Brush**

The material is suitable for brush application. Application of more than one coat may be necessary to give equivalent dry film thickness to a single spray applied coat.

##### **Dip/Flow**

This material may be applied using proprietary dip or flow coating equipment. Care must be taken to monitor the applied film thickness, as this can vary according to the position on the coated article with thicker film typically achieved lower down the piece as the paint drains down during the drying process. Application of multiple coats may be necessary to achieve the required film thickness.

#### ***APPLICATION CONDITIONS AND OVERCOATING***

In conditions of high relative humidity, i.e. 80-85% good ventilation conditions are essential. Substrate temperature shall be at least 3°C above the dew point and always above 0°C. Application at ambient air temperatures below 5°C is not recommended.

#### ***ADDITIONAL NOTES***

Drying times should be considered as a guide only. Numerical values quoted for physical data may vary slightly from batch to batch.

#### ***HEALTH AND SAFETY***

Consult Product Health and Safety Data Sheet for information on safe storage, handling and application of this product.

#### ***WARRANTY***

Any person or company using the product without first making further enquiries as to the suitability of the product for the intended purpose does so at their own risk, and Sherwin-Williams can accept no liability for the performance of the product, or for any loss or damage arising out of such use.

The information detailed in this Data Sheet is liable to modification from time to time in the light of experience and of normal product development, and before using, customers are advised to check with Sherwin-Williams, quoting the reference number, to ensure that they possess the latest issue.