MACROPOXY® 646
FAST CURE EPOXY

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.

INTENDED USES

• Recommended for marine applications, refineries, offshore platforms, fabrication shops, chemical plants, tank exteriors, power plants, water treatment plants, and mining and minerals industry
• Mill White and Black are acceptable for immersion use for salt water and fresh water, not acceptable for potable water

PRODUCT DATA

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:
Aluminum & Galvanizing: SSPC-SP1. If surface has not been weathered for more than 6 months, follow SSPC-SP1 then SSPC-SP16. For fire proofing projects, consult a Sherwin-Williams representative for surface preparation requirements.
Concrete & Masonry: Atmospheric: SSPC-SP13/NACE 6, or ICRI No. 310.2R CSP 1-3 Immersion: SSPC-SP13/NACE 6-4.3.1

Ref: 1101-1 www.sherwin-williams.com/protective
## APPLICATION

### Airless Spray*
- Pump: 30:1
- Pressure: 2800-3000 psi (193-206 bar)
- Hose: 1/4" ID (6.3 mm)
- Tip: 0.017"-0.023" (0.43-0.58 mm)
- 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 (4.1-4.5 bar)
- Fluid Pressure: 10-20 psi (0.7-1.4 bar)

### Brush*
- Brush: Nylon/Polyester or Natural Bristle

### Roller*
- Cover: 3/8" woven with solvent resistant core

### Plural Component Spray
- Acceptable
- *Reduction: As needed up to 10% by volume

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

## RECOMMENDED SYSTEMS

### Steel, Immersion & Atmospheric
- 2 Cts. Macropoxy 646
- Dry Film Thickness / ct. Mils (Microns)
- 5.0-10.0 (125-250)

### Steel, Organic Zinc Primer, Atmospheric
- 1 Ct. Zinc Clad IV (85)
- 3.0-5.0 (75-125)
- 1 Ct. Macropoxy 646
- 5.0-10.0 (125-250)

### Steel, Inorganic Zinc Primer, Atmospheric
- 1 Ct. Zinc Clad II (85)
- 2.0-4.0 (50-100)
- 1 Ct. Macropoxy 646
- 5.0-10.0 (125-250)

### Steel, Organic Zinc/Epoxy/Urethane Topcoat
- 1 Ct. Zinc Clad IV (85)
- 3.0-5.0 (75-125)
- 1 Ct. Macropoxy 646
- 3.0-10.0 (75-250)
- 1 Ct. Acrolon 7300
- 2.0-4.0 (50-100)

### Steel, Inorganic Zinc/Epoxy/Urethane Topcoat
- 1 Ct. Zinc Clad II (85)
- 2.0-4.0 (50-100)
- 1 Ct. Macropoxy 646
- 3.0-10.0 (75-250)
- 1 Ct. Acrolon 7300
- 2.0-4.0 (50-100)

### Steel, Organic Zinc/Epoxy/Polysiloxane Topcoat, Atmospheric
- 1 Ct. Zinc Clad IV (85)
- 3.0-5.0 (75-125)
- 1 Ct. Macropoxy 646
- 3.0-10.0 (75-250)
- 1-2 Cts. Sher-Loxane 800
- 2.0-4.0 (50-100)

### Concrete/Masonry, Smooth, Immersion & Atmospheric
- 2 Cts. Macropoxy 646
- 5.0-10.0 (125-250)

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

## 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.

## HEALTH AND SAFETY

Refer to the SDS sheet before use.

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

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