



# Protective & Marine Coatings

## MACROPOXY™ K267 EPOXY UNDERCOAT/MIO

FORMERLY KNOWN AS EPIGRIP K267 / TRANSGARD TG121

Revised 08/2017 Issue 30

### PRODUCT INFORMATION

#### PRODUCT DESCRIPTION

A 2-pack epoxy, pigmented with micaceous iron oxide.

#### RECOMMENDED USE

As an intermediate coat in conjunction with Macropoxy high performance primers.

Also recommended as primer for painting galvanised steel.

#### ENDORSEMENTS

BS476 Part 7 - Surface Spread of Flame - for details of substrates/scheme, consult Sherwin-Williams.  
Highways Agency Item No. 121  
Network Rail Item No. 7.2.2

#### RECOMMENDED APPLICATION METHODS

Airless Spray      Brush  
Conventional Spray      Roller

Recommended Cleanser/Thinner: No 5

#### PRODUCT CHARACTERISTICS

Flash Point: Base : 32°C    Additive : 35°C

% Solids by Volume: 66 ± 3% (ASTM-D2697-91)

Pot Life: 3 hrs @ 15°C, 2 hrs @ 23°C, 1 hrs @ 35°C

Colour Availability: Light Grey R8051, Dark Grey R8050

#### VOC

297 gms/litre determined practically in accordance with UK Regulations PG6/23  
330 gms/litre calculated from formulation to satisfy EC Solvent Emissions Directive  
178 gms/kilo content by weight from formulation, to satisfy EC Solvent Emissions Directive

#### RECOMMENDED THICKNESS

Dry film thickness	Wet film thickness	Theoretical coverage
100 microns	152 microns	6.6 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	Roller
Dry	100*	100	75	50
Wet	152	152	114	76

\* Maximum sag tolerance typically 304µm wet (200µm dry) by airless spray

#### AVERAGE DRYING TIMES

	@ 15°C	@ 23°C	@ 35°C
To touch:	3 hours	2 hours	1 hour
To recoat:	6 hours	4 hours	3 hours
To handle:	24 hours	16 hours	12 hours

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

#### RECOMMENDED PRIMERS / TOPCOATS

Compatible with a wide range of Macropoxy, Dura-plate, Zinc Clad Epoxy Primers and Buildcoats.

Indefinitely overcoatable with epoxy systems provided the surfaces to be coated have been suitably cleaned.

Where a high degree of gloss and colour retention is required overcoat with Acrolon C137V2, Acrolon C237, Acrolon 1850 or Acrolon 7300 finishes. In order for the dry film of Macropoxy K267 to be recoated with Acrolon C137V2, Acrolon 7300, Acrolon C237 or Acrolon 1850 after extended periods (without maximum stated limits) the following conditions shall be matched in the moment of the finish application:

1. The previous coating has been applied at the recommended dry film thickness and in accordance with good painting practices. Is free from any application defects and the dry film is tightly adherent.
2. The surface is free from all type of contaminants such as soluble salts, oily and greasy materials and any other visible contamination that can affect intercoat adhesion. Any detected contamination shall be cleaned by adequate methods prior to the finish application.
3. Surface does not present burn marks or any type of defect caused by mechanical, chemical or other type of damage. All such damaged areas shall be repaired with the original coating system before applying the finish coat.
4. If under direct sunlight exposure for long periods the surface shall be checked for degraded superficial layer that can affect intercoat adhesion. If such layer is observed it should be removed by means of water jetting, abrading, solvent cleaning or other method considered to be suitable.

If applying Acrolon C750V2 overcoat within 4 days.

These overcoating times refer to achievement of optimum adhesion at 23°C and will vary with temperature.

For overcoating with alkyd systems consult Sherwin-Williams for advice.

#### PACKAGE

A two component material supplied in separate containers to be mixed prior to use.

**Pack Size:** 20 litre and 5 litre units when mixed.

**Mixing Ratio:** 4 parts base to 1 part additive by volume.

**Weight:** 1.86 kg/litre (may vary with shade).

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



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#### SURFACE PREPARATION

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

Galvanised substrate shall be prepared by degrease / mordant wash or abrasion / sweep blast in accordance with the appropriate Sherwin-Williams Specification.

#### APPLICATION EQUIPMENT

##### Airless Spray

Nozzle Size: 0.46mm (18 thou)

Fan Angle: 80°

Operating Pressure: 155kg/cm<sup>2</sup> (2200 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/cm<sup>2</sup> (50 psi)

Fluid Pressure : 0.7kg/cm<sup>2</sup> (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.

For application by conventional spray, it may be necessary to thin the paint by the addition of up to 10% Cleanser/Thinner No. 5. Where thinning has been carried out the wet film thickness must be adjusted accordingly.

##### 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.

##### Roller

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

#### APPLICATION CONDITIONS AND OVERCOATING

This material should preferably be applied at temperatures in excess of 10°C. In conditions of high relative humidity, ie 80-85% good ventilation conditions are essential. Substrate temperature shall be at least 3°C above the dew point and always above 0°C.

At application temperatures below 10°C, drying and curing times will be significantly extended, and spraying characteristics may be impaired.

Application at ambient air temperatures below 5°C is not recommended.

In order to achieve optimum water and chemical resistance, temperature needs to be maintained above 10°C during curing.

If it is desired to overcoat outside the times stated on the data sheet, please seek advice of Sherwin-Williams.

#### ADDITIONAL NOTES

Drying times, curing times and pot life should be considered as a guide only.

The curing reaction of epoxies commences immediately the two components are mixed, and since the reaction is dependent on temperature, the curing time and pot life will be approximately halved by a 10°C increase in temperature and doubled by a 10°C decrease in temperature.

##### Epoxy Coatings - Tropical Use

Epoxy paints at the time of mixing should not exceed a temperature of 35°C. Use of these products outside of the pot life may result in inferior adhesion properties even if the materials appear fit for application. Thinning the mixed product will not alleviate this problem.

The maximum air and substrate temperature for application is 50°C providing conditions allow satisfactory application and film formation. If the air and substrate temperatures exceed 50°C and epoxy coatings are applied under these conditions, paint film defects such as dry spray, bubbling and pinholing etc, can occur within the coating.

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.