



Protective & Marine Coatings

MACROPOXY™ M330 EPOXY TIE COAT

FORMERLY KNOWN AS EPIGRIP M330

Revised 04/2017 Issue 15

PRODUCT INFORMATION

PRODUCT DESCRIPTION

A 2-pack epoxy sealercoat

RECOMMENDED USE

As a sealercoat for use over zinc silicate and other types of zinc rich primers.

As a blast primer for use over stainless steel

RECOMMENDED APPLICATION METHODS

Airless Spray

Recommended Thinner: Cleanser/Thinner No. 5

PRODUCT CHARACTERISTICS

Flash Point: Base : 28°C Additive : 24°C

% Solids by Volume: 47 ± 2% (ASTM-D2697-91)

Colour Availability: Red oxide

VOC

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

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

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

TYPICAL THICKNESS

Dry film thickness	Wet film thickness	Theoretical coverage
25 microns	53 microns	18.8m ² /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
Dry	25*
Wet	53

AVERAGE DRYING TIMES

	@ 15°C	@ 23°C	@ 35°C
To touch:	15 minutes	10 minutes	10 minutes
To recoat:	5 hours	4 hours	2 hours
To handle:	16 hours	16 hours	8 hours
Pot Life:	10 hours	8 hours	4 hours

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

RECOMMENDED PRIMERS / TOPCOATS

Zinc Clad J984 Zinc Rich Primer

Zinc Clad II EU

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 within 7 days at a minimum dft of 50 microns or in the case of Accrolon 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: 5 litre units when mixed

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

Weight: 1.30 kg/litre

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.

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.

APPLICATION CONDITIONS AND OVERCOATING

Epoxy paints 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 from 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.

When M330 is used as a tie-coat or sealer coat over inorganic zinc silicate, the zinc silicate must be left for a minimum of 16 hours at 15°C and then checked for cure. Prior to overcoating, the inorganic zinc silicate primer must be fully cured.

Care must be taken to ensure that Macropoxy M330 is not over-applied on to the zinc silicate otherwise there is a possibility of pinholing occurring.

Epoxy Coatings - Tropical Use

Epoxy paints at the time of mixing should not exceed a temperature of 35°C. At this temperature the pot life will be approximately halved. 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.