



**Industrial
&
Marine
Coatings**

**4.51
MACROPOXY® HS
HIGH SOLIDS EPOXY**

PART A B58-400 SERIES
 PART A B58Y400 PRIMER
 PART B B58V400 HARDENER

PRODUCT INFORMATION		Revised 5/05																												
PRODUCT DESCRIPTION		RECOMMENDED USES																												
<p>MACROPOXY HS HIGH SOLIDS EPOXY is a VOC compliant epoxy polyamine mastic designed for application to properly prepared steel surfaces. May be used as a one or two coat, direct-to-metal protective coating, or over Macropoxy Primer. Can be applied to marginally prepared surfaces.</p> <ul style="list-style-type: none"> • Long-term durability • Corrosion resistant • Resistant to many solvents and chemicals • Barrier coat or universal primer when applying high performance coating over alkyds, to prevent lifting • Low VOC 		<p>For use over prepared substrates such as steel and concrete in industrial environments.</p> <ul style="list-style-type: none"> • Structural steel • Refineries • Railcars • Power plants • Self-priming coating for marginally prepared substrates • Suitable for use in USDA inspected facilities <p>• Paper mills</p> <p>• Tanks</p> <p>• Vessels</p> <p>• Marine applications</p> <p>Conforms to AWWA D102-03, OCS #5</p>																												
PRODUCT CHARACTERISTICS		PERFORMANCE CHARACTERISTICS																												
<p>Finish: Semi-Gloss</p> <p>Color: Wide range of colors available, including safety colors and yellow oxide primer</p> <p>Volume Solids: 80% ± 2%, mixed, may vary by color</p> <p>Weight Solids: 82% ± 2%, mixed, may vary by color</p> <p>VOC (EPA Method 24): Unreduced: <250 g/L; 2.08 lb/gal mixed Reduced 10%: <300 g/L; 2.50 lb/gal</p> <p>Mix Ratio: 1:1 by volume</p> <p>Recommended Spreading Rate per coat:</p> <p>Wet mils: 4.0 - 8.0 Dry mils: 3.0 - 6.0 Coverage: sq ft/gal approx 215 - 425</p> <p>NOTE: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.</p> <p>Drying Schedule @ 6.0 mils wet @ 50% RH:</p> <table border="0"> <tr> <td></td> <td style="text-align: center;">@ 50°F</td> <td style="text-align: center;">@ 77°F</td> <td style="text-align: center;">@ 100°F</td> </tr> <tr> <td>To touch:</td> <td>7 hours</td> <td>4-6 hours</td> <td>2-4 hours</td> </tr> <tr> <td>To stencil:</td> <td>8 hours</td> <td>4-6 hours</td> <td>4 hours</td> </tr> <tr> <td>To recoat:</td> <td></td> <td></td> <td></td> </tr> <tr> <td> minimum:</td> <td>24 hours</td> <td>18 hours</td> <td>8 hours</td> </tr> <tr> <td> maximum:</td> <td>30 days</td> <td>30 days</td> <td>21 days</td> </tr> <tr> <td>To cure:</td> <td>7 days</td> <td>7 days</td> <td>5 days</td> </tr> </table> <p>Pot Life: 6 hours N/A 45 min. 4 hours* 30 min. 2 hours*</p> <p>*Reduced 10% with MEK</p> <p>Sweat-in-time: 30 minutes 15 minutes 5 minutes If maximum recoat time is exceeded, abrade surface before recoating. Drying time is temperature, humidity, and film thickness dependent.</p> <p>Shelf Life: 36 months, unopened Store indoors at 40°F to 100°F.</p> <p>Flash Point: 105°F, PMCC, mixed</p> <p>Reducer/Clean Up: Reducer #54 (R7K54) or MEK (R6K10) In California: Use Oxsol 100 (exempt solvent) or R7K111</p>			@ 50°F	@ 77°F	@ 100°F	To touch:	7 hours	4-6 hours	2-4 hours	To stencil:	8 hours	4-6 hours	4 hours	To recoat:				minimum:	24 hours	18 hours	8 hours	maximum:	30 days	30 days	21 days	To cure:	7 days	7 days	5 days	<p>System Tested: (unless otherwise indicated) Substrate: Steel Surface Preparation: SSPC-SP6 1 ct. Macropoxy HS @ 5.0 - 6.0 mils dft</p> <p>Abrasion Resistance: Method: ASTM D4060, CS17 wheel, 1000 cycles, 1 kg load Result: 60 mg loss</p> <p>Adhesion: Method: ASTM D4541 Result: 750 psi</p> <p>Dry Heat Resistance: Method: ASTM D2485 Result: 225°F</p> <p>Exterior Durability: Method: 1 year 45° South Result: Excellent, chalks</p> <p>Flexibility: Method: ASTM D522, 180° bend, 5/8" mandrel Result: Passes</p> <p>Moisture Condensation Resistance: Method: ASTM D4585, 100°F, 1000 hours Result: Passes, no blistering, rust, or delamination</p> <p>Pencil Hardness: Method: ASTM D3363 Result: H</p> <p>Salt Fog Resistance: Method: ASTM B117, 1000 hours Result: Passes—no cracking, softening or delamination, no more than 1/16" rust creepage at scribe</p> <p>Epoxy coatings may darken or yellow following application and curing.</p>
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