Protective & Marine Coatings
PRODUCT DATA SHEET

MACROPOXY® 2600
EPOXY INTERMEDIATE

Revised 05/2024 Issue 2

PRODUCT DESCRIPTION

A high solids 2-pack epoxy, available with conventional pigmentation, or alternatively pigmented with micaceous iron oxide (MIO) to provide enhanced overcoating properties and excellent barrier protection.

RECOMMENDED USE

Suitable as an intermediate layer in multicoat systems for atmospheric exposure in marine and heavy industrial environments.
Ideal for maintenance painting and fabrication shop application.
The loading of MIO ensures protection of sharp edges, corners, and welds.

PRODUCT TECHNICAL DATA

Volume Solids: 82 ± 3% (ISO 3233-3)

Weight Solids: 89 ± 3%

VOC: 176 g/l EPA Method 24.
176 g/l (103 g/kg) EC Solvent Emissions Directive (Council Directive 1999/13/EC).

Colours: Light Grey, Dark Grey, Off White.
Additional colours upon request.

Flash Point: Base: 37°C, Base MIO: 31°C, Hardener: 31°C

Cleaner/Thinner: No.2 for cleaning.
Global R7K119 or No.2 or No.50 for thinning with max. 10% to adapt the viscosity.
Thinning will affect VOC compliance, sag tolerance and dry film thicknesses.

Pack Size: A two component material supplied in separate containers to be mixed prior to use:
20 litre (32.5 kg) and 5 litre (8.8 kg) units when mixed.
Weight will vary with colours and density.

Mixing Ratio: 4 parts base to 1 part additive by volume.
7.52 kg parts base to 1.64 kg parts hardener by weight.

Density: 1.7 kg/l (may vary with colours).

Shelf Life: 2 years from date of manufacture, stored in originally sealed containers in a cool and dry environment, between 5°C and 38°C.

Recommended Application Methods:
Airless Spray, Conventional Spray, Brush, Roller.

Typical Thickness:

Recommended Spreading Rate Per Coat

100-250 µm	Typical (airless spray)	Maximum Sag (airless spray)
Dry	100 µm**	650 µm
Wet	125 µm**	800 µm
Theoretical Consumption*	0.12 l/m² 0.20 kg/m²	
Theoretical Coverage*	8.2 m²/l 4.82 m²/kg	

* This figure makes no allowance for surface profile, uneven application, overspray or losses in containers and equipment.
** Typical for airless and conventional spray.

Film thickness will vary depending on actual use and specification.
For application by roller the typical thickness is 85µm (wet) 65µm (dry).
For application by brush the typical thickness is 92µm (wet) 65µm (dry).

Pot Life:

-5°C	10°C	23°C	35°C
3+ hours	2+ hours	1 hour	45 min

Pot life is dependent on temperature and volume.

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AVERAGE DRYING TIMES

For 100 µm Dry Film Thickness:

	-5°C	10°C	23°C	35°C
Dry to handle (Drying Stage 6*)	30 hours	5 hours	2 hours	45 min
To Recoat	24 hours	5.5 hours	2 hours	45 min

* ISO 9117

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

Maximum recoat time is 6 months. Prior to further applications all contamination must be removed. In the case of extended recoating times, mechanically abrade the surface and remove contamination prior to application of additional coats.

Final cure: 1-2 week, depending on film thickness and temperature.

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

APPROVALS & ENDORSEMENTS

ISO12944-6:2018 C2 to CX certificates available as part of a system.

Norsok M501 System 1 as part of a system.

For details of substrate / system / corrosivity categories, consult Sherwin Williams.

SURFACE PREPARATION

Ensure surfaces to be coated are clean, dry and free from all surface contamination such as oil, grease, dirt and corrosion products to achieve satisfactory adhesion.

Apply to suitably primed ferrous or non-ferrous substrates.

MIXING

Stir component A and B very thoroughly using a mechanical paint mixer (start slowly, then increase up to approx. 300 rpm). Add component B carefully and mix both components very thoroughly (including sides and bottom of the container). Mix for at least 3 minutes until a homogeneous mixture is achieved. We recommend to fill the mixed material into a clean container and mix again shortly as described above to avoid incorrect mixing.

During mixing and handling of the materials always wear protective goggles, suitable gloves and other protective clothing.

APPLICATION CONDITIONS

Air and surface shall be above -5°C and surafce at least +3ºC above the dew point. Material temperature shall be above +10°C, and maximum +35°C. Relative air humidity shall be below 85%.

APPLICATION EQUIPMENT

The following is a guide. Changes in pressures and tip sizes may be needed for satisfactory application characteristics. Always purge spray equipment before use with listed cleaner. Any reduction must be compliant with existing VOC regulations and compatible with the existing environmental and application conditions.

Airless Spray

Unit: Efficient airless equipment

Tip Size: 0.38 mm (0.015 inch)

Fan Angle: 40°

Operating Pressure: min. 151 bar (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 substrate 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 consult Sherwin-Williams.

Conventional Spray

Atomising Pressure: 3.4 bar (50 psi)

Fluid Pressure: 0.3 bar (5 psi)

Brush and Roller

The material is suitable for brush and roller application.

Application of more than one coat may be necessary to give equivalent dry film thickness to a single spray applied coat.

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RECOMMENDED SYSTEMS

Suitable primers are:
Compatible with a wide range of Sherwin-Williams Macropoxy® and Zinc Clad® epoxy primers:
For example: Macropoxy® 4600

Suitable topcoats are:
Compatible with a wide range of Sherwin-Williams Acrolon® topcoats:
For example: Acrolon® 7300
The systems listed above are representative of the product's use, other systems may be appropriate.

ADDITIONAL NOTES

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

Epoxy Coatings - Colour Stability:
Variable colour stability is a feature of epoxy materials.
When epoxy materials are exposed to ultra-violet light a surface chalking effect will develop. This effect in no way detracts from the performance of the system.

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.
If the air and substrate temperatures exceed 40°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.

Chemical resistance:
Combined with 2-pack epoxy intermediate coats and 2-pack topcoats: Resistant to weathering, water, seawater, smoke gas, de-icing salts, acid and alkali vapours, oils, grease and short-term exposure to fuels and solvents.

Temperature resistance:
Dry heat up to +120°C, short term up to +150°C.
High humid ambient temperature up to approx.+50°C.
In case of higher temperatures consult Sherwin-Williams customer service.
Macropoxy® 2600 is not recommended for permanent immersion service.
Numerical values quoted for physical data may vary slightly from batch to batch.

HEALTH & SAFETY

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

WARRANTY

Whilst all statements made about our products (whether in this data sheet or otherwise) are correct and accurate to the best of our knowledge, we have no control over the quality or the condition of the substrate, the application conditions or the many other factors affecting your use and application of our product.

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