MACROPOXY® 646-100
FAST CURE EPOXY

Product Description
MACROPOXY 646-100 FAST CURE EPOXY is a high solids, less than 100 g/L VOC, 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.

- <100 g/L VOC
- Chemical resistant
- Low odor
- Abrasion resistant
- Outstanding application properties

Product Characteristics
Finish: Semi-Gloss
Color: Mill White and a wide range of colors available through tinting
Volume Solids: 73% ± 2%, mixed
Weight Solids: 83% ± 2%, mixed
VOC (EPA Method 24): Unreduced: <100 g/L; .83 lb/gal
mix Ratio: 1:1 by volume

Recommended Spreading Rate per coat:
- Wet mils (microns) 7.0 (175)
- Dry mils (microns) 5.0 (125) 10.0 (250)
- Coverage sq ft/gal (m²/L) 116 (28.6)

Recommended Uses
- Marine applications
- Fabrication shops
- Pulp and paper mills
- Power plants
- Offshore platforms
- Mill White is acceptable for immersion use for salt water and fresh water
- Not acceptable for potable water
- Suitable for use in USDA inspected facilities
- Acceptable for use in Canadian Food Processing facilities, categories: D3 (Confirm acceptance of specific part numbers/recipes with your SW Sales Representative)
- Conforms to AWWA D102 OCS #5
- Approved with FIRETEX hydrocarbon coatings

Performance Characteristics
Substrate*: Steel
Surface Preparation*: SSPC-SP10/NACE 2
System Tested*: 1 ct. Macropoxy 646-100 Fast Cure @ 6.0 mils (150 microns) dft

Test Name Test Method Results
 Abrasion Resistance ASTM D4060, CS17 wheel, 1000 cycles, 1 kg load 84 mg loss
 Accelerated Weathering - QUV† ASTM D4587, QUV-A, 12,000 hours Passes
 Adhesion ASTM D4541 1,037 psi
 Corrosion Resistance ASTM D5894, 36 cycles, 12,000 hours Rating 10 per ASTM D714 for blistering; Rating 9 per ASTM D610 for rusting
 Direct Impact Resistance ASTM D2794 30 in. lb.
 Dry Heat Resistance ASTM D2485 250°F (121°C)
 Exterior Durability 1 year at 45° South Excellent, chalks
 Flexibility ASTM D522, 180° blend, 3/4" mandrel Passes
 Immersion 1 year fresh and salt water Passes, no rusting, blistering, or loss of adhesion
 Pencil Hardness ASTM D3363 3H
 Salt Fog Resistance† ASTM B117, 6,500 hours Rating 10 per ASTM D610 for rusting; Rating 9 per ASTM D1654 for corrosion
 Water Vapor Permeance ASTM D1653, Method B 1.16 US perms

Footnotes:
† Zinc Clad II Plus Primer

Drying Schedule @ 7.0 mils wet (175 microns):

- To touch: 4-5 hours 2 hours 1.5 hours
- To handle: 48 hours 8 hours 4.5 hours
- To recoat: minimum 48 hours 8 hours 4.5 hours
  maximum 1 year 1 year 1 year
- Cure for minimum 10 days 7 days 4 days
  service 14 days 7 days 4 days
- If maximum recoat time is exceeded, abrade surface before recoating.
- Drying time is temperature, humidity, and film thickness dependent.

Pot Life: 10 hours 4 hours 2 hours
Sweat-in-time: 30 minutes 30 minutes 15 minutes

Shelf Life: 36 months, unopened
Store indoors at 40°F (4.5°C) to 100°F (38°C).
Flash Point: 61°F (16°C), PMCC, mixed
Reducer/Clean Up: Reducer R7K111 or Oxsol 100

0°F (−18°C), PMCC, mixed

Reducing Time 10%: <100 g/L; .83 lb/gal

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- Low odor
- Abrasion resistant
- <100 g/L VOC
- Chemical resistant

Mix Ratio:

- Unreduced: <100 g/L; .83 lb/gal
- Reduced 10%: <100 g/L; .83 lb/gal

VOC (EPA Method 24): Unreduced: <100 g/L; .83 lb/gal

Weight Solids: 83% ± 2%, mixed

Volume Solids: 73% ± 2%, mixed

Mix Ratio: 1:1 by volume

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- Cure for minimum 10 days 7 days 4 days
  service 14 days 7 days 4 days

If maximum recoat time is exceeded, abrade surface before recoating.

Drying time is temperature, humidity, and film thickness dependent.

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Shelf Life: 36 months, unopened
Store indoors at 40°F (4.5°C) to 100°F (38°C).
Flash Point: 61°F (16°C), PMCC, mixed
Reducer/Clean Up: Reducer R7K111 or Oxsol 100

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### Recommended Systems

<table>
<thead>
<tr>
<th>Surface Type</th>
<th>Dry Film Thickness / ct.</th>
<th>Microns</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Immersion and atmospheric:</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Steel:</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>2 cts. Macropoxy 646-100</td>
<td>5.0-10.0</td>
<td>(125-250)</td>
</tr>
<tr>
<td><strong>Concrete/Masonry, smooth:</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>2 cts. Macropoxy 646-100</td>
<td>5.0-10.0</td>
<td>(125-250)</td>
</tr>
<tr>
<td><strong>Concrete Block:</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>1-2 cts. of recommended topcoat</td>
<td></td>
<td></td>
</tr>
<tr>
<td>1 ct. Macropoxy 646-100 Fast Cure Epoxy</td>
<td>3.0-6.0</td>
<td>(75-150)</td>
</tr>
<tr>
<td><strong>Atmospheric:</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>&quot;Steel:&quot;</td>
<td></td>
<td></td>
</tr>
<tr>
<td>(Shop applied system, new construction, AWWA D102, can also be used at 3 mils (75 microns) dft when used as part of a multi-coat system)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>1 ct. Macropoxy 646-100</td>
<td>5.0-10.0</td>
<td>(125-250)</td>
</tr>
<tr>
<td><strong>Aluminum:</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>1-2 cts. Acrolon 218 Polyurethane</td>
<td>3.0-6.0</td>
<td>(75-150)</td>
</tr>
<tr>
<td>or Hi-Solids Polyurethane</td>
<td>3.0-5.0</td>
<td>(75-125)</td>
</tr>
<tr>
<td>or SherThane 2K Urethane</td>
<td>2.0-4.0</td>
<td>(50-100)</td>
</tr>
<tr>
<td><strong>Steel:</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>2 cts. Macropoxy 646-100</td>
<td>5.0-10.0</td>
<td>(125-250)</td>
</tr>
<tr>
<td>1-2 cts. Tile-Clad HS Epoxy</td>
<td>2.5-4.0</td>
<td>(63-100)</td>
</tr>
<tr>
<td><strong>Steel:</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>1 ct. Zinc Clad II Plus</td>
<td>3.0-6.0</td>
<td>(75-150)</td>
</tr>
<tr>
<td>1 ct. Macropoxy 646-100</td>
<td>3.0-10.0</td>
<td>(75-250)</td>
</tr>
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<td>(75-150)</td>
</tr>
<tr>
<td><strong>Aluminum:</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>2 cts. Macropoxy 646-100</td>
<td>5.0-10.0</td>
<td>(125-250)</td>
</tr>
<tr>
<td><strong>Galvanizing:</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>2 cts. Macropoxy 646-100</td>
<td>5.0-10.0</td>
<td>(125-250)</td>
</tr>
</tbody>
</table>

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

### 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.**
- **Refer to product Application Bulletin for detailed surface preparation information.**
- **Minimum recommended surface preparation:**
  - **Iron & Steel**
    - Atmospheric: SSPC-SP2/B
    - Immersion: SSPC-SP10/NACE 2, 2-3 mil (50-75 micron) profile
  - **Aluminum:** SSPC-SP1
  - **Galvanizing:** SSPC-SP1
  - **Concrete & Masonry**
    - Atmospheric: SSPC-SP13/NACE 6, or ICRI No. 310.2R, CSP 1-3
    - Immersion: SSPC-SP13/NACE 6-4.3.1 or 4.3.2, or ICRI No. 310.2R, CSP 1-3
  - **Ductile Iron Pipe:**
    - Atmospheric: NAPF 500-03-03 Power Tool Cleaning
    - Buried & Immersion: NAPF 500-03-04 Abrasive Blast Cleaning
  - **Cast Ductile Iron Fittings:**
    - NAPF 500-03-05 Abrasive Blast Cleaning

### Tinting

- **Tint Part A with Maxitoners at 150% strength. Five minutes minimum mixing on a mechanical shaker is required for complete mixing of color.**
- **Tinting is not recommended for immersion service.**

### Application Conditions

- **Temperature:** 40°F (4.5°C) minimum, 140°F (60°C) maximum (air, surface, and material)
- **Relative humidity:** 85% maximum

Refer to product Application Bulletin for detailed application information.

### Ordering Information

- **Packaging:**
  - Part A: 1 gallon (3.78L) and 5 gallon (18.9L) containers
  - Part B: 1 gallon (3.78L) and 5 gallon (18.9L) containers
- **Weight:** 13.24 ± 0.2 lb/gal ; 1.6 Kg/L
  - mixed, may vary by color

### Safety Precautions

- Refer to the SDS sheet before use.
- Published technical data and instructions are subject to change without notice. Contact your Sherwin-Williams representative for additional technical data and instructions.

### 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.

Disclaimer:
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Surface Preparations

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.

Iron & Steel, Atmospheric Service:
Minimum surface preparation is Hand Tool Clean per SSPC-SP2. Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1. For better performance, use Commercial Blast Cleaning per SSPC-SP6. Use a 2-3 mil (50-75 micron) blast, clean all surfaces using a sharp, angular abrasive for optimum surface profile. Prime any bare steel within 8 hours or before flash rusting occurs.

Carbon Steel, Immersion Service:
Clean and degrease the surface prior to abrasive blasting per SSPC-SP1 Solvent Cleaning. Methods described in SSPC-SP 1 include solvents, alkali, detergent/water, emulsions, and steam. The surface shall be abrasive blasted to SSPC-SP10/Cleaning. The anchor pattern shall be sharp with no evidence of a polished surface. The finished surface shall be free of all visible oil, grease, dust, dirt, mill scale, rust, coating, oxides, corrosion products, and other foreign matter with no more than 5% staining. After blasting, all dust and loose residue should be removed from the surface by acceptable means. Coat steel the same day as it is prepared and prior to the formation of rust.

Ductile Iron Pipe, Atmospheric Service:
Minimum surface preparation is Power Tool Clean per NAPF 500-03-03. Remove all oil and grease from surface by Solvent Cleaning per NAPF 500-03-01.

Ductile Iron Pipe, Buried and Immersion Service:
Minimum surface preparation is Abrasive Blast Cleaning per NAPF 500-03-04. Ductile iron pipe external surfaces, in some cases, can be damaged by excessive abrasive blast cleaning beyond this standard. Remove all oil and grease from surface by Solvent Cleaning per NAPF 500-03-01.

Ductile Iron Fittings:
Minimum surface preparation is Abrasive Blast Cleaning of Cast Ductile Iron Fittings per NAPF 500-03-05. Remove all oil and grease from surface by Solvent Cleaning per NAPF 500-03-01.

Aluminum
Remove all oil, grease, dirt, oxide and other foreign material by Solvent Cleaning per SSPC-SP1.

Galvanized Steel
Allow to weather a minimum of six months prior to coating. Solvent Clean per SSPC-SP1 (recommended solvent is VM&P Naphtha). When weathering is not possible, or the surface has been treated with chromates or silicates, first Solvent Clean per SSPC-SP1 and apply a test patch. Allow paint to dry at least 5°F (2.8°C) above dew point. If adhesion is poor, brush blasting per SSPC-SP7 is necessary to remove these treatments. Rusty galvanizing requires a minimum of Hand Tool Cleaning per SSPC-SP2, prime the area the same day as cleaned.

Concrete and Masonry
For surface preparation, refer to SSPC-SP13/NACE 6, or ICRI No. 310.2R, CSP 1-3. Surfaces should be thoroughly clean and dry. Concrete and mortar must be cured at least 28 days @ 75°F (24°C). Remove all loose mortar and foreign material. Surface must be free of laitance, concrete dust, dirt, form release agents, moisture curing membranes, loose cement and hardeners. Fill bug holes, air pockets and other voids with Steel-Seam FT910.

Follow the standard methods listed below when applicable:
ASTM D4258 Standard Practice for Cleaning Concrete.
ASTM D4259 Standard Practice for Abridging Concrete.
ASTM D4260 Standard Practice for Etching Concrete.
ASTM F1869 Standard Test Method for Measuring Moisture Vapor Emission Rate of Concrete.
SSPC-SP 13/NACE 6 Surface Preparation of Concrete.
ICRI No. 310.2R Concrete Surface Preparation.

Concrete, Immersion Service:
For surface preparation, refer to SSPC-SP13/NACE 6, Section 4.3.1 or 1.3.2 or ICRI No. 310.2R, CSP 1-3.

Previously Painted Surfaces:
If in sound condition, clean the surface of all foreign material. Scaryfy the surface to create the desired surface profile. Apply coatings on a test area, allowing paint to dry one week before testing adhesion. If adhesion is poor, or if this product attacks the previous finish, removal of the previous coating may be necessary.

Surface Preparation Standards

<table>
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<th>Condition of Surface</th>
<th>ISO 8501-1</th>
<th>SSPC</th>
<th>NACE</th>
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<td>BS7679.A1</td>
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<tr>
<td>Near White Metal</td>
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<tr>
<td>Commercial Blast</td>
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<tr>
<td>Brush-Off Blast</td>
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<tr>
<td>Hand Tool Cleaning</td>
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<tr>
<td>Power Tool Cleaning</td>
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Application Conditions

- Temperature: 40°F (4.5°C) minimum, 140°F (60°C) maximum
- (air, surface, and material) At least 5°F (2.8°C) above dew point
- Relative humidity: 85% maximum

Application Equipment

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

Reducer/Clean Up ..........Reducer R7K111 or Oxsol 100

NOTE: The addition of reducer to the product can result in parameters not covered by the PDS for dry & handle times, cure time, min. and max. recoat times as well as sag resistance.

Airless Spray

- Pump: ................. 30:1
- Pressure: .............. 2800 - 3000 psi
- Hose: ................. 1/4" ID
- Filter: ................. 60 mesh
- Tip: .................. .017" - .023"
- 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
- Fluid Pressure: ......... 10-20 psi
- ReducEon: As needed up to 10% by volume
- Requires oil and moisture separators

Brush

- Brush: ................. Nylon/Polyester or Natural Bristle
- Reduction: As needed up to 10% by volume

Roller

- Cover: .................. 3/8" woven with solvent resistant core
- Reduction: As needed up to 10% by volume

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

**Application Procedures**

Surface preparation must be completed as indicated. Mix contents of each component thoroughly with low speed power agitation. Make certain no pigment remains on the bottom of the can. Then combine one part by volume of Part A with one part by volume of Part B. Thoroughly agitate the mixture with power agitation. Allow the material to sweat-in as indicated prior to application. Re-stir before using.

If reducer solvent is used, add only after both components have been thoroughly mixed, after sweat-in.

Apply paint at the recommended film thickness and spreading rate as indicated below:

<table>
<thead>
<tr>
<th>Recommended Spreading Rate per coat:</th>
<th>Minimum</th>
<th>Maximum</th>
</tr>
</thead>
<tbody>
<tr>
<td>Wet mils (microns)</td>
<td>7.0</td>
<td>13.5</td>
</tr>
<tr>
<td>Dry mils (microns)</td>
<td>5.0</td>
<td>10.0</td>
</tr>
<tr>
<td>~Coverage sq ft/gal (m²/L)</td>
<td>116</td>
<td>232</td>
</tr>
<tr>
<td>Theoretical coverage sq ft/gal (m²/L) @ 1 mil / 25 microns dft</td>
<td>1168 (28.6)</td>
<td></td>
</tr>
</tbody>
</table>

*May be applied at 3.0-10.0 mils (75-250 microns) dft in a multi-coat system. Refer to Recommended Systems and Performance Tips Sections.

**Drying Schedule @ 7.0 mils wet (175 microns):**

- **At 40°F/4.5°C:**
  - To touch: 4-5 hours
  - To handle: 48 hours
  - To recoat: 48 hours
  - Cure for service: 10 days
  - Cure for immersion: 14 days
- **At 77°F/25°C:**
  - To touch: 2 hours
  - To handle: 8 hours
  - To recoat: 8 hours
  - Cure for service: 7 days
  - Cure for immersion: 7 days
- **At 100°F/38°C:**
  - To touch: 1.5 hours
  - To handle: 4.5 hours
  - To recoat: 4.5 hours
  - Cure for service: 1 year
  - Cure for immersion: 1 year

If maximum recoat time is exceeded, abrade surface before recoating.

Drying time is temperature, humidity, and film thickness dependent.

**Clean Up Instructions**

Clean spills and spatters immediately with Reducer R7K111 or Oxsol 100. Clean tools immediately after use with Reducer R7K111 or Oxsol 100. Follow manufacturer’s safety recommendations when using any solvent.

**Disclaimer**

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**Performance Tips**

Stripe coat all crevices, welds, and sharp angles to prevent early failure in these areas.

When using spray application, use a 50% overlap with each pass of the gun to avoid holidays, bare areas, and pinholes. If necessary, cross spray at a right angle.

Spreading rates are calculated on volume solids and do not include an application loss factor due to surface profile, roughness or porosity of the surface, skill and technique of the applicator, method of application, various surface irregularities, material lost during mixing, spilling, overthinning, climatic conditions, and excessive film build.

Excessive reduction of material can affect film build, appearance, and adhesion.

Do not mix previously catalyzed material with new.

Do not apply the material beyond recommended pot life.

In order to avoid blockage of spray equipment, clean equipment before use or before periods of extended downtime with Reducer R7K111 or Oxsol 100.

Insufficient ventilation, incomplete mixing, miscatalyzation, and external heaters may cause premature yellowing.

Excessive film build, poor ventilation, and cool temperatures may cause solvent entrapment and premature coating failure.

Tinting is not recommended for immersion service.

Use only Mill White for immersion service.

Quik-Kick Epoxy Accelerator is acceptable for use. See data page 4.99 for details.

Application of coating above maximum or below minimum recommended spreading rate may adversely affect coating performance.

For Immersion Service: (if required) Holiday test in accordance with ASTM D5162 for steel, or ASTM D4787 for concrete.

When coating over steel in a zinc/epoxy/epoxy, or epoxy/epoxy/epoxy system, Macropoxy 646-100 must be applied at a minimum dft of 3.0 mils per coat.

Acceptable for Concrete Floors.

Refer to Product Information sheet for additional performance characteristics and properties.

**Safety Precautions**

Refer to the SDS sheet before use.

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**Warranty**

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