Protective & Marine Coatings
PRODUCT DATA SHEET

MACROPOXY® 2706 EG

EPOXY PRIMER AND INTERMEDIATE COAT/MIO

Revised 07/2023 Issue 1

PRODUCT DESCRIPTION

A 2-pack epoxy coating pigmented with micaceous iron oxide (MIO).
- Direct to hot-dip galvanized steel, stainless steel and aluminium
- Suitable as sealer for thermal-sprayed zinc coatings
- High mechanical resistance

RECOMMENDED USE

Can be used as a primer for hot-dip galvanized steel and as an intermediate coating for atmospheric corrosion protection on steel.
It can be used as a primer under FIRETEX®, Unitherm® and Pyroplast® fire protection systems.
Also recommended as a sealer coat for thermal-sprayed metallic zinc coatings to seal the pores.

PRODUCT TECHNICAL DATA

Volume Solids: 45 ± 2% (ISO 3233-3)

Weight Solids: 66 ± 2%

VOC: 476 g/l determined practically in accordance with Protective Coatings Directive of German Paint Industry Association (VdL-RL 04).
470 g/l calculated from formulation to satisfy EC Solvent Emissions Directive.
336 g/kg calculated from formulation to satisfy EC Solvent Emissions Directive (UK).

Colours: Approx. RAL 7032, pebble grey.
Finish: Matt.
Slight colour deviations are possible due to raw material characteristics.

Flash Point: Base: 35°C, Hardener: 24°C

Cleaner/Thinner: Cleaner 26 (for cleaning)
Thinner E+B for thinning with max. 2% to adapt the viscosity.
Thinning will affect VOC compliance, sag tolerance and dry film thicknesses.
If used as a sealer, thin with 10% Thinner E+B and use the thinned material immediately and under continuous stirring to avoid settling.

Pack Size: A two component material supplied in separate containers to be mixed prior to use:
24 kg (17.1 litre) and 3 kg (2.1 litre) units when mixed.
Volume will vary with colours and density.

Mixing Ratio: 100 parts base to 20 parts hardener by weight.
3.3 parts base to 1 part hardener by volume.

Density: 1.4 kg/l (may vary with colours)

Shelf Life: 3 years from date of manufacture, stored in originally sealed containers in a cool and dry environment.

Recommended Application Methods:
Airless Spray, Brush, Roller

Typical Thickness:

Recommended Spreading Rate Per Coat

	Typical
Dry	40 µm
Wet	89 µm
Theoretical Consumption*	0.124 kg/m² 0.089 l/m²
Theoretical Coverage*	8.04 m²/kg 11.25 m²/l

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

Pot Life:

+ 20°C	8 hours

Pot life is dependent on temperature and volume.

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AVERAGE DRYING TIMES

For 40 µm Dry Film Thickness:

	+ 20°C
Dry to handle (Drying Stage 6*)	16 hours
To Recoat	8 hours

*ISO 9117

Maximum recoat time is 6 months. Prior to further applications all contamination must be removed. In the case of extended recoating times consult Sherwin Williams customer service.

Final cure: 1 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

Tested and official approved primer for FIRETEX®, Unitherm® and Pyroplast® fire protection systems on steel.

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.
For contaminated and weathered surfaces e.g. primed areas we recommend to clean with Cleaner Wash.

Steel surfaces shall be blast-cleaned to Sa 2½ according to ISO 8501-1 (ISO 12944-4)

Hot-dip galvanized surfaces shall be prepared by degreasing or, in case of permanent immersion or condensation, sweep blasting according to ISO 12944-4 with a non-ferrous blasting abrasive.

Thermal-sprayed metallic coating shall be thoroughly cleaned of spray dust and loose spray particles. Sealing must be started immediately after the spraying process and before visible oxidation of the surface occurs and to avoid contamination by dirt or moisture.

Stainless steel and aluminium shall be sweep blasted according to ISO 12944-4 with a non-ferrous blasting abrasive.

MIXING

Stir component A 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

Substrate temperature shall be above + 10°C and at least 3°C above the dew point.
Material temperature shall be above + 10°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: Airless equipment
Tip Size: 0.38 – 0.53 mm (0.015 – 0.021 inch)
Fan Angle: 40° - 80°
Operating Pressure: min. 180 bar (2600 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 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 customer service.

Brush and Roller
The coating is suitable for brush and roller application.

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RECOMMENDED SYSTEMS

Steel

1 x Macropoxy® or Zinc Clad® primer

1 x Macropoxy® 2706 EG

1 x Acrolon® topcoat

Intermediate coat

Compatible with a wide range of Sherwin-Williams Macropoxy® and Zinc Clad® epoxy primers.

Overcoatable with epoxy and polyurethane coatings provided the surface to be coated is clean, dry and free from contamination.

Hot-dip galvanized steel, stainless steel and aluminium

1 x Macropoxy® 2706 EG

1 x Macropoxy® intermediate coat

1 x Acrolon® topcoat

Thermal-sprayed metallic zinc coatings

1 x Macropoxy® 2706 EG as sealer

Intumescent coating on hot-dip galvanized steel

1 x Macropoxy® 2706 EG

FIRETEX®, Unitherm® or Pyroplast® fire protection systems in the recommended dry film thickness

For use as a sealer on thermal-sprayed metallic zinc coatings, thin with 10% Thinner E+B. Apply the thinned material immediately and under constant stirring as a thin mist-coat to fill substrate porosity without applying a full coat at this stage.

After a waiting time of approx. 15 minutes, spray 'wet on wet' the remaining thickness of the Macropoxy® intermediate coat.

ADDITIONAL NOTES

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

Epoxy Coatings - Tropical Use

Epoxy coatings at the time of mixing should not exceed a temperature of 35ºC. 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 40ºC 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:

Resistant to weathering, water, seawater, smoke, 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.

In case of higher temperatures consult Sherwin-Williams customer 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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