



MAKEPaints

MAKEMASTIC HIGH SOLID 601 Surface Tolerant Epoxy

Base 601 : Curing Agent 6011

PRODUCT DESCRIPTION Two Components Surface Tolerant High Solid Polyamine Cured Modified Epoxy Primer / Coating

RECOMMENDED USE High performance surface tolerant epoxy for general maintenance coating which can be applied to new or old steel and resists to splash / spillage of a wide range of chemicals.

CHARACTERISTIC

- Surface tolerant coating for lower grade of steel surface preparation.
- High performance self-priming topcoats.
- Can be over coated with wide range of topcoats.
- Compatible with various aged coatings.
- Can be applied over most existing coatings.
- Excellent corrosion resistance and good flexibility.
- Good resistance to splash / spillage of acids, alkalis, solvents, fresh and salt water
- Resists high humidity and moisture.
- Not recommended to immersion in acids and alkalis

PHYSICAL DATA

- **Colour** : Available on request.
- **Gloss level** : Semi Gloss.
- **Specific Gravity** : 1.50 ± 0.10 kg/ltr.
- **Volume Solid** : Approx 84%.
- **Dry Film Thickness** : 100-200 microns / coats.
- **Theoretical Coverage** : 5.60 sq.m/ltr for 150 microns.
- **Dry Time** :

Temperature	Touch Dry	Hard Dry
26°C	4 hours	10 hours
32°C	3 hours	8 hours
36°C	2.5 hours	7 hours
40°C	2 hours	6 hours

- **Full Cure** : 7 Day
- **Painting Interval** : Min : 8 Hours, Max 6 Months
- **VOC** : Max. 190 g/ltr
- **Flash Point(DIN 53213)** : 65°C for base and 45°C for hardener
- **Pot Life** : 8 hours (after mixing the components)
- **Service Temperature** : Continuous : 120°C ; Periodic : up to 150°C
- **Shelf Life** : 12 months (cool and dry place)

SURFACE PREPARATION

Steel

- Dry abrasive blast in accordance with ISO – Sa 2.5 or SSPC – SP 10 “Commercial”.
- Blast to achieve an anchor profile of 25 microns as determined with a Keane Tutor Surface Profile Comparator.
- Remove abrasive residue or dust from surface.
- However when this is impossible, can be applied over mechanically cleaned surface, hand tool or power tool to St 2 or St 3.
- Old coating system, sufficiently roughened, cleaned and dry.

Aluminium and Galvanizing

- Light abrasive blast.

Concrete

Abrasive blast to ASTM D 4259.

CONDITION OF APPLICATION

Temperature ; minimum 5°C : maximum 50°C.
 Relative Humidity maximum 85%.
 Substrate temperature should be at last 3°C above dew point.

SYSTEM SPECIFICATION

Preceding coat : MAKETHANE 700

INSTRUCTION FOR USE

- Mixing ratio by volume ; Base; Hardener 1 : 1
- The temperature of mixed base and hardener should be above 15°C, otherwise extra solvent may be required to obtain application viscosity.
- Stir well before use preferable by means of mechanical mixer. Thinner should be added after mixing the components
- Too much solvent result in lower sag resistance and slower cure
- Thinner should be added after mixing the components

APPLICATION DETAILS

Method Application	Airless Spray	Air Spray	Roller Brush
Thinner No	MAKE 906	MAKE 906	MAKE 906
Volume of Thinner	Max 10%	Max 15%	Max 5%
Nozzle orifice	0.018 (0.46m)	1.5-2 mm	-
Nozzle Pressure	150 bar (2100 psi)	3-4 bar / 57 psi	-
Cleaning Solven	MAKE 10	-	-

ADDITIONAL DATA

Over coating table for Epoxy and Polyurethane paint

Substrate Temp	10°C	20°C	32°C	40°C
Min. interval	24 hours	12 hours	8 hours	8 hours
Max. interval	6 months	4 months	3 months	3 months

Pot life (at application viscosity)

Temperature	Pot life	The figures are valid for quantities of 5 liter and more
15°C	10 hours	
20°C	8 hours	
26°C	6 hours	
32°C	5 hours	
36°C	4 hours	

STORAGE & HANDLING

The product must be stored in accordance with national regulation. Storage conditions are to keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition. Containers must be kept tightly closed. Handle with care, stir well before use.

SAFETY PRECAUTION

Keep away from heat, spark and open flames. Avoid breathing of vapour on skin and eye contact. Keep container closed and store in cool, ventilated area when not in use. Proper ventilation and protective measures must be provided during mixing, application and drying, to keep vapour concentration within safe limits and to protect against toxic hazard. Necessary safety equipment must be used and ventilation requirements carefully observed, especially in confined or enclosed spaces, such as tank interior and building.

DISCLAIMER

The information in this product data sheet is given to the best of our knowledge based on laboratory testing and practical experience. If the product is used under condition beyond our control, we cannot guarantee anything but the quality of the products it self. The information in this product data sheet is liable for modification from time to time in the light of experience and our policy of continuous product development, and without further notice.