



MAKEPaints

**MAKEGUARD 606
Glass Flake**

Base 606 : Curing Agent 6061

PRODUCT DESCRIPTION Two Component High Solid Glass Flake Reinforced Polyamine Cured Epoxy Coating

RECOMMENDED USE Glass flake particularly used in areas of the subject to heavy impact, excellent corrosion resistant due to its low permeability and high electrolytic resistance

- CHARACTERISTIC**
- Exellent abrasion and impact resistance
 - Long term protection for areas subject to heavy wear and tear
 - Exellent resistance to corrosion
 - Very low water permeability, due to glass flake barrier
 - Tar free
 - Resistance to splash and spillage of a wide range of chemicals
 - Application and curing at temperatures down to -5°C

PHYSICAL DATA

- **Colour** : Black
- **Gloss level** : Gloss
- **Specific Gravity** : 1.50 ± 0.20 kg/litre
- **Volume Solid** : 84 ± 2%
- **Dry Film Thickness** : 400 microns
- **Wet Film Thickness** : 476 microns
- **Theoretical Coverage** : 2.1 m²/litre - 400 microns
- **Dry Time** :

Temperature	Touch Dry	Hard Dry
26°C	2.5 hours	7 hours
32°C	2 hours	5 hours
36°C	1.5 hours	4 hours
40°C	1 hours	3 hours

- **Full Cure** : 7 Day
- **Painting Interval** : Min : 8 Hours, Max 30 days
- **VOC** : Max. 140 g/ltr
- **Flash Point(DIN 53213)** : 25°C for base and 26°C for hardener
- **Pot Life** : 5 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 Dry abrasive blast in accordance with ISO – Sa 2.5 or SSPC – SP 10 “Near White”. Blast to achieve an anchor profile of 25 – 50 microns as determined with a Keane Tutor Surface Profile Comparator. Remove abrasive residue or dust from surface.

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

INSTRUCTION FOR USE Precedin Coat :

- CONDITION OF APPLICATION**
- Mixing ratio by volume ; Base; Hardener 3 : 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- mm	-
Nozzle Pressure	150 bar (2100 psi)	3-4 bar / 57 psi	-
Cleaning Solvent	MAKE 10	-	-

Over coating table for Epoxy and Polyurethane paint

Substrate Temp	10°C	20°C	32°C	40°C
Min. interval	12 hours	8 hours	6 hours	5 hours
Max. interval	30 days	30 days	30 days	3 months

Pot life (at application viscosity)

Temperature	Touch Dry	Hard Dry	Full Spray	Pot life
10°C	8 hours	8 hours	8 days	4 hours
20°C	3 hours	6 hours	7 days	3 hours
32°C	2 hours	5 hours	4 days	2 hours
40°C	1 hours	3 hours	2 days	1 hours

STORAGE & HANDLING

The Product must be stored in accordance with National Regulation. Storage condition are to keep the containers in 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

Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult MAKE Safety Data Sheets and follow all local or national safety regulations.

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.