



MAKEPaints

**MAKEGUARD 608
Epoxy Multipurpose**

Base 608 : Curing Agent 6081

PRODUCT DESCRIPTION	Multipurpose High Build Polyamide Cured Epoxy															
RECOMMENDED USE	High performance primer or built coat for durable systems with wide range of protective topcoats.															
CHARACTERISTIC	<ul style="list-style-type: none"> • Rust inhibitive epoxy primer. • Compatible with compromised surface preparation. • Excellent shop primer for corrosive service • Easy application • Excellent adhesion to bare steel and inorganic zinc silicate. • Suitable for immersion in salt solution and water at temperature up to 60°C. • Tank lining for alkaline, salt solution, petroleum fuels and sewage waste. • Can be applied over concrete, aluminium, stainless steel and galvanizing. 															
PHYSICAL DATA	<ul style="list-style-type: none"> • Colour : Available On Request • Gloss level : Flat • Specific Gravity : 1.50 ± 0.10 kg/litre • Volume Solid : 70% • Dry Film Thickness : 100 -150 microns / coats. • Theoretical Coverage : 7.00 sq.m/litre for 100 microns • Dry Time : <table border="1"> <thead> <tr> <th>Temperature</th> <th>Touch Dry</th> <th>Hard Dry</th> </tr> </thead> <tbody> <tr> <td>26°C</td> <td>60 minutes</td> <td>6 hours</td> </tr> <tr> <td>32°C</td> <td>50 minutes</td> <td>5.5 hours</td> </tr> <tr> <td>36°C</td> <td>40 minutes</td> <td>5 hours</td> </tr> <tr> <td>40°C</td> <td>30 minutes</td> <td>4 hours</td> </tr> </tbody> </table> <ul style="list-style-type: none"> • Full Cure : 7 Day. • Painting Interval : Min : 8 Hours, Max 6 Months. • VOC : Max. 316.8 g/litre. • Flash Point(DIN 53213) : 25°C for base and 26°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). 	Temperature	Touch Dry	Hard Dry	26°C	60 minutes	6 hours	32°C	50 minutes	5.5 hours	36°C	40 minutes	5 hours	40°C	30 minutes	4 hours
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SURFACE PREPARATION	Steel : blast cleaned in situ to at least SSPC – SP10 and free from rust, scale, shop primer and any other contamination.															
CONDITION OF APPLICATION	<p>Temperature ; minimum 5°C : maximum 50°C.</p> <p>Relative Humidity maximum 85%.</p> <p>Substrate temperature should be at last 3°C above dew point.</p>															
SYSTEM SPECIFICATION	Can be top coat with all paint type(alkyd, epoxy, coal tar epoxy, vinyl, chlorinate rubber or polyurethane, etc.															
INSTRUCTION FOR USE	<ul style="list-style-type: none"> • 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 Solvent	MAKE 10	-	-

ADDITIONAL DATA

Over coating table :

	Substrate Temp			
	10°C	20°C	32°C	40°C
Min interval	16 hours	8 hours	6 hours	4 hours
Max interval when not expose to daylight	6 hours	6 hours	4 hours	3 hours
Max interval when expose to daylight	3 hours	3 hours	2 hours	2 hours

Film Thickness and spreading rate

Max DFT Without sagging with airless spray	250 microns	2.4 m ² /ltr
Max DFT When Brushing	50 microns	12 m ² /litre
Max DFT for closed film with airless spray	25 microns	24 m ² /ltr

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.