



MAKEPaints

**MAKEGUARD 611  
Epoxy Finish**

**Base 611GL : Curing Agent 6111**

**PRODUCT DESCRIPTION**

**A two Component Chemical Resistace Finish based On polyamide cured epoxy resin**

**RECOMMENDED USE**

Suitable for use in both maintenance and new construction situations as part of an anti-corrosive coating system and protect steel and concrete surfaces against alkaline, salt and solvent solution.

**CHARACTERISTIC**

- Good resistance to splash, spillage and fumes of alkaline, salt and solvent solution.
- Hard and abrasion resistance.
- Resist continuous immersion in alkaline (up to 50% concentration) at ambient temperature.
- Resist continuous immersion in petroleum products such as motor fuels, jet fuels, diesel oil and gasoline.
- Resist continuous immersion in salt solution, fresh or dematerialized water up to 60°C.

**PHYSICAL DATA**

- **Colour** : Available On Request
- **Gloss level** : Gloss
- **Specific Gravity** : 1.25 ± 0.5 kg/litre
- **Volume Solid** : Approx. 50 ± 2%
- **Dry Film Thickness** : 75 microns per coats
- **Theoretical Coverage** : 6.7 sq.m/litre for 75microns
- **Dry Time** :

Temperature	Touch Dry	Hard Dry
26°C	3 hours	16 hours
32°C	2.5 hours	12 hours
36°C	2 hours	8 hours
40°C	1 hours	8 hours

- **Full Cure** : 7 Day
- **Painting Interval** : Min : 8 Hours, Max 6 Months
- **VOC** : Max. 429 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)

**SURFACE PREPARATION**

Previous epoxy coats : dry and free from contaminant and sufficiently roughened if necessary

**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**

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**INSTRUCTION FOR USE**

- 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)	1.5-2 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	10 hours	5 hours	3 hours	2 hours
Max interval	21 hours	10 hours	7 hours	7 hours

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.*