



MAKEPaints

**MAKEGUARD 616  
Shop Primer Epoxy**

**Base 616 : Curing Agent 6161**

**PRODUCT DESCRIPTION** Epoxy Shopprimer

**RECOMMENDED USE** As a shopprimer for protection of blast cleaned steel plate and other structural steel during storage and building period

**CHARACTERISTIC**

- Superior Resistant for chemical and oil.
- Excellent resistance to water and salt water.
- High build Performance properties.
- Fast drying, may be top coated in 3 hours at 25°C.
- Outstanding workability by airless spray.

**PHYSICAL DATA**

- **Colour** : light Grey, Red
- **Gloss level** : Flat.
- **Specific Gravity** : 1.22 ± 0.05 kg/litre
- **Volume Solid** : Approx 26 ± 1%
- **Dry Film Thickness** : 20 microns
- **Theoretical Coverage** : 13.6 sq.m/ltr -20 microns
- **Dry Time** :

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

- **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** : 6 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 : blast cleaned in situ to at least SSPC – SP10 and free from rust, scale, shop primer and any other contamination

**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** Can be top coated with all paint types, (alkyd, epoxy, coal tar epoxy, vinyl, chlorinate rubber or polyurethane, etc)

**INSTRUCTION FOR USE**

- Mixing ratio by volume ; Base; Hardener 4 : 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 :

	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 <sup>2</sup> /litre
Max DFT When Brushing	50 microns	12 m <sup>2</sup> /litre
Max DFT for closed film with airless spray	25 microns	24 m <sup>2</sup> /litre

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.*