



**Protective  
&  
Marine  
Coatings**

# MACROPOXY® 646-100 FAST CURE EPOXY

PART A  
PART B

B58-620  
B58V620

SERIES  
HARDENER

## PRODUCT INFORMATION

4.52

### RECOMMENDED SYSTEMS

|  | Dry Film Thickness / ct.      |                                  |
|--|-------------------------------|----------------------------------|
|  | Mils                          | (Microns)                        |
| <b>Immersion and atmospheric:</b>  |                               |                                  |
| <b>Steel:</b>  |                               |                                  |
| 2 cts. Macropoxy 646-100   | 5.0-10.0                      | (125-250)                        |
| <b>Concrete/Masonry, smooth:</b>   |                               |                                  |
| 2 cts. Macropoxy 646-100   | 5.0-10.0                      | (125-250)                        |
| <b>Concrete Block:</b>   |                               |                                  |
| 1 ct. Kem Cati-Coat HS Epoxy Filler/Sealer<br>as needed to fill voids and provide a continuous substrate.  | 10.0-20.0                     | (250-500)                        |
| 2 cts. Macropoxy 646-100   | 5.0-10.0                      | (125-250)                        |
| <b>Atmospheric:</b>  |                               |                                  |
| <b>*Steel:</b>   |                               |                                  |
| (Shop applied system, new construction, AWWA D102, can also be used at 3 mils (75 microns) dft when used as an intermediate coat as part of a multi-coat system) |                               |                                  |
| 1 ct. Macropoxy 646-100 Fast Cure Epoxy  | 3.0-6.0                       | (75-150)                         |
| 1-2 cts. of recommended topcoat  |                               |                                  |
| <b>Steel:</b>  |                               |                                  |
| 1 ct. Recoatable Epoxy Primer  | 4.0-6.0                       | (100-150)                        |
| 2 cts. Macropoxy 646-100   | 5.0-10.0                      | (125-250)                        |
| <b>Steel:</b>  |                               |                                  |
| 1 ct. Macropoxy 646-100  | 4.0-6.0                       |                                  |
| 1-2 cts. Acrolon 218 Polyurethane<br>or Hi-Solids Polyurethane<br>or SherThane 2K Urethane   | 3.0-6.0<br>3.0-5.0<br>2.0-4.0 | (75-150)<br>(75-125)<br>(50-100) |
| <b>Steel:</b>  |                               |                                  |
| 2 cts. Macropoxy 646-100   | 5.0-10.0                      | (125-250)                        |
| 1-2 cts. Tile-Clad HS Epoxy  | 2.5-4.0                       | (63-100)                         |
| <b>Steel:</b>  |                               |                                  |
| 1 ct. Zinc Clad II Plus  | 3.0-6.0                       | (75-150)                         |
| 1 ct. Macropoxy 646-100  | 5.0-10.0                      | (125-250)                        |
| 1-2 cts. Acrolon 218 Polyurethane  | 3.0-6.0                       | (75-150)                         |
| <b>Steel:</b>  |                               |                                  |
| 1 ct. Zinc Clad III HS<br>or Zinc Clad IV  | 3.0-5.0<br>3.0-5.0            | (75-125)<br>(75-125)             |
| 1 ct. Macropoxy 646-100  | 5.0-10.0                      | (125-250)                        |
| 1-2 cts. Hi-Solids Polyurethane-100  | 3.0-6.0                       | (75-150)                         |
| <b>Aluminum:</b>   |                               |                                  |
| 2 cts. Macropoxy 646-100   | 5.0-10.0                      | (125-250)                        |
| <b>Galvanizing:</b>  |                               |                                  |
| 2 cts. Macropoxy 646-100   | 5.0-10.0                      | (125-250)                        |

The systems listed above are representative of the product's use, other systems may be appropriate.

### DISCLAIMER

The information and recommendations set forth in this Product Data Sheet are based upon tests conducted by or on behalf of The Sherwin-Williams Company. Such information and recommendations set forth herein are subject to change and pertain to the product offered at the time of publication. Consult your Sherwin-Williams representative to obtain the most recent Product Data Information and Application Bulletin.

### SURFACE PREPARATION

Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.

Refer to product Application Bulletin for detailed surface preparation information.

Minimum recommended surface preparation:

|                    |   |  |  |
|--------------------|---|--|--|
| Iron & Steel       |   |  |  |
| Atmospheric:       | SSPC-SP2/3  |  |  |
| Immersion:         | SSPC-SP10/NACE 2, 2-3 mil (50-75 micron) profile            |  |  |
| Aluminum:          | SSPC-SP1  |  |  |
| Galvanizing:       | SSPC-SP1  |  |  |
| Concrete & Masonry |   |  |  |
| Atmospheric:       | SSPC-SP13/NACE 6, or ICRI No. 310.2, CSP 1-3                |  |  |
| Immersion:         | SSPC-SP13/NACE 6-4.3.1 or 4.3.2, or ICRI No. 310.2, CSP 1-3 |  |  |

### Surface Preparation Standards

| Condition of Surface | ISO 8501-1<br>BS7079:A1 | Swedish Std.<br>SIS055900 | SSPC  | NACE |
|----------------------|-------------------------|---------------------------|-------|------|
| White Metal          | Sa 3                    | Sa 3                      | SP 5  | 1    |
| Near White Metal     | Sa 2.5                  | Sa 2.5                    | SP 10 | 2    |
| Commercial Blast     | Sa 2                    | Sa 2                      | SP 6  | 3    |
| Brush-Off Blast      | Sa 1                    | Sa 1                      | SP 7  | 4    |
| Hand Tool Cleaning   | C St 2                  | C St 2                    | SP 2  | -    |
| Rusted               | D St 2                  | D St 2                    | SP 3  | -    |
| Pitted & Rusted      | D St 3                  | D St 3                    | SP 3  | -    |
| Power Tool Cleaning  | D St 3                  | D St 3                    | SP 3  | -    |

### TINTING

Tint Part A with Maxitones at 150% strength. Five minutes minimum mixing on a mechanical shaker is required for complete mixing of color.

Tinting is not recommended for immersion service.

### APPLICATION CONDITIONS

|                    |  |
|--------------------|--|
| Temperature:       | 40°F (4.5°C) minimum, 140°F (60°C) maximum<br>(air, surface, and material) |
| Relative humidity: | At least 5°F (2.8°C) above dew point<br>85% maximum                        |

Refer to product Application Bulletin for detailed application information.

### ORDERING INFORMATION

|            |   |
|------------|---|
| Packaging: |   |
| Part A:    | 1 gallon (3.78L) and 5 gallon (18.9L) containers          |
| Part B:    | 1 gallon (3.78L) and 5 gallon (18.9L) containers          |
| Weight:    | 13.24 ± 0.2 lb/gal ; 1.6 Kg/L<br>mixed, may vary by color |

### SAFETY PRECAUTIONS

Refer to the MSDS sheet before use.

Published technical data and instructions are subject to change without notice. Contact your Sherwin-Williams representative for additional technical data and instructions.

### WARRANTY

The Sherwin-Williams Company warrants our products to be free of manufacturing defects in accord with applicable Sherwin-Williams quality control procedures. Liability for products proven defective, if any, is limited to replacement of the defective product or the refund of the purchase price paid for the defective product as determined by Sherwin-Williams. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY SHERWIN-WILLIAMS, EXPRESSED OR IMPLIED, STATUTORY, BY OPERATION OF LAW OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.