



EPIGRIP M330

PRODUCT TECHNICAL DATA

FULL DESCRIPTION	: EPIGRIP M330 SEALERCOAT		
MATERIAL TYPE	: A 2-pack epoxy sealercoat		
RECOMMENDED USE	: As a sealercoat for use over zinc silicate and other types of zinc rich primers. : As a blast primer for use over stainless steel.		
RECOMMENDED APPLICATION METHODS	: Airless Spray		
COLOUR AVAILABILITY	: Red oxide		
FLASH POINT	: Base : 28°C		Additive : 24°C
% SOLIDS BY VOLUME	: 47 ± 2% (ASTM-D2697-91)		
V.O.C.	: 463 gms/litre determined practically in accordance with UK Regulations PG6/23 : 480 gms/litre calculated from formulation to satisfy EC Solvent Emissions Directive : 369 gms/kilo content by weight from formulation, to satisfy EC SED		
TYPICAL THICKNESS	Dry film thickness : 25 microns	Wet film thickness : 53 microns	Theoretical coverage : 18.8 m ² /ltr*
	* This figure makes no allowance for surface profile, uneven application, overspray or losses in containers and equipment. Film thickness will vary depending on actual use and specification.		
PRACTICAL APPLICATION	: Airless Spray		
RATES- microns per coat	: Dry	25*	
	: Wet	53	
AVERAGE DRYING TIMES	At 15°C	At 23°C	At 35°C
To touch	: 15 minutes	10 minutes	10 minutes
To recoat	: 5 hours	4 hours	2 hours
To handle	: 16 hours	16 hours	8 hours
	These figures are given as a guide only. Factors such as air movement and humidity must also be considered.		
RECOMMENDED THINNER	: Cleanser/Thinner No. 5		
RESISTANCE TO	: Moisture - Excellent Abrasion - Excellent	Weather - Excellent over zinc rich primers (subject to chalking)	
RECOMMENDED PRIMERS	: Epigrip J984 Zinc Rich Primer : Dox-Anode D5.		
RECOMMENDED TOPCOATS	: Indefinitely overcoatable with epoxy systems provided the surfaces to be coated have been suitably cleaned. Where a high degree of gloss and colour retention is required, overcoat with Resistex C137V2, Resistex C237, Resistex K651 within 7 days at a minimum dft of 50 microns or in the case of C750V2 overcoat within 4 days. These overcoating times refer to achievement of optimum adhesion at 23°C and will vary with temperature. : For overcoating with alkyd systems consult Sherwin-Williams for advice.		
POT LIFE	: 10 hours at 15°C	8 hours at 23°C	4 hours at 25°C
PACKAGE	: A two component material supplied in separate containers to be mixed prior to use.		
Pack Size	: 5 litre units when mixed		
Mixing Ratio	: 4 parts base to 1 part additive by volume		
Weight	: 1.30 kg/litre		
Shelf Life	: 2 years from date of manufacture or 'Use By' date where specified.		

SURFACE PREPARATION:

Ensure surfaces to be coated are clean, dry and free from all surface contamination.

APPLICATION EQUIPMENT:**Airless Spray**

Nozzle Size : 0.38mm (15 thou)
Fan Angle : 80°
Operating Pressure : 140kg/cm² (2000 psi)

The airless spray details given above are intended as a guide only. Details such as fluid hose length and diameter, paint temperature and job shape and size all have an effect on the spray tip and operating pressure chosen. However, the operating pressure should be the lowest possible consistent with satisfactory atomisation. As conditions will vary from job to job, it is the applicators' responsibility to ensure that the equipment in use has been set up to give the best results. If in doubt Sherwin-Williams should be consulted.

APPLICATION CONDITIONS AND OVERCOATING:

Epoxy paints should preferably be applied at temperatures in excess of 10°C. In conditions of high relative humidity, ie 80-85% good ventilation conditions are essential. Substrate temperature should be at least 3°C above the dew point and always above 0°C.

At application temperatures below 10°C, drying and curing times will be significantly extended, and spraying characteristics may be impaired.

Application at ambient air temperatures below 5°C is not recommended.

In order to achieve optimum water and chemical resistance, temperature needs to be maintained above 10°C during curing.

If it is desired to overcoat outside the times stated on the data sheet, please seek advice from Sherwin-Williams.

ADDITIONAL NOTES:

Drying times, curing times and pot life should be considered as a guide only.

The curing reaction of epoxies commences immediately the two components are mixed, and since the reaction is dependent on temperature, the curing time and pot life will be approximately halved by a 10°C increase in temperature and doubled by a 10°C decrease in temperature.

When M330 is used as a tie-coat or sealer coat over inorganic zinc silicate, the zinc silicate must be left for a minimum of 16 hours at 15°C and then checked for cure. Prior to overcoating, the inorganic zinc silicate primer must be fully cured.

Care must be taken to ensure that Epigrip M330 is not over-applied on to the zinc silicate otherwise there is a possibility of pinholing occurring.

Epoxy Coatings - Tropical Use

Epoxy paints at the time of mixing should not exceed a temperature of 35°C. At this temperature the pot life will be approximately halved. Use of these products outside of the pot life may result in inferior adhesion properties even if the materials appear fit for application. Thinning the mixed product will not alleviate this problem.

The maximum air and substrate temperature for application is 50°C providing conditions allow satisfactory application and film formation. If the air and substrate temperatures exceed 50°C and epoxy coatings are applied under these conditions, paint film defects such as dry spray, bubbling and pinholing etc. can occur within the coating.

Numerical values quoted for physical data may vary slightly from batch to batch.

HEALTH AND SAFETY:

Consult Product Health and Safety Data Sheet for information on safe storage, handling and application of this product.

Any person or company using the product without first making further enquiries as to the suitability of the product for the intended purpose does so at their own risk, and Sherwin-Williams can accept no liability for the performance of the product, or for any loss or damage arising out of such use.

The information detailed in this Data Sheet is liable to modification from time to time in the light of experience and of normal product development, and before using, customers are advised to check with Sherwin-Williams, quoting the reference number, to ensure that they possess the latest issue.