



# MACROPOXY® EG-1 RAPID PLUS

## FAST CURING EPOXY INTERMEDIATE COAT/MIO

Revised 03/2024 Issue 2

### PRODUCT DESCRIPTION

A 2-pack, high solids, fast curing epoxy coating pigmented with micaceous iron oxide (MIO).  
Low solvent content according to Protective Coatings Directive of German Paint Industry Association (VdL-RL 04).

- Low consumption per square meter
- Application at low temperatures
- Fast curing, with short overcoating time
- Direct to hot-dip galvanized steel, stainless steel and aluminium

### RECOMMENDED USE

Can be used as an intermediate coat in combination with Zinc Clad® or Macropoxy® high performance primers and Acrolon® topcoats.  
Also recommended as a primer for steel, hot-dip galvanized steel, stainless steel and aluminium.

### PRODUCT TECHNICAL DATA

**Volume Solids:** 66 ± 2% (MIO), 70 ± 2% (MIO-free) (ISO 3233-3)

**Weight Solids:** 80 ± 2% (MIO), 81 ± 2% (MIO-free)

**VOC:** 300 g/l determined practically in accordance with Protective Coatings Directive of German Paint Industry Association (VdL-RL 04).  
343 g/l calculated from formulation to satisfy EC Solvent Emissions Directive.  
229 g/kg calculated from formulation to satisfy EC Solvent Emissions Directive (UK).

**Colours:** MIO colour shades:  
Grey metallic approx. DB 702, material no. 687.12;  
Grey metallic approx. DB 703, material no. 687.13;  
Green metallic approx. DB 601, material no. 687.14;  
Black  
MIO-free colour shades:  
RAL 9002 Grey white  
Slight colour deviations are possible due to raw material characteristics..

**Flash Point:** Base: 23°C, Hardener: 34°C

**Cleaner/Thinner:** Cleaner 26 (for cleaning).  
Thinner EG for thinning with max. 5% to adapt the viscosity.  
Thinning will affect VOC compliance, sag tolerance and dry film thicknesses.

**Pack Size:** A two component material supplied in separate containers to be mixed prior to use:  
28.5 kg (19 litre) units when mixed.  
Volume will vary with colours and density.

**Mixing Ratio:** 94.7 parts base to 5.3 parts hardener by weight  
11.5 parts base to 1 part hardener by volume

**Density:** 1.5 kg/l (MIO)  
1.4 kg/l (MIO-free)  
(may vary with colours)

**Shelf Life:** 2 years from date of manufacture, stored in originally sealed containers in a cool and dry environment

**Recommended Application Methods:**  
Airless Spray, Conventional Spray, Brush, Roller

#### Typical Thickness:

Recommended Spreading Rate Per Coat		
MIO Shade	Typical	Maximum Sag
Dry	80 µm	240 µm
Wet	121 µm	364 µm
Theoretical Consumption*	0.182 kg/m <sup>2</sup> 0.121 l/m <sup>2</sup>	
Theoretical Coverage*	5.70 m <sup>2</sup> /kg 8.25 m <sup>2</sup> /l	
MIO-Free Shade	Typical	Maximum Sag
Dry	80 µm	240 µm
Wet	114 µm	343 µm
Theoretical Consumption*	0.160 kg/m <sup>2</sup> 0.114 l/m <sup>2</sup>	
Theoretical Coverage*	6.25 m <sup>2</sup> /kg 8.75 m <sup>2</sup> /l	

\* 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.

#### Pot Life:

+ 10°C	+ 20°C	+ 30°C
8 hours	5 hours	2 hours

Pot life is dependent on temperature and volume.



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### AVERAGE DRYING TIMES

#### For 80 µm Dry Film Thickness:

	0°C	+ 5°C	+ 10°C	+ 20°C
Dry to handle (Drying Stage 6*)	12 hours	6 hours	5 hours	2.5 hours
To Recoat	12 hours	6 hours	5 hours	2.5 hours

\*ISO 9117

Maximum recoat time is 1 year. Prior to further applications all contamination must be removed. In the case of extended recoating times consult Sherwin Williams customer service.

**Final cure:** 1-2 weeks, depending on film thickness and temperature.

These figures are given as a guide only. Factors such as air movement, film thickness and humidity must also be considered.

### APPROVALS & ENDORSEMENTS

- Approved according to German standard 'TL KOR-Stahlbauten, Blatt 97'
- Certificates C5 high and very high according to ISO 12944 are available

### SURFACE PREPARATION

Ensure surfaces to be coated are clean, dry and free from all surface contamination such as oil, grease, dirt and corrosion products to achieve satisfactory adhesion.

For contaminated and weathered surfaces e.g. primed areas we recommend to clean with Cleaner Wash.

**Steel surfaces** shall be blast-cleaned to Sa 2½ according to ISO 8501-1 (ISO 12944-4)

**Hot-dip galvanized surfaces, stainless steel and aluminium** shall be prepared by degreasing or, in case of permanent immersion or condensation, sweep blasting according to ISO 12944-4 with a non-ferrous blasting abrasive..

### MIXING

Stir component A very thoroughly using a mechanical paint mixer (start slowly, then increase up to approx. 300 rpm). Add component B carefully and mix both components very thoroughly (including sides and bottom of the container). Mix for at least 3 minutes until a homogeneous mixture is achieved. We recommend to fill the mixed material into a clean container and mix again shortly as described above to avoid incorrect mixing. During mixing and handling of the materials always wear protective goggles, suitable gloves and other protective clothing.

### APPLICATION CONDITIONS

Substrate temperature shall be above - 10°C and at least 3°C above the dew point. The surface must be dry and free from ice.

Material temperature shall be above 0°C.

Relative air humidity shall be below 85%.

### APPLICATION EQUIPMENT

The following is a guide. Changes in pressures and tip sizes may be needed for satisfactory application characteristics. Always purge spray equipment before use with listed cleaner. Any reduction must be compliant with existing VOC regulations and compatible with the existing environmental and application conditions.

#### Airless Spray

Unit: Efficient airless equipment

Tip Size: 0.38 – 0.53 mm (0.015 – 0.021 inch)

Fan Angle: 40° - 80°

Operating Pressure: min. 180 bar (2600 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 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 consult Sherwin-Williams customer service.

#### Conventional Spray

Atomising Pressure: 3 - 5 bar (43 - 73 psi)

Tip Size: 1.5 – 2.5 mm (0.06 – 0.10 inch)

#### Brush and Roller

The coating is suitable for brush and roller application. Application of more than one coat may be necessary to give equivalent dry film thickness to a single spray applied coat.



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### RECOMMENDED SYSTEMS

#### Steel

#### Intermediate coat

Compatible with a wide range of Sherwin-Williams Macropoxy® and Zinc Clad® epoxy primers.

#### Suitable topcoats

Versatile to overcoat with 1- or 2-pack epoxy and polyurethane coatings of Sherwin-Williams. Provided the surface to be coated is clean, dry and free from contamination.

#### Hot-dip galvanized steel, stainless steel and aluminium

1 x Macropoxy® EG-1 Rapid Plus  
1 x Acrolon® topcoat

### ADDITIONAL NOTES

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

#### Epoxy Coatings - Tropical Use:

Epoxy coatings at the time of mixing should not exceed a temperature of 35°C. 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. If the air and substrate temperatures exceed 40°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.

#### Chemical resistance:

Resistant to weathering, water, seawater, smoke, de-icing salts, acid and alkali vapours, oils, grease and short-term exposure to fuels and solvents.

#### Temperature resistance:

Dry heat up to + 150°C, short term up to + 200°C.  
Increased humid ambient temperature up to approx. + 50°C.  
In case of higher temperatures consult Sherwin-Williams customer service.

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

### HEALTH & SAFETY

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

### WARRANTY

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