SHERWIN-WILLIAMS
Protective & Marine Coatings

Equinor TR0042 ver.8
CSDS - Coating Systems Data Sheets

Coating System Reference	TR0042 v.8 System1A
Surface Cleanliness	Sa2½ according to ISO 8501-1
Surface Roughness	Grade Medium G (50µm to 85µm, R_{y5}) according to ISO 8503

Product Name	Product Type	DFT (µm)			Volume Solid (%)	Theoretical m² / ltr @ spec DFT	Mixing Thinner	Thinning %	Mix Ratio by Volume (Base:Additive)
		min	spec	max					
Zinc Clad II/EU	Inorganic Zinc	60	60	125	62	7.75	No.4	≤ 5	9.9Kgs : 3.43 litres
Macropoxy 646	Epoxy (Mist coat)	n/a	n/a	n/a	72	n/a	No.50	≤ 10	1:1
Macropoxy 646	Epoxy	100	140	280	72	5.9	No.50	≤ 5	1:1
Sherloxane 800	Polysiloxane	100	100	150	90	9	NR	NR	4:1
		TOTAL	300	555					

Product Name	5°C			10°C			23°C			40°C		
	Overcoating Time		Full Cure Time[1]	Overcoating Time		Full Cure Time[1]	Overcoating Time		Full Cure Time[1]	Overcoating Time		Full Cure Time[1]
	min	max		min	max		min	max		min	max	
Zinc Clad II/EU	[2]	Unlimited [3]	14 days [4]	48 hr [2]	Unlimited [3]	14 days [4]	18 hr [2]	Unlimited [3]	14 days [4]	18 hr [2]	Unlimited [3]	14 days [4]
Macropoxy 646	48hrs	1 year	10 days	24hrs	1 year	8 days	8hrs	1 year	7 days	4.5hrs	1 year	4 days
Sherloxane 800	16hrs	90d	8d	10 hrs	90d	8d	3hrs	90d	7d	1.5hrs	90d	3d

Notes

1. Overcoating and Full Cure Times are based on a Relative Humidity level of 50%.
2. Minimum Overcoating and Full Cure Time to be confirmed by carrying out 50 MEK double rubs. No zinc or only slight traces should be visible. Coin hardness test can also be used.
3. Maximum Overcoating time is "Unlimited" providing any salting on the zinc surface due to weathering exposure is fully removed prior to topcoating.
4. The time stated refers to cure-to-service. For handling times please see individual Product Technical Data Sheet.

NR Not Recommended

SHERWIN-WILLIAMS
Protective & Marine Coatings

Equinor TR0042 ver.8
CSDS - Coating Systems Data Sheets

Coating System Reference	TR0042 v.8 System 1B
Surface Cleanliness	Sa2½ according to ISO 8501-1
Surface Roughness	Grade Medium G (50µm to 85µm, R_{y5}) according to ISO 8503

Product Name	Product Type	DFT (µm)			Volume Solid (%)	Theoretical m² / ltr @ spec DFT	Mixing Thinner	Thinning %	Mix Ratio by Volume (Base:Additive)
		min	spec	max					
Zinc Clad IV	Organic Zinc	60	60	125	68	7.75	No.3	≤ 5	8:1
Macropoxy 646	Epoxy	100	120	250	72	5.9	No.50	≤ 5	1:1
Sherloxane 800	Polysiloxane	100	100	150	90	6	NR	NR	4:1
		TOTAL	280	525					

Product Name	5°C			10°C			23°C			40°C		
	Overcoating Time		Full Cure Time	Overcoating Time		Full Cure Time	Overcoating Time		Full Cure Time	Overcoating Time		Full Cure Time
	min	max		min	max		min	max		min	max	
Zinc Clad IV	6hrs	Unlimited	10d	5hrs	Unlimited	10d	4hrs	Unlimited	10d	2hrs	Unlimited	7d
Macropoxy 646	48hrs	1 year	10 days	24hrs	1 year	8 days	8hrs	1 year	7 days	4.5hrs	1 year	4 days
Sherloxane 800	16hrs	90d	8d	10hrs	90d	8d	3hrs	90d	7d	1.5hrs	90d	3d

Notes

NR Not Recommended

SHERWIN-WILLIAMS
Protective & Marine Coatings

Statoil TR0042 ver.7
CSDS - Coating Systems Data Sheets

Coating System Reference	TR0042 v.8 System 1F
Surface Cleanliness	Sa2½ according to ISO 8501-1
Surface Roughness	Grade Medium G (50µm to 85µm, R_{y5}) according to ISO 8503

Product Name	Product Type	DFT (µm)			Volume Solid (%)	Theoretical m² / ltr @ spec DFT	Mixing Thinner	Thinning %	Mix Ratio by Volume (Base:Additive)
		min	spec	max					
Duraplate 6000	Glass Flake Epoxy	300	500	1000	100	1.97	NR	NR	2:1
Duraplate 6000	Glass Flake Epoxy	300	500	1000	100	1.97	NR	NR	2:1
		TOTAL	1000	2000					

Product Name	5°C			10°C			23°C			40°C		
	Overcoating Time		Full Cure Time	Overcoating Time		Full Cure Time	Overcoating Time		Full Cure Time	Overcoating Time		Full Cure Time
	min	max		min	max		min	max		min	max	
Duraplate 6000	7hrs	28 days	10hrs	5hrs	28 days	10hrs	5hrs	28 days	10hrs	4hrs	28 days	10hrs
Duraplate 6000	7hrs	28 days	10hrs	5hrs	28 days	10hrs	5hrs	28 days	10hrs	4hrs	28 days	10hrs

Notes

NR Not Recommended

SHERWIN-WILLIAMS
Protective & Marine Coatings

Equinor TR0042 ver.8
CSDS - Coating Systems Data Sheets

Coating System Reference	TR0042 v.8 System 2A(i) - Thermally Sprayed Aluminium at 200µm ≤ 80°C
Surface Cleanliness	Sa2½ according to ISO 8501-1
Surface Roughness	Grade Medium G (50µm to 80µm, R_{y5}) according to ISO 8503

Product Name	Product Type	DFT (µm)			Volume Solid (%)	Theoretical m² / ltr @ spec DFT	Mixing Thinner	Thinning %	Mix Ratio by Volume (Base:Additive)
		min	spec	max					
Macropoxy 646	Epoxy	Sealercoat			72	5.9	No.50	≤ 20	1:1

Product Name	5°C			10°C			23°C			40°C		
	Overcoating Time		Full Cure Time	Overcoating Time		Full Cure Time	Overcoating Time		Full Cure Time	Overcoating Time		Full Cure Time
	min	max		min	max		min	max		min	max	
Macropoxy 646	48hrs	1 year	10 days	24hrs	1 year	8 days	8hrs	1 year	7 days	4.5hrs	1 year	4 days
Notes												

Coating System Reference	TR0042 v.8 System 2A(ii) - Thermally Sprayed Aluminium at 200µm >80°C - ≤ 600°C
Surface Cleanliness	Sa2½ according to ISO 8501-1
Surface Roughness	Grade Medium G (50µm to 80µm, R_{y5}) according to ISO 8503

Product Name	Product Type	DFT (µm)			Volume Solid (%)	Theoretical m² / ltr @ spec DFT	Mixing Thinner	Thinning %	Mix Ratio by Volume (Base:Additive)
		min	spec	max					
Heat- Flex M505	Silicone	Sealercoat			31	N/A	No.2	NR	N/A

Product Name	5°C			10°C			23°C			40°C		
	Overcoating Time		Full Cure Time	Overcoating Time		Full Cure Time	Overcoating Time		Full Cure Time	Overcoating Time		Full Cure Time
	min	max		min	max		min	max		min	max	
Heat- Flex M505	12 hr	Unlimited	[1]	8 hr	Unlimited	[1]	4 hr	Unlimited	[1]	2.5 hr	Unlimited	[1]

Notes

1. To achieve full cure, Leighs M505 must be post-cured by gradually elevating the temperature to a minimum of 205°C and maintaining this temperature for 2 hours.

NR Not Required

N/A Not Applicable

SHERWIN-WILLIAMS
Protective & Marine Coatings

Equinor TR0042 ver.8
CSDS - Coating Systems Data Sheets

Coating System Reference	TR0042 v.8 System 2B
Surface Cleanliness	Applied to TSZ
Surface Roughness	n/a

Product Name	Product Type	DFT (µm)			Volume Solid (%)	Theoretical m² / ltr @ spec DFT	Mixing Thinner	Thinning %	Mix Ratio by Volume (Base:Additive)
		min	spec	max					
Macropoxy 646	Epoxy (mist coat)	n/a	n/a	n/a	72	NA	No.50	≤ 10	1:1
Macropoxy 646	Epoxy	100	100	250	72	7.1	No.50	≤ 5	1:1
Sherloxane 800	Polysiloxane	100	100	150	90	9	NR	NR	4:1
		TOTAL	200	400					

Product Name	5°C			10°C			23°C			40°C		
	Overcoating Time		Full Cure Time	Overcoating Time		Full Cure Time	Overcoating Time		Full Cure Time	Overcoating Time		Full Cure Time
	min	max		min	max		min	max		min	max	
Macropoxy 646	48hrs	1 year	10 days	24hrs	1 year	8 days	8hrs	1 year	7 days	4.5hrs	1 year	4 days
Macropoxy 646	48hrs	1 year	10 days	24hrs	1 year	8 days	8hrs	1 year	7 days	4.5hrs	1 year	4 days
Sherloxane 800	16hrs	90d	8d	10 hrs	90d	8d	3hrs	90d	7d	1.5hrs	90d	3d

Notes

NR Not Recommended

Coating System Reference	TR0042 v.8 System 3A
Surface Cleanliness	Sa2½ according to ISO 8501-1
Surface Roughness	Grade Medium G (50µm to 80µm, R_{y5}) according to ISO 8503

Product Name	Product Type	DFT (µm)			Volume Solid (%)	Theoretical m² / ltr @ spec DFT	Mixing Thinner	Thinning %	Mix Ratio by Volume (Base:Additive)
		min	spec	max					
Dura-plate UHS	Epoxy	250	300	600	98	3.3	No.13	DNT	4:1
Dura-plate UHS	Epoxy	250	300	600	98	3.3	No.13	DNT	4:1
		TOTAL	600	1200					

Product Name	5°C			10°C			23°C			40°C		
	Overcoating Time		Full Cure Time	Overcoating Time		Full Cure Time ²	Overcoating Time		Full Cure Time ²	Overcoating Time		Full Cure Time ²
	min	max		min	max		min	max		min	max	
Dura-plate UHS	N/A			48 hr	21 days	10 days	14 hr	14 days	4 days	8 hr	14 days	24 hr
Dura-plate UHS	N/A			48 hr	21 days	10 days	14 hr	14 days	4 days	8 hr	14 days	24 hr

Notes

1. Dura-plate USH is NSF approved to Standard 61 for potable water (tanks of 1000 gallons (USA) or greater and pipes of 30" diameter or greater.)
2. The time stated refers to cure-to-service. For handling times please see individual Product Technical Data Sheet.

N/A Not Applicable

DNT Do Not Thin

Coating System Reference	TR0042 v.8 System 3B
Surface Cleanliness	Sa2½ according to ISO 8501-1
Surface Roughness	Grade Medium G (50µm to 80µm, R_{y5}) according to ISO 8503

Product Name	Product Type	DFT (µm)			Volume Solid (%)	Theoretical m² / ltr @ spec DFT	Mixing Thinner	Thinning %	Mix Ratio by Volume (Base:Additive)
		min	spec	max					
Dura-plate 301K	Epoxy	100	160	300	97	6.1	TH03	DNT	3.3:1
Dura-plate 301K	Epoxy	100	160	300	97	6.1	TH03	DNT	3.3:1
		TOTAL	320	600					

Product Name	15°C			25°C			40°C		
	Overcoating Time		Full Cure Time ²	Overcoating Time		Full Cure Time ²	Overcoating Time		Full Cure Time ²
	min	max		min	max		min	max	
Dura-plate 301K	24 hr	15 days	10 days	16 hr	8 days	7 days	8 hr	5 days	4 days
Dura-plate 301K	24 hr	15 days	10 days	16 hr	8 days	7 days	8 hr	5 days	4 days

Product Name	Product Type	DFT (µm)			Volume Solid (%)	Theoretical m² / ltr @ spec DFT	Mixing Thinner	Thinning %	Mix Ratio by Volume (Base:Additive)
		min	spec	max					
Dura-plate 301W	Epoxy	100	160	300	97	6.1	No.3	DNT	7:3
Dura-plate 301W	Epoxy	100	160	300	97	6.1	No.3	DNT	7:3
		TOTAL	320	600					

Product Name	0°C			10°C			20°C		
	Overcoating Time		Full Cure Time ²	Overcoating Time		Full Cure Time ²	Overcoating Time		Full Cure Time ²
	min	max		min	max		min	max	
Dura-plate 301W	48 hr	6 month	7 days	24 hr	6 month	5 days	8 hr	6 month	3 days
Dura-plate 301W	48 hr	6 month	7 days	24 hr	6 month	5 days	8 hr	6 month	3 days

Notes

1. Dura-plate 301K is for fair to warm climate use (typically >15°C). Dura-plate 301W is for cold to mild climate use (typically 0°C to 15°C).
2. The time stated refers to cure-to-service. For handling times please see individual Product Technical Data Sheet.

DNT Do Not Thin

Coating System Reference	TR0042 v.8 System 3C
Surface Cleanliness	Sa2½ according to ISO 8501-1
Surface Roughness	Grade Medium G (50µm to 80µm, R_{y5}) according to ISO 8503

Product Name	Product Type	DFT (µm)			Volume Solid (%)	Theoretical m² / ltr @ spec DFT	Mixing Thinner	Thinning %	Mix Ratio by Volume (Base:Additive)
		min	spec	max					
Dura-plate 301K	Epoxy	100	160	300	97	6.1	No.3	DNT	3.3:1
Dura-plate 301K	Epoxy	100	160	300	97	6.1	No.3	DNT	3.3:1
		TOTAL	320	600					

Product Name	15°C			25°C			40°C		
	Overcoating Time		Full Cure Time ²	Overcoating Time		Full Cure Time ²	Overcoating Time		Full Cure Time ²
	min	max		min	max		min	max	
Dura-plate 301K	24 hr	15 days	10 days	16 hr	8 days	7 days	8 hr	5 days	4 days
Dura-plate 301K	24 hr	15 days	10 days	16 hr	8 days	7 days	8 hr	5 days	4 days

Product Name	Product Type	DFT (µm)			Volume Solid (%)	Theoretical m² / ltr @ spec DFT	Mixing Thinner	Thinning %	Mix Ratio by Volume (Base:Additive)
		min	spec	max					
Dura-plate 301W	Epoxy	100	160	300	97	6.1	No.3	DNT	7:3
Dura-plate 301W	Epoxy	100	160	300	97	6.1	No.3	DNT	7:3
		TOTAL	320	600					

Product Name	0°C			10°C			20°C		
	Overcoating Time		Full Cure Time ²	Overcoating Time		Full Cure Time ²	Overcoating Time		Full Cure Time ²
	min	max		min	max		min	max	
Dura-plate 301W	48 hr	6 month	7 days	24 hr	6 month	5 days	8 hr	6 month	3 days
Dura-plate 301W	48 hr	6 month	7 days	24 hr	6 month	5 days	8 hr	6 month	3 days

Notes

1. Dura-plate 301K is for fair to warm climate use (typically >15°C). Dura-plate 301W is for cold to mild climate use (typically 0°C to 15°C).
2. The time stated refers to cure-to-service. For handling times please see individual Product Technical Data Sheet.

DNT Do Not Thin

Coating System Reference	TR0042 v.8 System 3D
Surface Cleanliness	Sa2½ according to ISO 8501-1
Surface Roughness	Grade Medium G (50µm to 80µm, R_{y5}) according to ISO 8503

Product Name	Product Type	DFT (µm)			Volume Solid (%)	Theoretical m² / ltr @ spec DFT	Mixing Thinner	Thinning %	Mix Ratio by Volume (Base:Additive)
		min	spec	max					
Epo-Phen FF	Epoxy Phenolic	125	175	225	70	4.0	No.50	≤ 15	4:1
Epo-Phen FF	Epoxy Phenolic	125	175	225	70	4.0	No.50	≤ 15	4:1
		TOTAL	350	450					

Product Name	5°C			10°C			23°C			40°C		
	Overcoating Time		Full Cure Time	Overcoating Time		Full Cure Time [1]	Overcoating Time		Full Cure Time [1]	Overcoating Time		Full Cure Time [1]
	min	max		min	max		min	max		min	max	
Epo-Phen FF	N/A			48 hr	30 days	21 days	16 hr	30 days	7 days	6 hr	30 days	3 days
Epo-Phen FF	N/A			48 hr	30 days	21 days	16 hr	30 days	7 days	6 hr	30 days	3 days

Notes

1. The time stated refers to cure-to-service. For handling times please see individual Product Technical Data Sheet.

NR Not Applicable

Coating System Reference	TR0042 v.8 System 3E
Surface Cleanliness	Sa2½ according to ISO 8501-1
Surface Roughness	Grade Medium G (50µm to 80µm, R_{y5}) according to ISO 8503

Product Name	Product Type	DFT (µm)			Volume Solid (%)	Theoretical m² / ltr @ spec DFT	Mixing Thinner	Thinning %	Mix Ratio by Volume (Base:Additive)
		min	spec	max					
Epo-Phen FF	Epoxy Phenolic	125	175	225	70	4.0	No.50	≤ 15	4:1
Epo-Phen FF	Epoxy Phenolic	125	175	225	70	4.0	No.50	≤ 15	4:1
		TOTAL	350	450					

Product Name	5°C			10°C			23°C			40°C		
	Overcoating Time		Full Cure Time	Overcoating Time		Full Cure Time [1]	Overcoating Time		Full Cure Time [1]	Overcoating Time		Full Cure Time [1]
	min	max		min	max		min	max		min	max	
Epo-Phen FF	N/A			48 hr	30 days	21 days	16 hr	30 days	7 days	6 hr	30 days	3 days
Epo-Phen FF	N/A			48 hr	30 days	21 days	16 hr	30 days	7 days	6 hr	30 days	3 days

Notes

1. The time stated refers to cure-to-service. For handling times please see individual Product Technical Data Sheet.

N/A Not Applicable

Coating System Reference	TR0042 v.8 System 3F
Surface Cleanliness	Sa2½ according to ISO 8501-1
Surface Roughness	Grade Medium G (50µm to 80µm, R_{y5}) according to ISO 8503

Product Name	Product Type	DFT (µm)			Volume Solid (%)	Theoretical m² / ltr @ spec DFT	Mixing Thinner	Thinning %	Mix Ratio by Volume (Base:Additive)
		min	spec	max					
Nova-plate 325	Epoxy Novolac	500	500	1000	98	2.0	No.13	DNT	2:1
		TOTAL	500	1000					

Product Name	5°C			10°C			23°C			40°C		
	Overcoating Time		Full Cure Time	Overcoating Time		Full Cure Time ²	Overcoating Time		Full Cure Time ²	Overcoating Time		Full Cure Time ²
	min	max		min	max		min	max		min	max	
Nova-plate 325	N/A			6.5 hr	21 days	14 days	2.5 hr	21 days	24 hr	1 hr	9 days	24 hr

Notes

1. Nova-plate 325 is to be applied using plural component airless spray equipment.
2. The time stated refers to cure-to-service. For handling times please see individual Product Technical Data Sheet.

N/A Not Applicable

DNT Do Not Thin

Coating System Reference	TR0042 v.8 System 3G
Surface Cleanliness	Sa2½ according to ISO 8501-1
Surface Roughness	Grade Medium G (50µm to 80µm, R_{y5}) according to ISO 8503

Product Name	Product Type	DFT (µm)			Volume Solid (%)	Theoretical m² / ltr @ spec DFT	Mixing Thinner	Thinning %	Mix Ratio by Volume (Base:Additive)
		min	spec	max					
Zinc Clad II/EU	Inorganic Zinc Silicate	50	75	100	62	8.3	No.2	≤ 10	14.1 ltr : 33.1 kg
		TOTAL	75	100					

Product Name	5°C			10°C [1]			23°C [1]			40°C [1]		
	Overcoating Time		Full Cure Time [4]	Overcoating Time		Full Cure Time [4]	Overcoating Time		Full Cure Time [4]	Overcoating Time		Full Cure Time [4]
	min	max		min	max		min	max		min	max	
Zinc Clad II/EU	[2]	Unlimited [3]	14 days [2]	48 hr [2]	Unlimited [3]	14 days [2]	18 hr [2]	Unlimited [3]	14 days [2]	18 hr [2]	Unlimited [3]	14 days [2]

Notes

1. Overcoating and Full Cure Times are based on a Relative Humidity level of 50%.
2. Minimum Overcoating and Full Cure Time to be confirmed by carrying out 50 MEK double rubs. No zinc or only slight traces should be visible. Coin hardness test can also be used.
3. Maximum Overcoating time is "Unlimited" providing any salting on the zinc surface due to weathering exposure is fully removed prior to topcoating.
4. The time stated refers to cure-to-service. For handling times please see individual Product Technical Data Sheet.

SHERWIN-WILLIAMS
Protective & Marine Coatings

Equinor TR0042 ver.8
CSDS - Coating Systems Data Sheets

Coating System Reference	TR0042 v.8 System 4A Exposed
Surface Cleanliness	Sa2½ according to ISO 8501-1
Surface Roughness	Grade Medium G (50µm to 80µm, R_{y5}) according to ISO 8503

Product Name	Product Type	DFT (µm)			Volume Solid (%)	Theoretical m² / ltr @ spec DFT	Mixing Thinner	Thinning %	Mix Ratio by Volume (Base:Additive)
		min	spec	max					
Macropoxy L425	Epoxy	50	75	125	60	8.0	No.5	NR	4:1
Epidek M153	Epoxy Anti-slip	2000	2925	3500	95	0.3	No.5	NR	3.7:2.4
Epidek M153D Heavy	Aggregate	1.4 - 2.8 mm particle size			N/A	8.5 kg / m²	N/A	N/A	N/A
		TOTAL	3000	3625					

Product Name	5°C			10°C			23°C			40°C		
	Overcoating Time		Full Cure Time [1]	Overcoating Time		Full Cure Time [1]	Overcoating Time		Full Cure Time [1]	Overcoating Time		Full Cure Time [1]
	min	max		min	max		min	max		min	max	
Macropoxy L425	10 hr	Unlimited	7 days	7 hr	Unlimited	4 days	4 hr	Unlimited	3 days	2.5 hr	Unlimited	2 days
Epidek M153	8 hr	Unlimited	7 days	7 hr	Unlimited	4 days	5 hr	Unlimited	3 days	2 hr	Unlimited	2 days
Epidek M153D Heavy	N/A			N/A			N/A			N/A		

Notes

1. The time stated refers to cure-to-service. For handling times please see individual Product Technical Data Sheet.

NR Not Required

N/A Not Applicable

Coating System Reference	TR0042 v.8 System 4B Unexposed
Surface Cleanliness	Sa2½ according to ISO 8501-1
Surface Roughness	Grade Medium G (50µm to 80µm, R_{y5}) according to ISO 8503

Product Name	**Product Type**	**DFT (µm)**			**Volume Solid (%)**	**Theoretical m² / ltr @ spec DFT**	**Mixing Thinner**	**Thinning %**	**Mix Ratio by Volume (Base:Additive)**
		min	**spec**	**max**					
Macropoxy L425	Epoxy	50	75	125	60	8.0	No.5	NR	4:1
Epidek M153	Epoxy Anti-slip	2000	1725	3500	95	0.6	No.5	NR	3.7:2.4
Epidek M153D Heavy	Aggregate	1.4 - 2.8 mm particle size			N/A	8.5 kg / m²	N/A	N/A	N/A
		TOTAL	1800	3625					

Product Name	**5°C**			**10°C**			**23°C**			**40°C**		
	Overcoating Time		**Full Cure Time [1]**	**Overcoating Time**		**Full Cure Time [1]**	**Overcoating Time**		**Full Cure Time [1]**	**Overcoating Time**		**Full Cure Time [1]**
	min	**max**		**min**	**max**		**min**	**max**		**min**	**max**	
Macropoxy L425	10 hr	Unlimited	7 days	7 hr	Unlimited	4 days	4 hr	Unlimited	3 days	2.5 hr	Unlimited	2 days
Epidek M153	8 hr	Unlimited	7 days	7 hr	Unlimited	4 days	5 hr	Unlimited	3 days	2 hr	Unlimited	2 days
Epidek M153D Heavy	N/A			N/A			N/A			N/A		

Notes

1. The time stated refers to cure-to-service. For handling times please see individual Product Technical Data Sheet.

NR Not Required

N/A Not Applicable

Coating System Reference	TR0042 v.8 System 5A - Carbon steel to receive Epoxy Passive Fire Protection [3]
Surface Cleanliness	Sa2½ according to ISO 8501-1
Surface Roughness	Grade Medium G (50µm to 80µm, R_{y5}) according to ISO 8503

Product Name	Product Type	DFT (µm)			Volume Solid (%)	Theoretical m² / ltr @ spec DFT	Mixing Thinner	Thinning %	Mix Ratio by Volume (Base:Additive)
		min	spec	max					
Zinc Clad IV	Epoxy Zinc Rich	50	75	100	68	9.1	No.13	≤ 5	8:1
Macropoxy L574	Epoxy	25	25	35	29	11.6	No.5	NR	4:1
Epoxy based PFP									
Macropoxy 646	Epoxy	50	50	100	72	14.2	No.50	≤ 10	1:1
Sherloxane 800	Polysiloxane	100	100	150	90	9	NR	NR	4:1
		TOTAL							

Product Name	5°C			10°C			23°C			40°C		
	Overcoating Time		Full Cure Time [2]	Overcoating Time		Full Cure Time [2]	Overcoating Time		Full Cure Time [2]	Overcoating Time		Full Cure Time [2]
	min	max		min	max		min	max		min	max	
Zinc Clad IV	6 hr	Unlimited [1]	10 days	5 hr	Unlimited [1]	10 days	4 hr	Unlimited [1]	10 days	2 hr	Unlimited [1]	7-10 days
Macropoxy L574	6 hr	Unlimited	1 hr	5 hr	Unlimited	45 mins	3 hr	Unlimited	20 mins	1.5 hr	Unlimited	10 mins

Notes

1. Maximum Overcoating time is "Unlimited" providing any salting on the zinc surface due to weathering exposure is fully removed prior to topcoating.
2. The time stated refers to cure-to-service. For handling times please see individual Product Technical Data Sheet.
3. A tie coat of Macropoxy 646 should be applied at 50 microns when applying a topcoat of Sherloxane 800

NR Not Required

Coating System Reference	TR0042 v.8 System 6A- Uninsulated stainless steel
Surface Cleanliness	Sa2½ according to ISO 8501-1
Surface Roughness	Grade Medium G (25µm to 85µm, R_{y5}) according to ISO 8503

Product Name	Product Type	DFT (µm)			Volume Solid (%)	Theoretical m² / ltr @ spec DFT	Mixing Thinner	Thinning %	Mix Ratio by Volume (Base:Additive)
		min	spec	max					
Macropoxy L425	Epoxy	50	50	100	60	12.0	No.5	NR	4:1
Macropoxy 646	Epoxy	100	100	300	72	7.2	No.50	NR	1:1
Sherloxane 800	Polysiloxane	100	100	150	90	9	NR	NR	4:1
		TOTAL	250	550					

Product Name	5°C			10°C			23°C			40°C		
	Overcoating Time		Full Cure Time	Overcoating Time		Full Cure Time	Overcoating Time		Full Cure Time	Overcoating Time		Full Cure Time
	min	max		min	max		min	max		min	max	
Macropoxy L425	10 hr	Unlimited	7 days	7 hr	Unlimited	4 days	4 hr	Unlimited	3 days	2.5 hr	Unlimited	2 days
Macropoxy 646	48hrs	1 year	10 days	24hrs	1 year	8 days	8hrs	1 year	7 days	4.5hrs	1 year	1 day
Sherloxane 800	16hrs	90d	8d	10 hrs	90d	8d	3hrs	90d	7d	1.5hrs	90d	3d

N/A Not Applicable

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Coating System Reference	TR0042 v.8 System 6B - Hot Dipped galvanised steel
Surface Cleanliness	Cleanining with Alkaline detergent followed by hosing with fresh water and sweep blast
Surface Roughness	n/a

Product Name	**Product Type**	**DFT (µm)**			**Volume Solid (%)**	**Theoretical m² / ltr @ spec DFT**	**Mixing Thinner**	**Thinning %**	**Mix Ratio by Volume (Base:Additive)**
		min	**spec**	**max**					
Macropoxy L425	Epoxy	50	50	100	60	12.0	No.5	≤ 5	4:1
Macropoxy 646	Epoxy	100	100	300	72	7.2	No.50	≤ 5	1:1
Sherloxane 800	Polysiloxane	100	100	150	90	9	NR	NR	4:1
		TOTAL	250	550					

Product Name	**5°C**			**10°C**			**23°C**			**40°C**		
	Overcoating Time		**Full Cure Time**	**Overcoating Time**		**Full Cure Time**	**Overcoating Time**		**Full Cure Time**	**Overcoating Time**		**Full Cure Time**
	min	**max**		**min**	**max**		**min**	**max**		**min**	**max**	
Macropoxy L425	10 hr	Unlimited	7 days	7 hr	Unlimited	4 days	4 hr	Unlimited	3 days	2.5 hr	Unlimited	2 days
Macropoxy 646	48hrs	1 year	10 days	24hrs	1 year	8 days	8hrs	1 year	7 days	4.5hrs	1 year	1 day
Sherloxane 800	16hrs	90d	8d	10 hrs	90d	8d	3hrs	90d	7d	1.5hrs	90d	3d

N/A Not Applicable

Coating System Reference	TR0042 v.8 System 6C
Surface Cleanliness	Sweep blasting with non-metallic and chloride free grit.
Surface Roughness	25µm to 85µm

Product Name	Product Type	DFT (µm)			Volume Solid (%)	Theoretical m² / ltr @ spec DFT	Mixing Thinner	Thinning %	Mix Ratio by Volume (Base:Additive)
		min	spec	max					
Epo-Phen FF	Epoxy Phenolic	125	125	175	70	5.6	No.50	≤ 15	4:1
Epo-Phen FF	Epoxy Phenolic	125	125	175	70	5.6	No.50	≤ 15	4:1
		TOTAL	250	350					

Product Name	5°C			10°C			23°C			40°C		
	Overcoating Time		Full Cure Time	Overcoating Time		Full Cure Time [1]	Overcoating Time		Full Cure Time [1]	Overcoating Time		Full Cure Time [1]
	min	max		min	max		min	max		min	max	
Epo-Phen FF	N/A			48 hr	30 days	21 days	16 hr	30 days	7 days	6 hr	30 days	3 days
Epo-Phen FF	N/A			48 hr	30 days	21 days	16 hr	30 days	7 days	6 hr	30 days	3 days

Notes

1. The time stated refers to cure-to-service. For handling times please see individual Product Technical Data Sheet.

N/A Not Applicable

Coating System Reference	TR0042 v.8 System 7A
Surface Cleanliness	Sa2½ according to ISO 8501-1
Surface Roughness	Grade Medium G (50µm to 80µm, R_{y5}) according to ISO 8503

Product Name	Product Type	DFT (µm)			Volume Solid (%)	Theoretical m² / ltr @ spec DFT	Mixing Thinner	Thinning %	Mix Ratio (Base:Additive)
		min	spec	max					
Magnalux 41V2	Vinyl Ester Glass Flake	500	750	1000	85 [1]	1.1	13	DNT	50:1 by weight
Magnalux 41V2	Vinyl Ester Glass Flake	500	750	1000	85 [1]	1.1	13	DNT	50:1 by weight
		TOTAL	1500	2000					

Product Name	5°C			10°C			23°C			40°C		
	Overcoating Time		Full Cure Time [2]	Overcoating Time		Full Cure Time [2]	Overcoating Time		Full Cure Time [2]	Overcoating Time		Full Cure Time [2]
	min	max		min	max		min	max		min	max	
Magnalux 41V2	6 hr	Unlimited	7 days	4 hr	Unlimited	4 days	2.5 hr	Unlimited	3 days	1 hr	Unlimited	2 days
Magnalux 41V2	6 hr	Unlimited	7 days	4 hr	Unlimited	4 days	2.5 hr	Unlimited	3 days	1 hr	Unlimited	2 days

Notes

1. Theoretical 98% at time of mixing. Practical typically 85% ± 5%. All vinyl/polyester resin systems are subject to monomer loss and material shrinkage during application and curing
2. The time stated refers to cure-to-service. For handling times please see individual Product Technical Data Sheet.

Coating System Reference	TR0042 v.8 System 7B
Surface Cleanliness	Sa2½ according to ISO 8501-1
Surface Roughness	Grade Medium G (50µm to 80µm, R_{y5}) according to ISO 8503

Product Name	Product Type	DFT (µm)			Volume Solid (%)	Theoretical m² / ltr @ spec DFT	Mixing Thinner	Thinning %	Mix Ratio by Volume (Base:Additive)
		min	spec	max					
Macropoxy M922	Epoxy Glass Flake	175	175	500	83	4.7	No.9	NR	4:1
Macropoxy M922	Epoxy Glass Flake	175	175	500	83	4.7	No.9	NR	4:1
		TOTAL	350	1000					

Product Name	5°C			10°C			23°C			40°C		
	Overcoating Time		Full Cure Time [1]	Overcoating Time		Full Cure Time [1]	Overcoating Time		Full Cure Time [1]	Overcoating Time		Full Cure Time [1]
	min	max		min	max		min	max		min	max	
Macropoxy M922	6 hr	Unlimited	7 days	5 hr	Unlimited	4 days	3 hr	Unlimited	3 days	1 hr	Unlimited	2 days
Macropoxy M922	6 hr	Unlimited	7 days	5 hr	Unlimited	4 days	3 hr	Unlimited	3 days	1 hr	Unlimited	2 days

Notes

1. The time stated refers to cure-to-service. For handling times please see individual Product Technical Data Sheet.

NR Not Required

Coating System Reference	TR0042 v.8 System 7C(i) Temperatures up to 80ºC
Surface Cleanliness	Sa2½ according to ISO 8501-1
Surface Roughness	Grade Medium G (50µm to 80µm, R_{y5}) according to ISO 8503

Product Name	Product Type	DFT (µm)			Volume Solid (%)	Theoretical m² / ltr @ spec DFT	Mixing Thinner	Thinning %	Mix Ratio by Volume (Base:Additive)
		min	spec	max					
Macropoxy M922	Epoxy Glass Flake	175	175	500	83	4.7	No.9	NR	4:1
Macropoxy M922	Epoxy Glass Flake	175	175	500	83	4.7	No.9	NR	4:1
		TOTAL	350	1000					

Product Name	5°C			10°C			23°C			40°C		
	Overcoating Time		Full Cure Time [1]	Overcoating Time		Full Cure Time [1]	Overcoating Time		Full Cure Time [1]	Overcoating Time		Full Cure Time [1]
	min	max		min	max		min	max		min	max	
Macropoxy M922	6 hr	Unlimited	7 days	5 hr	Unlimited	4 days	3 hr	Unlimited	3 days	1 hr	Unlimited	2 days
Macropoxy M922	6 hr	Unlimited	7 days	5 hr	Unlimited	4 days	3 hr	Unlimited	3 days	1 hr	Unlimited	2 days

Notes

1. The time stated refers to cure-to-service. For handling times please see individual Product Technical Data Sheet.

NR Not Required

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Coating System Reference	TR0042 v.8 System 7C (ii) Temperatures up to 99C
Surface Cleanliness	Sa2½ according to ISO 8501-1
Surface Roughness	Grade Medium G (50µm to 80µm, R_{y5}) according to ISO 8503

Product Name	Product Type	DFT (µm)			Volume Solid (%)	Theoretical m² / ltr @ spec DFT	Mixing Thinner	Thinning %	Mix Ratio by Volume (Base:Additive)
		min	spec	max					
Epo-Phen FF	Epoxy Novalac	175	175	225	70	4.0	50	DNT	4:1
Epo-Phen FF	Epoxy Novalac	175	175	225	70	4.0	50	DNT	4:1
		TOTAL	350	450					

Product Name	5°C			10°C			23°C			40°C		
	Overcoating Time		Full Cure Time	Overcoating Time		Full Cure Time	Overcoating Time		Full Cure Time	Overcoating Time		Full Cure Time
	min	max		min	max		min	max		min	max	
Epo-Phen FF	N/A			48 hrs	30 days	21 days	16 hrs	30 days	7 days	6 hr	30 days	3 days
Epo-Phen FF	N/A			48 hrs	30 days	21 days	16 hrs	30 days	7 days	6 hr	30 days	3 days

Notes

N/A Not Applicable

DNT Do Not Thin

Coating System Reference	TR0042 v.8 System 7C (iii) Temperatures up to 140C
Surface Cleanliness	Sa2½ according to ISO 8501-1
Surface Roughness	Grade Medium G (50µm to 80µm, R_{y5}) according to ISO 8503

Product Name	Product Type	DFT (µm)			Volume Solid (%)	Theoretical m² / ltr @ spec DFT	Mixing Thinner	Thinning %	Mix Ratio by Volume (Base:Additive)
		min	spec	max					
Nova-plate UHS	Epoxy Novalac	175	175	500	98	5.6	13	DNT	4:1
Nova-plate UHS	Epoxy Novalac	175	175	500	98	5.6	13	DNT	4:1
		TOTAL	350	1000					

Product Name	5°C			10°C [1]			23°C [1]			40°C [1]		
	Overcoating Time		Full Cure Time	Overcoating Time		Full Cure Time [2]	Overcoating Time		Full Cure Time [2]	Overcoating Time		Full Cure Time [2]
	min	max		min	max		min	max		min	max	
Nova-plate UHS	N/A			36 hr	21 days	7 days	14 hr	21 days	5 days	6 hr	14 days	5 days
Nova-plate UHS	N/A			36 hr	21 days	14 hr	3 hr	21 days	5 days	6 hr	14 days	5 days

Notes

1. Overcoating and Full Cure Times are based on the use of Nova-plate UHS Standard Hardener (ref: B62V221)
2. The time stated refers to cure-to-service. For handling times please see individual Product Technical Data Sheet.

N/A Not Applicable

DNT Do Not Thin

Coating System Reference	TR0042 v.8 System 7C (iv) Temperatures up to 180C
Surface Cleanliness	Sa2½ according to ISO 8501-1
Surface Roughness	Grade Medium G (50µm to 80µm, R_{y5}) according to ISO 8503

Product Name	Product Type	DFT (µm)			Volume Solid (%)	Theoretical m² / ltr @ spec DFT	Mixing Thinner	Thinning %	Mix Ratio by Volume (Base:Additive)
		min	spec	max					
Nova-plate 325	Epoxy Novalac	175	175	350	98	5.6	No.13	DNT	2:1
Nova-plate 325	Epoxy Novalac	175	175	350	98	5.6	No.13	DNT	2:1
		TOTAL	350	700					

Product Name	5°C			10°C			23°C			40°C		
	Overcoating Time		Full Cure Time	Overcoating Time		Full Cure Time [1]	Overcoating Time		Full Cure Time [1]	Overcoating Time		Full Cure Time [1]
	min	max		min	max		min	max		min	max	
Nova-plate 325	N/A			6.5 hrs	21 days	14 days	2.5 hrs	21 days	24 hours	1.5 hrs	9 days	24 hours
Nova-plate 325	N/A			6.5 hrs	21 days	14 days	2.5 hrs	21 days	24 hours	1.5 hrs	9 days	24 hours

Notes

1. The time stated refers to cure-to-service. For handling times please see individual Product Technical Data Sheet.

N/A Not Applicable

DNT Do Not Thin

Coating System Reference	TR0042 v.8 System 8
Surface Cleanliness	Sa2½ according to ISO 8501-1
Surface Roughness	Grade Medium G (50µm to 80µm, R_{y5}) according to ISO 8503

Product Name	**Product Type**	**DFT (µm)**			**Volume Solid (%)**	**Theoretical m² / ltr @ spec DFT**	**Mixing Thinner**	**Thinning %**	**Mix Ratio by Volume (Base:Additive)**
		min	**spec**	**max**					
Macropoxy 646	Epoxy	150	150	250	72	4.8	No.50	≤ 10	1:1
		TOTAL	150	250					

Product Name	**5°C**			**10°C**			**23°C**			**40°C**		
	Overcoating Time		**Full Cure Time [1]**	**Overcoating Time**		**Full Cure Time [1]**	**Overcoating Time**		**Full Cure Time [1]**	**Overcoating Time**		**Full Cure Time [1]**
	min	**max**		**min**	**max**		**min**	**max**		**min**	**max**	
Macropoxy 646	48 hr	1 year	10 days	24 hr	1 year	8 days	8 hr	1 year	7 days	4.5 hr	1 year	4 days

Notes

1. The time stated refers to cure-to-service. For handling times please see individual Product Technical Data Sheet.

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Coating System Reference	TR0042 v.8 System 9
Surface Cleanliness	Sa2½ according to ISO 8501-1
Surface Roughness	Grade Medium G (50µm to 85µm, R_{y5}) according to ISO 8503

Product Name	Product Type	DFT (µm)			Volume Solid (%)	Theoretical m² / ltr @ spec DFT	Mixing Thinner	Thinning %	Mix Ratio by Volume (Base:Additive)
		min	spec	max					
Zinc Clad II/EU	Inorganic Zinc	60	60	125	62	7.75	No.4	≤ 5	9.9Kgs : 3.43 litres
Macropoxy 646	Epoxy (Mist coat)	n/a	n/a	n/a	72	n/a	No.50	≤ 10	1:1
Macropoxy 646	Epoxy	100	140	250	72	5.9	No.50	≤ 5	1:1
Sherloxane 800	Polysiloxane	100	100	150	90	9	NR	NR	4:1
		TOTAL	300	600					

Product Name	5°C			10°C			23°C			40°C		
	Overcoating Time		Full Cure Time[1]	Overcoating Time		Full Cure Time[1]	Overcoating Time		Full Cure Time[1]	Overcoating Time		Full Cure Time[1]
	min	max		min	max		min	max		min	max	
Zinc Clad II/EU	[2]	Unlimited [3]	14 days [4]	48 hr [2]	Unlimited [3]	14 days [4]	18 hr [2]	Unlimited [3]	14 days [4]	18 hr [2]	Unlimited [3]	14 days [4]
Macropoxy 646	48hrs	1 year	10 days	24hrs	1 year	8 days	8hrs	1 year	7 days	4.5hrs	1 year	1 day
Sherloxane 800	16hrs	90d	8d	10 hrs	90d	8d	3hrs	90d	7d	1.5hrs	90d	3d

Notes

1. Overcoating and Full Cure Times are based on a Relative Humidity level of 50%.
2. Minimum Overcoating and Full Cure Time to be confirmed by carrying out 50 MEK double rubs. No zinc or only slight traces should be visible. Coin hardness test can also be used.
3. Maximum Overcoating time is "Unlimited" providing any salting on the zinc surface due to weathering exposure is fully removed prior to topcoating.
4. The time stated refers to cure-to-service. For handling times please see individual Product Technical Data Sheet.