



Protective & Marine Coatings

EPOLON™ II MULTI-MIL EPOXY

PART A
PART B

B62-800
B62V800

SERIES
HARDENER

Revised: September 30, 2025

PRODUCT INFORMATION

4.64

PRODUCT DESCRIPTION

EPOLON II MULTI-MIL EPOXY is a high performance, interior/exterior, high build, self-priming, two component, catalyzed polyamide epoxy.

- Long term durability
- Chemical and abrasion resistant
- Long pot life
- Outstanding application properties

PRODUCT CHARACTERISTICS

Finish:	Semi-Gloss
Color:	Wide range of colors available
Volume Solids:	67% ± 2%, ASTM D2697, mixed, may vary by color
Weight Solids:	81% ± 2%, ASTM D2369, mixed, may vary by color
VOC (EPA Method 24):	Unreduced: <280 g/L; 2.33 lb/gal Reduced 6%: <312 g/L; 2.60 lb/gal
Mix Ratio:	1:1 by volume

Recommended Spreading Rate per coat:

	Minimum	Maximum
Wet mils (microns)	4.5 (112)	9.0 (225)
Dry mils (microns)	3.0* (75)	6.0* (150)
~Coverage sq ft/gal (m²/L)	180 (4.4)	365 (8.9)
Theoretical coverage sq ft/gal (m²/L) @ 1 mil / 25 microns dft	1072 (26.2)	

*See Performance Tips section

NOTE: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.

Drying Schedule @ 4.0 mils wet (100 microns):

	@ 50°F/10°C	@ 77°F/25°C 50% RH	@ 120°F/49°C
To touch:	4 hours	3 hours	1 hour
To handle:	16 hours	8 hours	3 hours
To recoat:			
minimum:	24 hours	18 hours	8 hours
maximum:	6 months	6 months	6 months
To cure:	7 days	7 days	7 days
<i>If maximum recoat time is exceeded, abrade surface before recoating.</i>			
<i>Drying time is temperature, humidity, and film thickness dependent.</i>			
Pot Life:	4 hours	4 hours	1 hour
Sweat-in-time:	15 minutes	none	none

Shelf Life:	24 months, unopened Store indoors at 40°F (4.5°C) to 100°F (38°C).
Flash Point:	110°F (43°C), PMCC, mixed
Reducer/Clean Up:	Reducer #145, R7K145

RECOMMENDED USES

For use over prepared surfaces such as:

- Steel
- Galvanized
- Structural steel
- Tank exteriors
- Piping
- Bridges
- Suitable for use in USDA inspected facilities
- Not intended for architectural applications.
- Conforms to AWWA D102 OCS #5
- Concrete
- Masonry
- Masonry surfaces
- Paper mills
- Refineries
- Power plants



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RECOMMENDED SYSTEMS

	Dry Film Thickness / ct.	
	Mils	(Microns)
Steel:		
1 ct. Macropoxy 4600	3.0-10.0	(75-250)
1-2 cts. Epolon II Multi-Mil Epoxy	3.0-6.0	(75-150)
Steel:		
1 ct. Macropoxy 646	5.0-10.0	(125-250)
1 ct. Epolon II Multi-Mil Epoxy	3.0-6.0	(75-150)
1-2 cts. Acrolon 218 HS Polyurethane	3.0-6.0	(75-150)
Steel:		
2 cts. Epolon II Multi-Mil Epoxy	3.0-6.0	(75-150)
Steel:		
1 ct. Zinc Clad II Plus	3.0-5.0	(75-125)
1-2 cts. Epolon II Multi-Mil Epoxy	3.0-6.0	(75-150)
Steel:		
1 ct. Dura-Plate 235	4.0-8.0	(100-200)
1-2 cts. Epolon II Multi-Mil Epoxy	2.0-4.0	(50-100)
Galvanized:		
1-2 cts. Epolon II Multi-Mil Epoxy	2.0-4.0	(50-100)
Masonry:		
1 ct. Kem Cati-Coat HS	10.0-20.0	(250-500)
2 cts. Epolon II Multi-Mil Epoxy	3.0-6.0	(75-150)

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: SSPC-SP6/NACE 3, 2 mil (50 micron) profile

Galvanizing: SSPC-SP1

Concrete & Masonry: SSPC-SP13/NACE 6, or ICRI No. 310.2R, CSP 1-3

Surface Preparation Standards

Condition of Surface	ISO 8501-1 BS7079:A1	Swedish Std. 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	-
Pitted & Rusted	D St 2	D St 2	SP 2	-
Rusted	C St 3	C St 3	SP 3	-
Power Tool Cleaning	Pitted & Rusted	D St 3	SP 3	-

TINTING

Tint Part A with Blend-A-Color Toner at 200% strength. Five minutes minimum mixing on a mechanical shaker is required for complete mixing of color.

APPLICATION CONDITIONS

Temperature: 50°F (10°C) minimum, 120°F (49°C) maximum

(air, surface, and material)

Relative humidity: At least 5°F (2.8°C) above dew point 85% maximum

Refer to product Application Bulletin for detailed application information.

ORDERING INFORMATION

Packaging:
Parts A and B: 1 gallon (3.78L) and 5 gallon (18.9L) containers

Weight: 11.9 ± 0.2 lb/gal ; 1.4 Kg/L mixed, may vary with color

SAFETY PRECAUTIONS

Refer to the SDS 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.



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APPLICATION BULLETIN

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SURFACE PREPARATIONS

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.

Iron & Steel (atmospheric service)

Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1. Minimum surface preparation is Commercial Blast Cleaning per SSPC-SP6/NACE 3. For better performance, use Near White Metal Blast Cleaning per SSPC-SP10/NACE 2. Blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (2 mils / 50 microns). Prime any bare steel the same day as it is cleaned.

Galvanized Steel

Allow to weather a minimum of six months prior to coating. Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1 (recommended solvent is VM&P Naphtha). When weathering is not possible, or the surface has been treated with chromates or silicates, first Solvent Clean per SSPC-SP1 and apply a test patch. Allow paint to dry at least one week before testing adhesion. If adhesion is poor, brush blasting per SSPC-SP7 is necessary to remove these treatments. Rusty galvanizing requires a minimum of Hand Tool Cleaning per SSPC-SP2, prime the area the same day as cleaned.

Concrete and Masonry

For surface preparation, refer to SSPC-SP13/NACE 6, or ICRI No. 310.2R, CSP 1-3. Surfaces should be thoroughly clean and dry. Concrete and mortar must be cured at least 28 days @ 75°F (24°C). Remove all loose mortar and foreign material. Surface must be free of laitance, concrete dust, dirt, form release agents, moisture curing membranes, loose cement and hardeners. Fill bug holes, air pockets and other voids with Steel-Seam FT910.

Follow the standard methods listed below when applicable:

- ASTM D4258 Standard Practice for Cleaning Concrete.
- ASTM D4259 Standard Practice for Abrading Concrete.
- ASTM D4260 Standard Practice for Etching Concrete.
- ASTM F1869 Standard Test Method for Measuring Moisture Vapor Emission Rate of Concrete.
- SSPC-SP 13/Nace 6 Surface Preparation of Concrete.
- ICRI No. 310.2R Concrete Surface Preparation.

Surface Preparation Standards

Condition of Surface	ISO 8501-1 BS7079:A1	Swedish Std. 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	Rusted C St 2	C St 2	SP 2	-
Pitted & Rusted	D St 2	D St 2	SP 2	-
Rusted	C St 3	C St 3	SP 3	-
Power Tool Cleaning	Pitted & Rusted D St 3	D St 3	SP 3	-

APPLICATION CONDITIONS

Temperature: 50°F (10°C) minimum, 120°F (49°C) maximum (air, surface, and material)
At least 5°F (2.8°C) above dew point

Relative humidity: 85% maximum

APPLICATION EQUIPMENT

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

Reducer/Clean UpReducer #145, R7K145

Airless Spray

Pressure.....2700 - 3000 psi
Hose.....3/8" ID
Tip0.017" - .021"
Filter60 mesh
Reduction.....As needed up to 6% by volume

Conventional Spray

GunBinks 95
Fluid Nozzle68
Air Nozzle.....68PB
Atomization Pressure.....50 psi
Fluid Pressure.....20 psi
Reduction.....As needed up to 6% by volume

Brush

Brush.....Nylon/Polyester or Natural Bristle
Reduction.....As needed up to 6% by volume

Roller

Cover3/8" - 1/2" woven with solvent resistant core
Reduction.....As needed up to 6% by volume

If specific application equipment is not listed above, equivalent equipment may be substituted.



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APPLICATION PROCEDURES

Surface preparation must be completed as indicated.

Mix contents of each component thoroughly with low speed power agitation. Make certain no pigment remains on the bottom of the can. Then combine one part by volume of Part A with one part by volume of Part B. Thoroughly agitate the mixture with power agitation. Allow the material to sweat-in as indicated. Re-stir before using.

If reducer solvent is used, add only after both components have been thoroughly mixed, after sweat-in.

Apply paint at the recommended film thickness and spreading rate as indicated below:

Recommended Spreading Rate per coat:

	Minimum	Maximum
Wet mils (microns)	4.5 (112)	9.0 (225)
Dry mils (microns)	3.0* (75)	6.0* (150)
~Coverage sq ft/gal (m ² /L)	180 (4.4)	365 (8.9)
Theoretical coverage sq ft/gal (m ² /L) @ 1 mil / 25 microns dft	1072 (26.2)	

*See Performance Tips section

NOTE: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.

Drying Schedule @ 4.0 mils wet (100 microns):

	@ 50°F/10°C	@ 77°F/25°C 50% RH	@ 120°F/49°C
To touch:	4 hours	3 hours	1 hour
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To recoat:			
minimum:	24 hours	18 hours	8 hours
maximum:	6 months	6 months	6 months
To cure:	7 days	7 days	7 days
<i>If maximum recoat time is exceeded, abrade surface before recoating. Drying time is temperature, humidity, and film thickness dependent.</i>			
Pot Life:	4 hours	4 hours	1 hour
Sweat-in-time:	15 minutes	none	none

Application of coating above maximum or below minimum recommended spreading rate may adversely affect coating performance.

CLEAN UP INSTRUCTIONS

Clean spills and spatters immediately with Reducer #145, R7K145. Clean tools immediately after use with Reducer #145, R7K145. Follow manufacturer's safety recommendations when using any solvent.

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PERFORMANCE TIPS

Stripe coat all crevices, welds, and sharp angles to prevent early failure in these areas.

When using spray application, use a 50% overlap with each pass of the gun to avoid holidays, bare areas, and pinholes. If necessary, cross spray at a right angle.

Spreading rates are calculated on volume solids and do not include an application loss factor due to surface profile, roughness or porosity of the surface, skill and technique of the applicator, method of application, various surface irregularities, material lost during mixing, spillage, overthinning, climatic conditions, and excessive film build.

Excessive reduction of material can affect film build, appearance, and adhesion.

Insufficient ventilation, incomplete mixing, miscatalyzation, and external heaters may cause premature yellowing.

Excessive film build, poor ventilation, and cool temperatures may cause solvent entrapment and premature coating failure.

Do not apply the material beyond recommended pot life.

Do not mix previously catalyzed material with new.

In order to avoid blockage of spray equipment, clean equipment before use or before periods of extended downtime with Reducer #145, R7K145.

Not intended for architectural applications.

Quik-Kick Epoxy Accelerator is acceptable for use. See data page for details.

When coating over aluminum and galvanizing, recommended dft is 2-4 mils (50-100 microns).

Refer to Product Information sheet for additional performance characteristics and properties.

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