SAXON PAINTS.

SAXON SHIELD-06

DESCRIPTION

SAXON SHIELD-06 is a two-component, polyamide-cured, zinc-rich epoxy primer formulated with a very high zinc dust content to provide excellent anti-corrosive protection. It meets the compositional requirements of SSPC Paint 20 Level 1, ISO 12944-5, BS 4652, BS 5493, and AS/NZS 3750.9:1994. Designed for use as a primer in atmospheric exposure conditions, it offers reliable corrosion resistance when applied as part of a complete protective coating system. It is suitable for carbon steel, repair areas of inorganic zinc silicate coatings, and damaged galvanized steel surfaces. The zinc dust used in this product complies with ASTM D520 Type II.

Suitable for use on structural steel and piping exposed to aggressive atmospheric conditions. Designed for environments classified up to C5 corrosivity category in accordance with ISO 12944-2, making it appropriate for highly corrosive industrial and marine atmospheres.

Recommended for a wide range of demanding applications, including:

MAIN PROPERTIES

- Offshore platforms and marine structures
- Refineries and petrochemical plants
- Power generation facilities
- Bridges and infrastructure projects
- Commercial and industrial buildings
- Mining equipment and heavy machinery
- General structural steel fabrication

Specially formulated for use as a high-performance primer in protective coating systems where long-term durability and corrosion resistance are required. Provides a strong anti-corrosive foundation when used as part of a complete coating system, helping to extend the service life of steel structures.

Suitable for projects requiring extended maintenance intervals, especially in environments where exposure to moisture, salt, chemicals, or industrial pollutants may accelerate corrosion. Approved under various bridge and infrastructure specifications requiring a 90% zinc dust content, offering enhanced sacrificial protection to carbon steel substrates. Ideal for steelwork where reliable protection, strong adhesion, and compatibility with subsequent coating layers are essential.

COLOUR AND PRODUCT PRESENTATION

Colour range	See Saxon Colour Chart (other colours available on request)
Size	10 litres – 20 litres

MAIN PROPERTIES

PREPARED MIXED PRODUCT	DETAILS
Application	Roller and brush for stripe coating, spot repair or small sections. Spray gun/machine for product application.
Touch Dry	3 to 40 minutes depending on ambient conditions.
Recoatable	2.5 hours to 30 minutes, drying times will be significantly longer in cold conditions.
Coverage	25 m^2 per litre at 25 µm DFT 8 m^2 per litre at 100 µm DFT This numbers could be lower on highly porous surfaces.

PREPARED MIXED PRODUCT	DETAILS
Thinning	The amount of thinner added should not exceed 10% by volume, unless otherwise stated in the product's Technical Data Sheet.
Cleaning	Clean equipment immediately after use with solvents / thinners.
Colours	Off-white & Light Grey (other colours available on request).
Shelf Life	Base: 24 months: if correctly stored to manufacturer's guidelines. Activator: 24 months: if correctly stored to manufacturer's guidelines.
Fully cured	3 days.
DFT	25 - 100 µm depending on system required.
Volume of Solids	60%
Pot Life	24 hours.

CURING TIME FOR DFT UP TO 100 µm	
Substrate temperature	Dry to touch
5˚C (41˚F)	40 min
10˚C (50˚F)	20 minutes
20˚C (68˚F)	15 minutes
30˚C (86˚F)	10 minutes
40˚C (104˚F)	3 minutes

OVERCOATING INTERVAL FOR DFT up to 100 µm						
Product	Interval	5˚C (41˚F)	10˚C (50˚F)	20˚C (68˚F)	30˚C (86˚F)	40˚C (104˚F)
Saxon Shield-06	Minimum	8 days	6 days	4 days	2 days	36 hours

LIMITATIONS

During application and curing, the substrate temperature must be maintained above 5 ˚C (41 ˚F) and at least 3˚C (5 ˚F) above the dew point to prevent condensation. The product shall be mixed by volume at a ratio of 75:25 (base to activator), equivalent to 3:1. For proper application, the paint temperature should preferably exceed 20˚ C (68˚ F). Thorough mechanical mixing of the base and activator is essential, the product is supplied ready for use and normally does not require thinning, if thinning is necessary to improve application properties, it should be done only with the recommended thinner.

Note: Do not use if the substrate is above 180 degrees Fahrenheit.

PREPARATION

This product requires proper surface preparation in accordance with conventional coating system requirements. Prior to application, the substrate must be sound, clean, dry, and free from oil, laitance, loose material, dust, or any other contaminants that may affect adhesion or performance. For steel surfaces, abrasive blast cleaning shall be carried out to a minimum standard of SSPC-SP10 or ISO Sa 2½, with a recommended surface profile of 50–125 µm / 2.0–5.0 mils. When applied over steel previously coated with a suitable primer, the primed surface must be fully dry, intact, and free from any contamination before overcoating.

COATING SYSTEM

APPLICATION

Stir well before and during use.

ROLLER

For spot repairs, touch-ups, stripe coating and small areas the product may be applied by roller directly from the container, ensuring the roller sleeve is fully loaded with material before application. Apply the coating in a controlled and systematic manner, focusing only on the affected areas, welds, edges, corners, bolts, seams, or other localized sections requiring additional protection. Work the material evenly into the surface to achieve full coverage and proper film build, blending the repair area into the surrounding coating while the material remains wet. Maintain a manageable wet edge during application to avoid visible lap marks and ensure a uniform finish.

BRUSH

For spot repairs, touch-ups, stripe coating and small areas the product may be applied by brush directly from the container. Before use, ensure the brush is clean and free from dust, loose bristles, or any contamination that could affect the coating finish. Load the brush by dipping up to approximately half the length of the bristles into the product, then gently tap off any excess material against the side of the container without wiping the brush aggressively. Apply the coating in a controlled and even manner, concentrating on localized areas such as welds, edges, corners, bolts, seams, or damaged sections requiring additional protection. Avoid excessive pressure during application; allow the material to flow from the brush to achieve proper coverage, film build, and adhesion. Blend the repaired or striped area into the surrounding coating while the material remains wet to obtain a uniform finish.

SPRAY

For spray application, use heavy-duty, single-feed airless spray equipment, preferably with a 60:1 pump ratio, suitable high-pressure hoses, and

equipment capable of maintaining the required spray pressure throughout the application. The product is supplied ready for use and should normally be applied without adding thinner. If thinning is required, use only the recommended thinner and do not exceed 10% by volume, unless otherwise stated in the Technical Data Sheet.

As general guiding data for airless spray application, use a nozzle tip size between 0.015–0.021 in. / 15–21 thou. The minimum recommended pressure at the nozzle is 150 bar / 2,100 psi. For higher-build application or where additional atomization is required, an approximate nozzle orifice of 0.53 mm / 0.021 in may be used. At a paint temperature of 20˚C / 68˚F, the minimum recommended nozzle pressure is 28.0 MPa / 280 bar / 4,061 psi. At a paint temperature of 30˚C / 86˚F, the minimum recommended nozzle pressure is 22.0 MPa / 220 bar / 3,191 psi.

Before spraying, mask and protect all areas that are not intended to be coated using suitable masking tape, paper, or protective film. Begin application from the upper sections and work downward, applying the coating with smooth, controlled, and overlapping spray passes while maintaining a consistent wet edge. Keep the spray gun at a uniform distance from the surface and apply the material evenly to achieve the required film build, coverage, and finish.

For larger surfaces, apply the coating in a systematic pattern using horizontal and vertical passes, or a crosshatch method where required, to obtain a full and uniform coating without missed areas, dry spray, or excessive build-up. The spray tip should be checked and cleaned regularly during application to prevent blockage and maintain a consistent spray pattern.

Other spray equipment or application methods may be suitable depending on site conditions; however, Saxon Technical Support should be consulted when alternative equipment is proposed.

CLEANING

Return excess material/paint to container. Wash and clean using solvents or thinner immediately after use. All application tools and spray equipment should be cleaned thoroughly immediately after use to prevent material build-up or curing inside the system. Any mixed coating remaining inside the spray unit, hoses, gun, or related equipment must be flushed out before the product reaches the end of its pot life.

HEALTH AND SAFETY

Please refer to the Safety, Health and Environmental Information on the

RECOMMENDATIONS

container. When preparing the surfaces avoid the inhalation of dust and/or metal particles. Wear a suitable facemask and recommended safety personal protection. Material Safety Data Sheets for this is available freely available at Saxon Paints website.

STORAGE

Store in secure dry conditions. Keep out of reach of children. Containers should be kept closed during storage. Do not empty into drains, water rivers or access routes to septic drums.

For further information contact Saxon Paints

GENERAL INFORMATION

Apply all products in accordance with BS 6150: 2006 Code of practice for painting of buildings and BS 8000: Part 12: 1989 Code of practice for decorative wallcoverings and painting.

Every care is taken to ensure that all information provided on this Technical Data Sheet is accurate. Results cannot be guaranteed by the manufacturer as it has no control over the conditions under which its products are applied.

For help or more information contact Saxon Paints or visit our website at www.saxonpaints.com Before using this product please ensure you have the latest information. The information is correct at date of issue August 2022.

WARRANTY

SAXON PAINTS warrant its title to the product, that the quality of the product conforms to Saxon Paints' specifications for such product in effect at the time of manufacture and that the product shall be delivered free of the rightful claim of any third person for infringement of any patent covering the product. This product is for professional use only. The applicators and operators shall be trained, experienced and have the capability and equipment to mix/stir and apply the paints correctly and according to Saxon Paints' technical documentation. Applicators and operators shall use appropriate personal protection equipment when using this product. This guideline is given based on the current knowledge of the product. These are the only warranties that Saxon Paints makes and all other express or implied warranties, under statute or arising otherwise in law, from a course of dealing or usage of trade, including without limitation, any other warranty of fitness for a particular purpose or use, are disclaimed by Saxon Paints. Any claim under this warranty must be made by Buyer to Saxon Paints in writing within five (5) days of Buyer's discovery of the claimed defect, but in no event later than the expiration of the applicable shelf life of the product, or one year from the date of the delivery of the product to the Buyer, whichever is earlier. Buyer's failure to notify Saxon Paints of such non-conformance as required herein shall bar Buyer from recovery under this warranty Any suggested deviation to suit the site conditions shall be forwarded to the responsible Saxon Paints' representative for approval before commencing the work.

LIMITATIONS OF LIABILITY

The information in this document is given to the best of Saxon Paints' knowledge. The information in this sheet is intended for guidance only and is based upon laboratory tests that Saxon Paints' believes to be reliable. Saxon Paints' products are considered as semi-finished goods and as such, products are often used under conditions beyond Saxon Paints' control like the quality or condition of the substrate, or the many factors affecting the use and application of the product. The product and related information are designed for users having the requisite knowledge and industrial skills in the industry and it is the end-user's responsibility to determine the suitability of the product for its own particular use and it shall be deemed that Buyer has done so, as its sole discretion and risk. Saxon Paints' does not accept any liability arising from any loss, injury or damage resulting from such use or the contents of this information. Variations in the application environment, changes in procedures of use, or extrapolation of data may cause unsatisfactory results. Minor product variations may be implemented to comply with local requirements. Users should always consult Saxon Paints' for specific guidance on the general suitability of this product for their needs and specific application practices. If there is any inconsistency between different language issues of this document, the English (United Kingdom) version will prevail