SIGMACOVER 350

4 pages September 2005

DESCRIPTION

two component high build polyamine cured epoxy primer/coating

PRINCIPAL CHARACTERISTICS

- surface tolerant maintenance coating for dry cargo holds
- good impact and abrasion resistance
- fast curing
- smooth film, easy to clean
- compatible with various aged coatings
- excellent corrosion resistance
- resistant to splash and spillage of a wide range of chemicals

COLOURS AND GLOSS

grey, redbrown - semigloss

BASIC DATA AT 20°C

(1 g/cm³ = 8.25 lb/US gal; 1 m²/l = 40.7 ft²/US gal)
(data for mixed product)

Mass density	1.4 g/cm³
Volume solids	74 ±2%
VOC (supplied)	max. 263 g/kg (Directive 1999/13/EC, SED) max. 361 g/l (approx. 3.0 lb/gal)
Recommended dry film thickness	125 - 150 µm *
Theoretical spreading rate	5.9 m²/l for 125 µm, 4.9 m²/l for 150 µm
Touch dry after	2 hours
Overcoating interval	min. see tables * max. see tables *
Curing time	7 days
	(data for components)
Shelf life (cool and dry place)	at least 12 months
Flash point	base 23°C, hardener 24°C

* see additional data

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

- **for atmospheric exposure conditions:**
  - steel; blast cleaned to ISO-Sa2½ for excellent corrosion protection
  - steel; blast cleaned to ISO-Sa2 or power tool cleaned to ISO-St2 for good corrosion protection
  - existing sound epoxy coating systems and most sound alkyd coating systems; sufficiently roughened, dry and free from any contamination
- substrate temperature should be above 5°C and at least 3°C above dew point

SYSTEM SPECIFICATION

2 x 125 µm dft SigmaCover 350

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INSTRUCTIONS FOR USE

mixing ratio by volume: base to hardener 80 : 20

- the temperature of the mixed base and hardener should preferably be above 15°C, otherwise extra solvent may be required to obtain application viscosity
- too much solvent results in reduced sag resistance
- thinner should be added after mixing the components

Induction time: none

Pot life: 3 hours at 20°C *
* see additional data

AIRLESS SPRAY

Recommended thinner: Sigma thinner 91-92
Volume of thinner: 0 - 5%, depending on required thickness and application conditions
Nozzle orifice: approx. 0.48 - 0.53 mm (= 0.019 - 0.021 in)
Nozzle pressure: 15 MPa (= approx. 150 bar; 2130 p.s.i.)

AIR SPRAY

Recommended thinner: Sigma thinner 91-92
Volume of thinner: 5 - 10%, depending on required thickness and application conditions
Nozzle orifice: 1.8 - 2 mm
Nozzle pressure: 0.3 - 0.4 MPa (= approx. 3 - 4 bar, 43 - 57 p.s.i.)

BRUSH/ROLLER

Recommended thinner: Sigma thinner 91-92
Volume of thinner: 0 - 5%

CLEANING SOLVENT

Sigma thinner 90-53

SAFETY PRECAUTIONS

for paint and recommended thinners see safety sheets 1430, 1431 and relevant material safety data sheets

this is a solvent based paint and care should be taken to avoid inhalation of spray mist or vapour as well as contact between the wet paint and exposed skin or eyes

ADDITIONAL DATA

Film thickness and spreading rate

theoretical spreading rate m²/l	5.9	4.9
dft in µm	125	150

max. dft when brushing: 100 µm

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Overcoating table for SigmaCover 350 for dft up to 150 µm

	substrate temperature	5°C	10°C	20°C	30°C	40°C
with epoxy coatings	minimum interval	16 hours	10 hours	6 hours	4 hours	3 hours
with itself	maximum interval when **not** exposed to direct sunshine	12 months	9 months	6 months	3 months	1 month
with itself	maximum interval when exposed to direct sunshine	1 month	1 month	21 days	14 days	7 days

– surface should be dry and free from any contamination

Curing table for SigmaCover 350 for dft up to 150 µm

substrate temperature	touch dry	dry to handle	full cure
5°C	12 hours	16 hours	25 days
10°C	6 hours	9 hours	15 days
20°C	2 hours	6 hours	7 days
30°C	1 hour	4 hours	4 days
40°C	1 hour	3 hours	2 days

– adequate ventilation must be maintained during application and curing (please refer to sheet 1433 and 1434)

Pot life (at application viscosity)

15°C	4 hours
20°C	3 hours
30°C	2 hours
40°C	1 hour

Worldwide availability

Whilst it is always the aim of Sigma Coatings to supply the same product on a worldwide basis, slight modification of the product is sometimes necessary to comply with local or national rules/circumstances.
Under these circumstances an alternative product data sheet is used.

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REFERENCES

Explanation to product data sheets	see information sheet 1411
Safety indications	see information sheet 1430
Safety in confined spaces and health safety	
Explosion hazard - toxic hazard	see information sheet 1431
Safe working in confined spaces	see information sheet 1433
Directives for ventilation practice	see information sheet 1434

LIMITATION OF LIABILITY

DS	7970
220296 grey	5177052200
220298 redbrown	6179052200

SIGMA COATINGS