

A two sheet issue

DESCRIPTION	two component multipurpose primer and build coat based on polyamide cured water borne epoxy for cement based substrates.
PRINCIPAL CHARACTERISTICS	<ul style="list-style-type: none"> - general multipurpose epoxy primer and coating for concrete - particularly suitable when solvents are not permitted because of health and safety reasons - free from lead and chromate containing pigments - can be overcoated with most alkyd paints and 2 component durable finishes - easy application by brush/roller and (airless) spray - suitable for concrete floors
COLOUR AND GLOSS	limited color range available – Matt finish
BASIC DATA AT 20 °C	(for mixed product)
Mass density	approx. 1.5 g/cm ³
Solids content	approx. 57 ±2 % by volume
VOC (Directive 1999/13/EC, SED)	max. 20 g/kg (Directive 1999/13/EC, SED)
VOC (UK PG 6/23(92) appendix 3)	max. 30 g/l (approx. 0.24 lb/gal)
Recommended dry film thickness	50 - 100 µm depending on the system
Theoretical spreading rate	11.4 m ² /ltr for 50 µm, 5.7 m ² /ltr for 100 µm depending on the nature and condition of the substrate and the application method employed
Touch dry	approx. 2 hours
Overcoating interval	min. 6 hours* max. 6 months*
Full cure after	6 days
Shelf life (cool, dry place)	12 months
Available pack size	5 ltr, 20 ltr set
*see additional data	please turn

RECOMMENDED SUBSTRATE CONDITIONS

new concrete:

- surface must be cured, clean, dry and free of disintegrated or chalky materials
- substrate temperature must be above 10°C and at least 3°C above dew point during application and curing
- maximum relative humidity during application and curing is 75%

INSTRUCTIONS FOR USE

- mixing ratio: by volume; base to hardener 84 : 16
- prior to application the equipment must be flushed with Sigma thinner 70-05 and tap water according to the cleaning procedure for waterborne coatings
- adequate ventilation must be maintained during application and curing.
- must be protected from freezing at all times during storage and/or transport
- too much water will result in lower sag resistance and slower cure
- the temperature of the mixed base and hardener should preferably be above 15°C, otherwise extra water may be required to obtain application viscosity
- water should only be added after proper mixing of the base and hardener

Induction time at 20 °C

none

Potlife at 20 °C

1.5 hours*

METHOD OF APPLICATION

AIRLESS SPRAY

Recommended thinner

sweet water

Volume of thinner

0 - 5% depending on required thickness and application conditions

Nozzle orifice

approx. 0.48 mm (0.019 inch)

Nozzle pressure

15 MPa (= approx. 150 bar, 2176 p.s.i.)

AIR SPRAY

Recommended thinner

sweet water

Volume of thinner

0 - 5% depending on required thickness and application conditions

Nozzle orifice

1.5- 3.0 mm

Nozzle pressure

3 - 4 bar (approx. 43 - 57 p.s.i.)

BRUSH AND ROLLER

Recommended thinner

sweet water

Volume of thinner

0 - 5%

CLEANING SOLVENT

tap water and Thinner 70-05

see sheet two

Sheet two

CLEANING PROCEDURE

- **cleaning procedures of the spray equipment:**
- pulsator filter and tip filter must be taken out of the equipment cleaned properly
- following tables illustrate the cleaning procedure of the spray equipment when changing spraying from solvent borne paint to water borne paints (table 1) and from water borne paints to solvent borne paints (table 2)

table 1: from solvent borne - to water borne paints

1 st cleaning	with Thinner 90-53
2 nd cleaning	with Thinner 70-05
3 rd cleaning	with warm tap water (30 – 35°C)

after which water borne paints can be sprayed.

table 2: from water borne - to solvent borne paints

1 st cleaning	with warm tap water (30 – 35°C)
2 nd cleaning	with Thinner 70-05
3 rd cleaning	with Thinner 90-53

SAFETY PRECAUTIONS



see safety sheet 1570 for information on LEL and TLV values

ADDITIONAL DATA

overcoating table for SIGMACAP AQUA 300

	substrate temperature	20 °C	30 °C	40 °C
with itself	minimum interval	6 hours	5 hours	4 hours
with Sigmadur	minimum interval	48 hours	36 hours	24 hours
	maximum interval	6 months	6 months	6 months

Curing table for dft up to 100 µm

substrate temperature	touch dry	dry to handle	full cure
10 °C	3 hours	18 hours	6 days
20 °C	2 hours	6 hours	6 days
30 °C	1.5 hours	5 hours	5days
40 °C	1.0 hour	4 hours	4 days

Potlife at application viscosity

paint temperature	Pot life
10 °C	4 hours
20 °C	90 mins
30 °C	70 mins
40 °C	45 mins

REFERENCES

explanation to product data sheets on information sheet 1551