

# SIGMARINE™ 24

## DESCRIPTION

Modified zinc phosphate alkyd primer

## PRINCIPAL CHARACTERISTICS

- Economical, general-purpose maintenance and new-building primer
- Suitable for use on superstructures and on steel surfaces not normally exposed to water immersion
- The adhesion of subsequent coats is not affected by long weathering periods of the primer
- Should not be used over zinc primers, except when exposed to dry interior conditions
- To be recoated with conventional paint systems
- A thickness of 75 µm (3.0 mils) can be obtained by spray application in one operation by means of the cross-coat technique

## COLOR AND GLOSS LEVEL

- Yellow, brown, red, gray, dark gray (offwhite only on request)
- Flat

## BASIC DATA AT 20°C (68°F)

Data for product	
Number of components	One
Mass density	1.4 kg/l (11.7 lb/US gal)
Volume solids	56 ± 2%
VOC (Supplied)	Directive 2010/75/EU, SED: max. 245.0 g/kg max. 343.0 g/l (approx. 2.9 lb/US gal) China GB 38469-2019 (tested) 379.0 g/l (approx. 3.2 lb/gal)
Recommended dry film thickness	35 - 75 µm (1.4 - 3.0 mils) per coat
Theoretical spreading rate	16.0 m <sup>2</sup> /l for 35 µm (642 ft <sup>2</sup> /US gal for 1.4 mils) 7.5 m <sup>2</sup> /l for 75 µm (299 ft <sup>2</sup> /US gal for 3.0 mils)
Dry to touch	2 hours
Overcoating Interval	Minimum: 24 hours Maximum: Unlimited
Shelf life	At least 24 months when stored cool and dry

### Notes:

- See ADDITIONAL DATA - Spreading rate and film thickness
- See ADDITIONAL DATA - Curing time

# SIGMARINE™ 24

## RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

### Substrate conditions

- Steel; blast cleaned to ISO-Sa2½, blasting profile 40 – 70 µm (1.6 – 2.8 mils)
- Steel; power tool cleaned to min. ISO-St2
- Shop primed steel; sweep blasted or power tool cleaned to SPSS-Ss or SPSS-Pt2
- Previous coat must be dry and free from any contamination

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### Substrate temperature and application conditions

- Substrate temperature during application should not exceed 50°C (122°F)
- Substrate temperature during application should be at least 3°C (5°F) above dew point

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## SYSTEM SPECIFICATION

- SYSTEMS FOR BOOTTOP AND TOPSIDE – SYSTEM SHEET 3102
- SYSTEMS FOR DECKS – SYSTEM SHEET 3103
- SYSTEMS FOR SUPERSTRUCTURE AND DECK FITTINGS – SYSTEM SHEET 3104
- SYSTEMS FOR INTERIOR(S) – SYSTEM SHEET 3105

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## INSTRUCTIONS FOR USE

- Stir well before use
- The temperature of the paint should preferably be above 15°C (59°F), otherwise extra thinner may be required to obtain application viscosity
- Adding too much thinner results in reduced sag resistance
- Adequate ventilation must be maintained during application and curing (please refer to INFORMATION SHEETS 1433 and 1434)

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### Airless spray

#### **Recommended thinner**

THINNER 20-05

#### **Volume of thinner**

0 - 3%, depending on required thickness and application conditions

#### **Nozzle orifice**

Approx. 0.43 – 0.48 mm (0.017 – 0.019 in)

#### **Nozzle pressure**

12.0 - 15.0 MPa (approx. 120 - 150 bar; 1741 - 2176 p.s.i.)

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# SIGMARINE™ 24

## Brush/roller

### Recommended thinner

THINNER 20-05

### Volume of thinner

0 - 2%

## Cleaning solvent

THINNER 20-05

## ADDITIONAL DATA

Spreading rate and film thickness	
DFT	Theoretical spreading rate
35 µm (1.4 mils)	16.0 m <sup>2</sup> /l (642 ft <sup>2</sup> /US gal)
75 µm (3.0 mils)	7.5 m <sup>2</sup> /l (299 ft <sup>2</sup> /US gal)

Overcoating interval for DFT up to 75 µm (3.0 mils)				
Overcoating with...	Interval	5°C (41°F)	20°C (68°F)	35°C (95°F)
Itself, SIGMARINE 48, SIGMADUR ONE	Minimum	48 hours	24 hours	10 hours
	Maximum	Unlimited	Unlimited	Unlimited

Note: Surface should be dry and free from chalking and contamination

Curing time for DFT up to 75 µm (3.0 mils)	
Substrate temperature	Dry to touch
5°C (41°F)	3 hours
20°C (68°F)	2 hours

## SAFETY PRECAUTIONS

- For paint and recommended thinners see INFORMATION SHEETS 1430, 1431 and relevant Material Safety Data Sheets
- This is a solvent-borne paint and care should be taken to avoid inhalation of spray mist or vapor, as well as contact between the wet paint and exposed skin or eyes

## WORLDWIDE AVAILABILITY

It is always the aim of PPG Protective and Marine Coatings to supply the same product on a worldwide basis. However, 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.



# SIGMARINE™ 24

## REFERENCES

• CONVERSION TABLES	INFORMATION SHEET	1410
• EXPLANATION TO PRODUCT DATA SHEETS	INFORMATION SHEET	1411
• SAFETY INDICATIONS	INFORMATION SHEET	1430
• SAFETY IN CONFINED SPACES AND HEALTH SAFETY, EXPLOSION HAZARD – TOXIC HAZARD	INFORMATION SHEET	1431
• SAFE WORKING IN CONFINED SPACES	INFORMATION SHEET	1433
• DIRECTIVES FOR VENTILATION PRACTICE	INFORMATION SHEET	1434
• CLEANING OF STEEL AND REMOVAL OF RUST	INFORMATION SHEET	1490
• SPECIFICATION FOR MINERAL ABRASIVES	INFORMATION SHEET	1491
• RELATIVE HUMIDITY – SUBSTRATE TEMPERATURE – AIR TEMPERATURE	INFORMATION SHEET	1650

## WARRANTY

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