

A two sheet issue

DESCRIPTION	two component polyamide cured corrosion inhibiting epoxy primer
PRINCIPAL CHARACTERISTICS	<ul style="list-style-type: none"> - general purpose primer used in protective coating systems for immersion and atmospheric exposure conditions - good adhesion to steel and galvanized steel - good adhesion to non ferrous metals - good flow and wetting properties - good water and corrosion resistance - cures at temperatures as low as 5 °C - suitable for touching up of weld seams and damaged epoxy primers during construction - long recoating intervals are possible when overcoating with epoxy and polyurethane coatings - can be overcoated with alkyd, chlorinated rubber, vinyl, epoxy and polyurethane coatings - suitable for application to <u>wet</u> or <u>dry</u> abrasive cleaned substrates - tolerant to a damp steel surface - compatible with cathodic protection systems - can be used in conjunction with Sigma Wet Blast Inhibitor
COLOUR AND GLOSS	red-brown and green – eggshell
BASIC DATA AT 20 °C	(for mixed product)
Mass density	approx. 1.4g/cm ³
Solids content	approx. 57% by volume
Recommended dry film thickness	50 - 125 µm
Theoretical spreading rate	11.4 m ² /ltr for 50 µm* depending on the nature and condition of the substrate and the application method employed
Touch dry after	approx. 30 minutes
Overcoating interval	min. 8 hours* max. 3 - 6 months*
Full cure after	7 days*
Shelf life (cool,dry place)	12 months
Flashpoint	base and hardener - 26 °C
Available pack size	1 ltr, 5 ltr, 20 ltr
*see additional data	please turn

RECOMMENDED SUBSTRATE CONDITIONS

for immersion exposure

- steel; blast cleaned (dry or wet) to ISO Sa2½
- steel with approved zinc silicate shop primer; pretreated according to SPSS-Ss

for atmospheric exposure

- steel; pretreated to ISO-Sa2½ or ISO-St3
- shop primed steel; pretreated according to SPSS-Pt3
- galvanized steel; free from grease, salts and other contamination, preferably blast cleaned to (Rz) 30 µm
- substrate temperature should be above 5 °C and at least 3 °C above the dew point during application and curing

INSTRUCTIONS FOR USE

- mixing ratio: by volume; base to hardener 80 : 20
- the temperature of the mixed base and hardener should be above 15 °C, otherwise extra solvent may be required to obtain the correct application viscosity
- too much solvent will result in lower sag resistance and slower cure
- thinner should only be added after proper mixing of the base and hardener

Induction time at 20 °C

none

Potlife at 20 °C

8 hours*

METHOD OF APPLICATION

AIRLESS SPRAY

Recommended thinner

91-92 (flashpoint 20 °C)

Volume of thinner

0 - 5% for 75 - 125 µm - 10 - 25% for 50 - 75 µm

Nozzle orifice

approx. 0.46 mm (0.018 inch)

Nozzle pressure

150 bar (approx. 2100 p.s.i.)

AIR SPRAY

Recommended thinner

91-92 (flashpoint 20 °C)

Volume of thinner

5 - 10%

Nozzle orifice

1.5 - 2.0 mm

Nozzle pressure

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

BRUSH AND ROLLER

Recommended thinner

91-92 (flashpoint 20 °C)

Volume of thinner

0 - 5%

CLEANING SOLVENT

90-53 (flashpoint 30 °C)

see sheet two

Sheet two

**SAFETY
PRECAUTIONS**



see safety sheet 1570 for information on LEL and TLV values

ADDITIONAL DATA

Film thickness and spreading rate

Dry film thickness in microns (µm)	75	100
Theoretical spreading rate (m²/l)	7.6	5.7

Maximum dft without sagging with airless spray: 250 µm

Minimum dft for closed film with airless spray: 30 µm

Maximum dft for brush application: 50 µm

Note: maximum dft is for overlap areas only

overcoating table for Sigmacover TCP coating, Sigma TCN 300, epoxy and polyurethane paints used for immersion service

Substrate temperature	5 °C	10 °C	15 °C	20 °C	30 °C	40 °C
Minimum interval	36 hours	16 hours	10 hours	8 hours	6 hours	4 hours
Maximum interval when <u>not</u> exposed to daylight	6 months	6 months	6 months	6 months	4 months	3 months
Maximum interval when exposed to daylight	3 months	3 months	3 months	3 months	2 months	2 months

please turn

Overcoating table for Sigmacover CM Coating, chlorinated rubber, vinyl and alkyd paints used for atmospheric exposure

substrate temperature	5 °C	10 °C	15 °C	20 °C	30 °C	40 °C
minimum interval	16 hours	10 hours	6 hours	5 hours	3 hours	2 hours
maximum interval	21 days	21 days	14 days	10 days	7 days	7 days

figures contained in above are valid for a dft of approx. 50 µm substrate should be free from chalking and contamination

Curing table

Substrate temperature	Touch Dry	Dry to handle	Full cure
5 °C	120 min.	6 hours	18 days
10 °C	60 min.	4 hours	12 hours
15 °C	45 min.	3 hours	7 days
20 °C	30 min.	2 hours	5 days
30 °C	20 min.	1 hour	4 days

Potlife at application Viscosity

Paint temperature	Pot life
15 °C	12 hours
20 °C	8 hours
25 °C	6 hours
30 °C	5 hours
35 °C	4 hours

REFERENCES

explanation to product data sheets on information sheet 1551