

A two sheet issue

<b>DESCRIPTION</b>	two component chemical resistant multipurpose coating based on polyamide cured epoxy resins for a wide range of non immersed substrate types
<b>PRINCIPAL CHARACTERISTICS</b>	<ul style="list-style-type: none"> <li>- general multi purpose coating</li> <li>- can be used as primer and buildcoat and finish as part of a concrete flooring system; see sheet 1561</li> <li>- good flow properties</li> <li>- easy to apply by spray, roller and brush</li> <li>- good water resistance</li> <li>- resistant to splash and spillage of mild chemicals and solvents</li> <li>- good abrasion and impact resistance</li> <li>- can be given non skid properties by the addition of quartz sand added to the second coat whilst still wet</li> <li>- easy to clean</li> </ul>
<b>COLOUR AND GLOSS</b>	see Sigma P.C. colour card – gloss
<b>BASIC DATA AT 20 °C</b>	( for mixed product )
<b>Mass density</b>	approx. 1.4g/cm <sup>3</sup>
<b>Solids content</b>	approx. 53% by volume
<b>Recommended dry film thickness</b>	50 - 100 µm
<b>Theoretical spreading rate</b>	6.6 m <sup>2</sup> /ltr for a dft of 80 µm* depending on the nature and condition of the substrate and the application method employed
<b>Touch dry after</b>	approx. 3 hours
<b>Overcoating interval</b>	min. 10 hours* max. 3 months*
<b>Full cure after</b>	7 days
<b>Shelf life (cool,dry place)</b>	12 months
<b>Flashpoint</b>	base 27 °C - hardener 28 °C
<b>Available pack size</b>	5 ltr, 20 ltr
*see additional data	please turn

## RECOMMENDED SUBSTRATE CONDITIONS

- previous coat of epoxy primer or buildcoat within overcoating interval and free from any contamination
- if previous coat is exposed longer it should be roughened prior to application of next coat
- substrate temperature should be above 5 °C and at least 3 °C above the dew point

## INSTRUCTIONS FOR USE

- mixing ratio: by volume; base to hardener 76 : 24
- 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** 10 minutes

**Potlife at 20 °C** 8 hours\*

## METHOD OF APPLICATION

### AIRLESS SPRAY

**Recommended thinner** 91-92 (flashpoint 20 °C)  
**Volume of thinner** 5 - 10%  
**Nozzle orifice** approx. 0.48 mm (0.019 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- 3.0 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

<b>Dry film thickness in microns (µm)</b>	50	80	100
<b>Theoretical spreading rate (m<sup>2</sup>/l)</b>	10.6	6.6	5.3

Maximum dft without sagging with airless spray: 160 µm

Minimum dft for closed film with airless spray: 60 µm

Maximum dft for brush application: 70 µm

**Note: maximum dft is for overlap areas only**

### Overcoating table with epoxy paint

<b>Substrate temperature</b>	20 °C	30 °C	40 °C
<b>Minimum interval</b>	8 hours	6 hours	5 hours
<b>Maximum interval</b>	3 months	2 months	1 month

substrate should be free from chalking and contamination

### Curing table

<b>Substrate temperature</b>	<b>Dry to handle</b>	<b>Full cure</b>
20 °C	18 hours	7 days
30 °C	12 hours	5 days
40 °C	8 hours	3 days

### Potlife at application viscosity; these figures are valid for approx. 5 ltr

<b>Paint temperature</b>	<b>Pot life</b>
20 °C	8 hours
30 °C	6 hours
40 °C	4 hours

## REFERENCES

explanation to product data sheets on information sheet 1551