

SIGMAFAST™ 155 Y

DESCRIPTION

Two-component, high solids, zinc phosphate epoxy primer and buildcoat

PRINCIPAL CHARACTERISTICS

- General-purpose epoxy primer/coating for atmospheric conditions
- Can be specified as a single coat, direct-to-metal system for ISO 12944 C1 and C2 environments
- Corrosion prevention based on inhibitive anti-corrosive pigments
- Good adhesion to steel
- Good recoatability with epoxy and polyurethane paints
- Can be applied by airless spray, roller and brush

COLOR AND GLOSS LEVEL

- Gray (redbrown on request)
- Eggshell

BASIC DATA AT 20°C (68°F)

Data for mixed product	
Number of components	Two
Mass density	1.4 kg/l (11.7 lb/US gal), depending on color
Volume solids	70 ± 2%
VOC (Supplied)	EPA Method 24: 240.0 g/ltr (2.0 lb/USgal)
Recommended dry film thickness	50 - 150 µm (2.0 - 6.0 mils) depending on system
Theoretical spreading rate	14.0 m ² /l for 50 µm (561 ft ² /US gal for 2.0 mils)
Dry to touch	3 hours
Overcoating Interval	Minimum: 8 hours Maximum: Unlimited
Full cure after	10 days
Shelf life	Base: at least 12 months when stored cool and dry Hardener: at least 12 months when stored cool and dry

Notes:

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

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

Substrate conditions

- Steel; pretreated preferably to ISO-Sa2½, , blasting profile 30 - 75 µm (1.2 - 3.0 mils) or according to ISO-St3



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Substrate temperature

- Substrate temperature during application and curing should be above 5°C (41°F)
 - Substrate temperature during application and curing should be at least 3°C (5°F) above dew point
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INSTRUCTIONS FOR USE

Mixing ratio by volume: base to hardener 80:20 (4:1)

- 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 and slower cure
 - Thinner should be added after mixing the components
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Induction time

None

Pot life

4 hours at 20°C (68°F)

Note: See ADDITIONAL DATA – Pot life

Air spray

Recommended thinner

THINNER 91-92

Volume of thinner

5 - 15%

Nozzle orifice

1.5 – 3.0 mm (approx. 0.060 – 0.110 in)

Nozzle pressure

0.2 - 0.3 MPa (approx. 3 - 4 bar; 35 - 48 p.s.i.)



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Airless spray

Recommended thinner

THINNER 91-92

Volume of thinner

5 - 10%

Nozzle orifice

Approx. 0.43 – 0.53 mm (0.017 – 0.021 in)

Nozzle pressure

15.0 MPa (approx. 150 bar; 2176 p.s.i.)

Brush/roller

Recommended thinner

THINNER 91-92

Volume of thinner

0 - 3%

Cleaning solvent

THINNER 90-53

ADDITIONAL DATA

Spreading rate and film thickness	
DFT	Theoretical spreading rate
50 µm (2.0 mils)	14.0 m ² /l (561 ft ² /US gal)
100 µm (4.0 mils)	7.0 m ² /l (281 ft ² /US gal)
150 µm (6.0 mils)	4.7 m ² /l (187 ft ² /US gal)

Overcoating interval for DFT up to 150 µm (6.0 mils)				
Overcoating with...	Interval	20°C (68°F)	30°C (86°F)	40°C (104°F)
various two-pack epoxy and polyurethane coatings	Minimum	8 hours	4 hours	2.5 hours
	Maximum	Unlimited	Unlimited	Unlimited

Notes:

- Surface should be dry and free from any contamination
- Alkyd finishes require a suitable undercoat

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Curing time for DFT up to 150 µm (6.0 mils)		
Substrate temperature	Dry to touch	Full cure
20°C (68°F)	3 hours	10 days
30°C (86°F)	2 hours	6 days
40°C (104°F)	1 hour	3 days

Note: Adequate ventilation must be maintained during application and curing (please refer to INFORMATION SHEETS 1433 and 1434)

Pot life (at application viscosity)	
Mixed product temperature	Pot life
20°C (68°F)	4 hours
30°C (86°F)	2 hours
40°C (104°F)	less than 1 hour

SAFETY PRECAUTIONS

- 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.

REFERENCES

• 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

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