

# SIGMACAP 620 ZP

## DESCRIPTION

Two-component, surface tolerant, zinc phosphate and aluminium pigmented high-build polyamide cured epoxy coating

## PRINCIPAL CHARACTERISTICS

- Excellent corrosion resistance
- Good flexibility
- Surface tolerant coating for lower grade of steel preparation
- Good drying and curing property
- Easy application by different application methods such as airless spray, brush etc.

## COLOR AND GLOSS LEVEL

- Aluminum colors (dark gray, light gray)
- Eggshell

## BASIC DATA AT 20°C (68°F)

Data for mixed product	
Number of components	Two
Mass density	1.5 kg/l (12.5 lb/US gal)
Volume solids	80 ± 2%
VOC (Supplied)	Directive 2010/75/EU, SED: max. 150.0 g/kg UK PG 6/23(92) Appendix 3: max. 225.0 g/l (approx. 1.9 lb/US gal)
Recommended dry film thickness	75 - 200 µm (3.0 - 8.0 mils) depending on system
Theoretical spreading rate	6.4 m <sup>2</sup> /l for 125 µm (257 ft <sup>2</sup> /US gal for 5.0 mils)
Dry to touch	3 hours
Overcoating Interval	Minimum: 8 hours Maximum: 6 months
Full cure after	7 days
Shelf life	Base: at least 24 months when stored cool and dry Hardener: at least 24 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

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## RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

### Steel

- Steel; blast cleaned to ISO-Sa2½ for excellent corrosion protection
- Steel; blast cleaned to ISO-Sa2 or power tool cleaned to ISO-St2 for good corrosion protection
- Shop primed steel; pretreated to SPSS-Pt2
- Galvanized steel; sweep blasted to roughen the surface and to remove any zinc salts which might be present

### 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

## INSTRUCTIONS FOR USE

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

- The temperature of the mixed base and hardener 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

### Induction time

Mixed product induction time	
Mixed product temperature	Induction time
Above 10°C (50°F)	None

### Pot life

4 hours at 20°C (68°F)

Note: See ADDITIONAL DATA – Pot life

### Airless spray

#### Recommended thinner

THINNER 91-92

#### Volume of thinner

0 - 10%, depending on required thickness and application conditions

#### Nozzle orifice

Approx. 0.46 – 0.53 mm (0.018 – 0.021 in)

#### Nozzle pressure

20.0 - 25.0 MPa (approx. 200 - 250 bar; 2901 - 3626 p.s.i.)



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### Brush/roller

- Application by roller will leave roller marking and is suitable for minimum DFT requirements only
- A roller suitable for epoxy application must be used

### Recommended thinner

THINNER 91-92

### Volume of thinner

0 - 5%

### Cleaning solvent

THINNER 90-53

## ADDITIONAL DATA

Spreading rate and film thickness	
DFT	Theoretical spreading rate
75 µm (3.0 mils)	10.7 m <sup>2</sup> /l (428 ft <sup>2</sup> /US gal)
100 µm (4.0 mils)	8.0 m <sup>2</sup> /l (321 ft <sup>2</sup> /US gal)
125 µm (5.0 mils)	6.4 m <sup>2</sup> /l (257 ft <sup>2</sup> /US gal)
150 µm (6.0 mils)	5.3 m <sup>2</sup> /l (214 ft <sup>2</sup> /US gal)
200 µm (8.0 mils)	4.0 m <sup>2</sup> /l (160 ft <sup>2</sup> /US gal)

Overcoating interval for DFT up to 125 µm (5.0 mils)						
Overcoating with...	Interval	5°C (41°F)	10°C (50°F)	20°C (68°F)	30°C (86°F)	40°C (104°F)
various two-pack epoxy and polyurethane coatings	Minimum	48 hours	24 hours	8 hours	4 hours	2 hours
	Maximum exposed to direct sunshine	3 months	3 months	3 months	3 months	3 months
	Maximum NOT exposed to direct sunshine	6 months	6 months	6 months	6 months	6 months

Note: Surface should be dry and free from any contamination and sufficiently roughened after long exposure

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Curing time for DFT up to 125 µm (5.0 mils)			
Substrate temperature	Dry to touch	Dry to handle	Full cure
5°C (41°F)	24 hours	48 hours	20 days
10°C (50°F)	12 hours	24 hours	14 days
20°C (68°F)	3 hours	8 hours	7 days
30°C (86°F)	2 hours	6 hours	4 days
40°C (104°F)	1 hour	3 hours	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
10°C (50°F)	10 hours
15°C (59°F)	6 hours
20°C (68°F)	4 hours
30°C (86°F)	2 hours
40°C (104°F)	1 hour

## 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.

## 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



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