

SIGMAFAST 40

3 pages

September 2009
Revision of June 2007

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| DESCRIPTION | high build finish coating, based on modified alkyd resin |
| PRINCIPAL CHARACTERISTICS | <ul style="list-style-type: none"> - suitable for atmospheric exposure conditions - fast drying - fast handling - good gloss and colour retention - not suitable for immersion in water |
| COLOURS AND GLOSS | RAL colours (other colours available on request) - semigloss |
| BASIC DATA AT 20°C | (1 g/cm ³ = 8.25 lb/US gal; 1 m ² /l = 40.7 ft ² /US gal) |
| Mass density | 1.3 g/cm ³ |
| Volume solids | 45 ± 2% |
| VOC (supplied) | max. 390 g/kg (Directive 1999/13/EC, SED) max. 490 g/l (approx. 4.1 lb/gal) |
| Recommended dry film thickness | 50 µm per coat |
| Theoretical spreading rate | 9.0 m ² /l for 50 µm |
| Touch dry after | 45 min. |
| Overcoating interval | min. 4 hours for 50 µm dft max. unlimited at higher dft's drying time will be longer |
| Shelf life (cool and dry place) | at least 24 months |
| RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES | <ul style="list-style-type: none"> - previous suitable coat; (e.g. SigmaFast 20) dry and free from any contamination - old existing sound coating; sufficiently roughened, dry and cleaned - substrate temperature should be above 5°C and at least 3°C above dew point |
| INSTRUCTIONS FOR USE | <ul style="list-style-type: none"> - stir well before use - the temperature of the paint should preferably be above 15°C, otherwise extra thinner may be required to obtain application viscosity - too much solvent results in reduced sag resistance - adequate ventilation must be maintained during application and curing (please refer to sheets 1433 and 1434) |
| AIRLESS SPRAY | |
| Recommended thinner | Thinner 21-06 |
| Volume of thinner | 0 - 5%, depending on required thickness and application conditions |
| Nozzle orifice | approx. 0.38 - 0.48 mm (= 0.015 - 0.019 in) |
| Nozzle pressure | 12 - 16 MPa (= approx. 120 - 160 bar; 1700 - 2270 p.s.i.) |

SIGMAFAST 40

September 2009

AIR SPRAY

Recommended thinner Thinner 21-06
 Volume of thinner 5 - 10%, depending on required thickness and application conditions
 Nozzle orifice 1.5 - 2 mm
 Nozzle pressure 0.3 - 0.4 MPa (= approx. 3 - 4 bar; 43 - 57 p.s.i.)

BRUSH/ROLLER

Recommended thinner Thinner 20-05
 Volume of thinner 0 - 2%

CLEANING SOLVENT

Thinner 21-06

SAFETY PRECAUTIONS

for paint and recommended thinners see safety 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 vapour as well as contact between the wet paint and exposed skin or eyes

ADDITIONAL DATA

Overcoating table for SigmaFast 40 for dft up to 50 µm

with itself

| substrate temperature | 10°C | 15°C | 20°C | 30°C |
|-----------------------|-----------|-----------|-----------|-----------|
| minimum interval | 8 hours | 6 hours | 4 hours | 3 hours |
| maximum interval | unlimited | unlimited | unlimited | unlimited |

– surface should be dry and free from any contamination

Worldwide availability

Whilst it is always the aim of PPG Protective & Marine Coatings to supply the same product on a worldwide basis, 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 see information sheet 1411
 Safety indications see information sheet 1430
 Safety in confined spaces and health safety
 Explosion hazard - toxic hazard see information sheet 1431
 Safe working in confined spaces see information sheet 1433
 Directives for ventilation practice see information sheet 1434

SIGMAFAST 40

September 2009

LIMITATION OF LIABILITY

The information in this data sheet is based upon laboratory tests we believe to be accurate and is intended for guidance only. All recommendations or suggestions relating to the use of the Sigma Coatings products made by PPG Protective & Marine Coatings, whether in technical documentation, or in response to a specific enquiry, or otherwise, are based on data which to the best of our knowledge are reliable. The products and information are designed for users having the requisite knowledge and industrial skills and it is the end-user's responsibility to determine the suitability of the product for its intended use.

PPG Protective & Marine Coatings has no control over either the quality or condition of the substrate, or the many factors affecting the use and application of the product. PPG Protective & Marine Coatings does therefore not accept any liability arising from loss, injury or damage resulting from such use or the contents of this data sheet (unless there are written agreements stating otherwise).

The data contained herein are liable to modification as a result of practical experience and continuous product development.

This data sheet replaces and annuls all previous issues and it is therefore the user's responsibility to ensure that this sheet is current prior to using the product.

The English text of this document shall prevail over any translation thereof.

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| | PDS | 7234 |
| 235941 | base L | 0710002197 |
| 235942 | base L | 0710001492 |
| 235289 | base Z | 0070002179 |
| 235290 | base Z | 0070001448 |