

SIGMAFAST 45

3 pages

September 2009
Revision of September 2005

DESCRIPTION	fast drying finish, based on modified alkyd resin
PRINCIPAL CHARACTERISTICS	<ul style="list-style-type: none"> - suitable for atmospheric exposure conditions - good gloss and colour retention - fast drying - fast handling
COLOURS AND GLOSS	RAL colours - gloss
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	1.1 g/cm ³
Volume solids	44 ± 2%
VOC (supplied)	max. 468 g/kg (Directive 1999/13/EC, SED) max. 506 g/l (approx. 4.2 lb/gal)
Recommended dry film thickness	35 - 50 µm per coat
Theoretical spreading rate	12.6 m ² /l for 35 µm, 8.8 m ² /l for 50 µm
Touch dry after	1.5 hour
Overcoating interval	min. 8 hours for 35 µm dft at higher dft's drying time will be longer
Shelf life (cool and dry place)	at least 12 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 must be above 5°C and at least 3°C above dew point during application and curing
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	approx. 10%, depending on required thickness and application conditions
Nozzle orifice	approx. 0.33 - 0.38 mm (= 0.013 - 0.015 in)
Nozzle pressure	12 - 16 MPa (= approx. 120 - 160 bar; 1700 - 2270 p.s.i.)
AIR SPRAY	
Recommended thinner	Thinner 21-06
Volume of thinner	25%, depending on required thickness and application conditions
Nozzle orifice	approx. 1.4 - 2.0 mm
Nozzle pressure	0.3 - 0.4 MPa (= approx. 3 - 4 bar; 43 - 57 p.s.i.)

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BRUSH/ROLLER

Recommended thinner no thinner should be added

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 45 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

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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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