SIGMA ZINC CHROMATE SA 40

DESCRIPTION
anti corrosion and adhesion primer for steel, based on modified alkyd resin

PRINCIPAL CHARACTERISTICS
- suitable for internal and external use
- excellent anticorrosive properties
- good flow properties
- sustained dry heat resistance up to 120°C and up to 180°C for short periods
- good adhesion to cold rolled steel and pretreated aluminium
- lead free
- easy to apply

COLOURS AND GLOSS
red brown – eggshell

BASIC DATA AT 20°C
(1 g/cm³ = 8.25 lb/US gal; 1 m³/l = 40.7 ft³/US gal)
Mass density
1.4 g/cm³
Volume solids
55± 2%
VOC (supplied)
max. 343 g/l (approx. 2.9 lb/gal)
Recommended dry film thickness
35 µm per coat
Theoretical spreading rate
15.7m²/l for 35 µm
Touch dry after
2 hours at 20°C
Overcoating interval
min. 24 hours at 20°C
max. unlimited
Shelf life (cool and dry place)
at least 12 months

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES
- steel; blast cleaned to ISO-Sa2½
- steel; power tool cleaned to min. ISO-St2
- shop primed steel; sweep blasted or power tool cleaned to SPSS-Ss or SPSS-Pt2
- compatible previous coat; dry and free from any contamination
- substrate temperature should be above 5°C and at least 3°C above dew point

SYSTEM SPECIFICATION
- to be used as a first coat in an alkyd system
- best anticorrosive qualities will be obtained if applied in two coats

INSTRUCTIONS FOR USE
- 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 sheet 1433 and 1434)
AIRLESS SPRAY
Recommended thinner  Sigma thinner 20-05
Volume of thinner  0 - 3%, depending on required thickness and application conditions
Nozzle orifice  approx. 0.43 - 0.48 mm (= 0.017 - 0.019 in)
Nozzle pressure  12 - 15 MPa (= approx. 120 - 150 bar; 1700 - 2130 p.s.i.)

BRUSH/ROLLER
Recommended thinner  Sigma thinner 20-05
Volume of thinner  0 - 3%

CLEANING SOLVENT
Sigma thinner 20-05

SAFETY PRECAUTIONS
for paint and recommended thinners see safety sheets 1430, 1431 and relevant material safety data sheets
this is a solvent based 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

Worldwide availability
Whilst it is always the aim of Sigma 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.
This product is not part of the Sigma Coatings global range and availability is depending on location.

REFERENCES
Explanation to product data sheets  see information sheet 1411
Safety indications  see information sheet 1430
Safety in confined spaces and health safety  see information sheet 1431
Explosion hazard - toxic hazard  see information sheet 1433
Safe working in confined spaces  see information sheet 1434
Directives for ventilation practice  see information sheet 1490
Cleaning of steel and removal of rust  see information sheet 1490

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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.
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DS 0601
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