SIGMAZAM AFD PRIMER

3 pages

May 2008
Revision of December 2000

DESCRIPTION

very quick drying primer for steel based on modified short oil alkyd resins pigmented with red iron oxide and zinc phosphate

PRINCIPAL CHARACTERISTICS

- for interior and exterior use
- good corrosion preventing properties
- lead free
- can be dip applied
- can be applied with automatic spray equipment
- can be overcoated with solvent based alkyd, acrylic and chlorinated rubber based paint

COLOURS AND GLOSS

red and grey – flat

BASIC DATA AT 20°C

(1 g/cm³ = 8.25 lb/US gal; 1 m²/l = 40.7 ft²/US gal)

Mass density	approx. 1.33g/cm³
Volume solids	approx. 38% by volume
Recommended dry film thickness	35 µm
Theoretical spreading rate	approx. 11 m²/ltr (42 m²/usg) for 35 µm (depending on the nature and condition of the substrate and the application method employed)
Touch dry after	approx. 10 minutes (3 - 5 minutes at 40 °C)
Overcoating interval	min. 4 hours max. no limitation
Shelf life (cool and dry place)	at least 12 months

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

- steel should be free from oil, grease and any other contamination.
- steel; for best performance blast cleaned to ISO-Sa2½
- steel; mechanically cleaned to remove loose scale and surface rust, for good performance 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

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 21-06, 21-04 or Sigmazam reducer
Volume of thinner	0-20%
Nozzle orifice	approx. 0.43 - 0.48 mm (0.017 -0.019 inch)
Nozzle pressure	120-150 bar (1700 - 2100 p.s.i.)

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AIR SPRAY

Recommended thinner	Sigma thinner 21-06, 21-04 or Sigmazam reducer
Volume of thinner	5-20%
Nozzle orifice approx.	1.5 - 2.0 mm
Nozzle pressure	3 - 4 bar (approx. 43 - 57 p.s.i.)

BRUSH/ROLLER **not recomended**

DIPPING

Recommended thinner	Sigma thinner 21-04
Volume of Thinner	20-25% (depending on application line conditions)

CLEANING SOLVENT Sigma 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 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	
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
Cleaning of steel and removal of rust	see information sheet 1490

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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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Sigma Paints Saudi Arabia Ltd