

# SIGMACAP FAST DRY 21

2 pages

July 2010

<b>DESCRIPTION</b>	quick drying, modified alkyd, zinc phosphate primer for structural steel
<b>PRINCIPAL CHARACTERISTICS</b>	<ul style="list-style-type: none"> <li>- fast drying, quick handling</li> <li>- recommended for electrostatic spray</li> <li>- good anticorrosive properties</li> <li>- recoatable with various alkyd products</li> <li>- summer and winter grade thinners available</li> <li>- suitable for atmospheric exposure conditions</li> </ul>
<b>COLOURS AND GLOSS</b>	redbrown - flat
<b>BASIC DATA AT 20°C</b>	(1 g/cm <sup>3</sup> = 8.25 lb/US gal; 1 m <sup>2</sup> /l = 40.7 ft <sup>2</sup> /US gal)
Mass density	1.4 g/cm <sup>3</sup>
Volume solids	40 ± 2%
VOC (supplied)	max. 550 g/l (approx. 4.6 lb/gal) (depending on shade)
Recommended dry film thickness	50-100 µm per coat
Theoretical spreading rate	8 m <sup>2</sup> /l for 50 µm
Touch dry after	20 min. at 20°C for 50µm
Dry to handle	30 min. at 20°C, less than 10 min at 40°C, for 50µm
Overcoating interval	min. 30 minutes max. unlimited
Shelf life (cool and dry place)	at least 12 months
Flash point	40°C
<b>RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES</b>	<ul style="list-style-type: none"> <li>- steel; blast cleaned to ISO-Sa2½ or power tool cleaned to min. ISO-St3</li> <li>- substrate temperature should be above 5°C and at least 3°C above dew point</li> </ul>
<b>INSTRUCTIONS FOR USE</b>	<ul style="list-style-type: none"> <li>- stir well before use</li> <li>- the temperature of the paint should preferably be above 15°C, otherwise extra thinner may be required to obtain application viscosity</li> <li>- too much solvent results in reduced sag resistance</li> <li>- adequate ventilation must be maintained during application and curing (please refer to sheet 1433 and 1434)</li> </ul>
<b>ELECTROSTATIC SPRAY</b>	
Recommended thinner	Sigma thinner 21-06 (standard) Sigma thinner 21-22 (summer grade), Sigma thinner 21-04 (winter grade)
Volume of thinner	0 - 8%, 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.)
<b>AIR SPRAY</b>	
Recommended thinner	Sigma thinner 21-06 (standard) Sigma thinner 21-22 (summer grade), Sigma thinner 21-04 (winter grade)
Volume of thinner	5 - 10%, depending on required thickness and application conditions
Nozzle orifice approx.	1.7 - 2.0 mm
Nozzle pressure	0.2 - 0.3 MPa (= approx. 2 - 3 bar; 28 - 43 p.s.i.)

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<b>BRUSH/ROLLER</b>	(not recommended due to the fast drying nature of the product)
Recommended thinner	Sigma thinner 21-22 for electrostatic spray
Volume of thinner	0 - 3%
<b>CLEANING SOLVENT</b>	Sigma thinner 21-06 (preferred) or 90-53
<b>SAFETY PRECAUTIONS</b>	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

## ADDITIONAL DATA

paint type:

Sigma Fast dry alkyd products

### Overcoating table

substrate temperature	10°C	20°C	40°C
minimum interval	2hours	1 hour	20 minutes
maximum interval	unlimited, provided that the surface is dry and cleaned from any contamination		

## 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

## 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.

DS 7856  
Sigma Paints Saudi Arabia Ltd