

SIGMAGUARD 260

4 pages

April 2009
Revision of November 2008

DESCRIPTION	two component high build amine adduct cured phenolic epoxy holding primer	
PRINCIPAL CHARACTERISTICS	<ul style="list-style-type: none"> – holding primer for SigmaGuard CSF 650, Novaguard 840 and Novaguard 890 – can be applied and cures at temperatures down to +5°C – good application properties, resulting in a smooth surface – good abrasion resistance 	
COLOURS AND GLOSS	pink - eggshell	
BASIC DATA AT 20°C	(1 g/cm ³ = 8.25 lb/US gal; 1 m ² /l = 40.7 ft ² /US gal) (data for mixed product)	
Mass density	1.7 g/cm ³	
Volume solids	68 ± 2%	
VOC (supplied)	max. 194 g/kg (Directive 1999/13/EC, SED) max. 328 g/l (approx. 2.7 lb/gal)	
Recommended dry film thickness	75 µm *	
Theoretical spreading rate	9.1 m ² /l for 75 µm	
Touch dry after	2 - 3 hours at 20°C, 14 - 16 hours at 5°C	
Overcoating interval	min. 8 hours * max. 1 month *	
Full cure after	see curing table *	
	(data for components)	
Shelf life (cool and dry place)	at least 12 months * see additional data	
RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES	<ul style="list-style-type: none"> – steel; blast cleaned in situ to at least ISO-Sa2½ and free from rust, scale, shop primer and any other contamination – blasting profile 50 - 100 µm – the substrate must be perfectly dry before and during application of SigmaGuard 260 – substrate temperature must be above 5°C and at least 3°C above dew point during application and curing 	
SYSTEM SPECIFICATION	SigmaGuard 260	75 µm
INSTRUCTIONS FOR USE	mixing ratio by volume: base to hardener 87 : 13 <ul style="list-style-type: none"> – the temperature of the mixed base and hardener should preferably be above 15°C, otherwise extra solvent may be required to obtain application viscosity – too much solvent results in reduced sag resistance and slower cure – thinner should be added after mixing the components 	

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Induction time allow induction time before use
 5°C - 20 min.
 10°C - 15 min.
 15°C - 10 min.

Pot life 2 hours at 20°C *
 * see additional data

AIRLESS SPRAY

Recommended thinner Thinner 91-92
 Volume of thinner 5 - 10%, depending on required thickness and application conditions
 Nozzle orifice approx. 0.48 - 0.53 mm (= 0.019 - 0.021 in)
 Nozzle pressure 15 MPa (= approx. 150 bar; 2130 p.s.i.)

AIR SPRAY

Recommended thinner Thinner 91-92
 Volume of thinner 5 - 10%, depending on required thickness and application conditions
 Nozzle orifice 2 mm
 Nozzle pressure 0.3 MPa (= approx. 3 bar; 43 p.s.i.)

BRUSH

only for spot repair and stripe coating
 Recommended thinner Thinner 91-92
 Volume of thinner 0 - 5%

CLEANING SOLVENT

Thinner 90-53

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

Film thickness and spreading rate

theoretical spreading rate m ² /l	9.1	6.8
dft in µm	75	100

max. dft when brushing: 60 µm

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Overcoating table for SigmaGuard 260 for dft up to 75 µm

with SigmaGuard CSF 650,
Novaguard 840 or Novaguard 890

substrate temperature	5°C	10°C	15°C	20°C	30°C
minimum interval	24 hours	20 hours	14 hours	8 hours	5 hours
maximum interval when not exposed to sunshine	2 months	2 months	2 months	1 month	1 month

- surface should be dry and free from any contamination

Curing table for dft up to 75 µm

substrate temperature	dry to handle	full cure
5°C	20 hours	10 days
10°C	10 hours	7 days
20°C	3 hours	5 days
40°C	1 hour	3 days

- adequate ventilation must be maintained during application and curing (please refer to sheets 1433 and 1434)
- when used as a primer under solvent free tank-linings the dft must be limited to a maximum of 100 µm

Pot life (at application viscosity)

5°C	8 hours
10°C	6 hours
15°C	4 hours
20°C	2 hours
40°C	30 min.

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.

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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.

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