SIGMAGUARD 260

4 pages

April 2009
Revision of November 2008

DESCRIPTION

two component high build amine adduct cured phenolic epoxy holding primer

PRINCIPAL CHARACTERISTICS

- 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/cm³ = 8.25 lb/US gal; 1 m²/l = 40.7 ft²/US gal)
(data for mixed product)

Mass density	1.7 g/cm³
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 m²/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

- 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

- 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 m²/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

	PDS	7944
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