SIGMACAP PRIMER EP 7680

Two sheet issue June 2008

DESCRIPTION	general purpose two component high build polyamide cured epoxy primer
PRINCIPAL CHARACTERISTICS	- developed as an epoxy primer for steel and concrete structures in atmospheric exposure conditions - easy to apply - relatively long potlife at elevated temperatures - good corrosion resistance - resistant to splash and spillage of mild chemicals and solvents - good wetting properties
COLOUR AND GLOSS	red-brown - eggshell
BASIC DATA AT 20 °C	(for mixed product)
Mass density	approx. 1.4g/cm³
Solids content	approx. 63% by volume
VOC (supplied)	max. 346 g/l
Recommended dry film thickness	50 - 100 µm*
Theoretical spreading rate	12.6 m²/ltr for 50 µm*
Touch dry after	approx. 3 hours
Overcoating interval	min. 10 hours* max. 3 months*
Full cure after	4 days
Shelf life (cool, dry place)	at least 12 months
Flashpoint	base 27 °C - hardener 28 °C

***** see additional data

RECOMMENDED SUBSTRATE CONDITIONS	- concrete; dry and free from any contamination - steel; blast cleaned to ISO-Sa2½ or power tool cleaned to SPSS-Pt3 - substrate temperature must be above 5 °C and at least 3 °C above the dew point

please turn

SIGMACAP PRIMER EP 7680

June 2008

INSTRUCTIONS FOR USE

- mixing ratio: by volume; base to hardener 80 : 20
- the temperature of the mixed base and hardener should be above 15 °C, otherwise extra solvent may be required to obtain the correct application viscosity
- too much solvent will result in lower sag resistance and slower cure
- thinner should only be added after proper mixing of the base and hardener

Induction time at 20 °C none

Pot life at 20 °C 8 hours*

AIRLESS SPRAY

Recommended thinner Sigma thinner 91-92 (flashpoint 20 °C)
Volume of thinner 0 - 5%
Nozzle orifice approx. 0.48 mm (0.019 inch)
Nozzle pressure 150 bar (approx. 2100 p.s.i.)

AIR SPRAY

Recommended thinner Sigma thinner 91-92 (flashpoint 20 °C)
Volume of thinner 5 - 10%
Nozzle orifice 1.5 - 3.0 mm
Nozzle pressure 3 - 4 bar (approx. 43 - 57 p.s.i.)

BRUSH AND ROLLER

Recommended thinner Sigma thinner 91-92 (flashpoint 20 °C)
Volume of thinner 0 - 5%

CLEANING SOLVENT Sigma thinner 90-53 (flashpoint 30 °C)

SAFETY PRECAUTIONS

see safety sheets 1430, 1431 and MSDS 7680 for information on LEL and TLV values

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

Film thickness and spreading rate

Dry film thickness in microns (µm)	50	75	100
Theoretical spreading rate (m²/l)	12.6	8.4	6.3

Minimum dft for closed film with airless spray: 40 µm

Maximum dft for brush application: 50 µm

see sheet two

SIGMACAP PRIMER EP 7680

Sheet two June 2008

Overcoating table for the Sigma epoxy range

substrate temperature	20 °C	30 °C	40 °C
minimum interval	10 hours	8 hours	6 hours
maximum interval	3 months	2 months	1 month

Overcoating table for the Sigma Polyurethane range

substrate temperature	20 °C	30 °C	40 °C
minimum interval	24 hours	16 hours	12 hours
maximum interval	3 months	2 months	1 month

Curing table

Substrate temperature	**Dry to handle**	**Full cure**
20 °C	10 hours	4 days
30 °C	7 hours	3 days
40 °C	5 hours	2 days

adequate ventilation must be maintained during application and curing (refer sheets 1433 and 1434)

Pot life (at application viscosity)

Paint temperature	**Pot life**
20 °C	8 hours
30 °C	6 hours
40 °C	4 hours

REFERENCES explanation to product data sheets on information sheet 1411