

Two sheet issue

June 2008

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| <b>DESCRIPTION</b> |
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general purpose two component high build polyamide cured epoxy coating

|                                  |
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| <b>PRINCIPAL CHARACTERISTICS</b> |
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- developed as an epoxy coating 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 abrasion resistance

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| <b>COLOUR AND GLOSS</b> |
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off white - eggshell (other colours on request)

|                            |
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| <b>BASIC DATA AT 20 °C</b> |
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( for mixed product )

**Mass density**

approx. 1.4g/cm<sup>3</sup>

**Solids content**

approx. 61% by volume

**VOC (supplied)**

max. 343 g/l

**Recommended dry film thickness**

75 - 125 µm\*

**Theoretical spreading rate**

8.1 m<sup>2</sup>/ltr for 75 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

|   |
|---|
| <b>RECOMMENDED SUBSTRATE CONDITIONS</b> |
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- concrete; dry and free from any contamination
- previously painted substrate; epoxy primer or build coat or zinc silicate within overcoating interval and free from any contamination
- substrate temperature must be above 5 °C and at least 3 °C above the dew point

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## 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 7682 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**

|   |     |     |     |
|---|-----|-----|-----|
| <b>Dry film thickness in microns (µm)</b>           | 75  | 100 | 125 |
| <b>Theoretical spreading rate (m<sup>2</sup>/l)</b> | 8.1 | 6.1 | 4.9 |

Minimum dft for closed film with airless spray: 50 µm

Maximum dft for brush application: 60 µm

see sheet two

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**Overcoating table for the Sigma epoxy range**

|                              |          |          |         |
|------------------------------|----------|----------|---------|
| <b>substrate temperature</b> | 20 °C    | 30 °C    | 40 °C   |
| <b>minimum interval</b>      | 10 hours | 8 hours  | 6 hours |
| <b>maximum interval</b>      | 3 months | 2 months | 1 month |

**Overcoating table for the Sigma Polyurethane range**

|                              |          |          |          |
|------------------------------|----------|----------|----------|
| <b>substrate temperature</b> | 20 °C    | 30 °C    | 40 °C    |
| <b>minimum interval</b>      | 24 hours | 16 hours | 12 hours |
| <b>maximum interval</b>      | 3 months | 2 months | 1 month  |

**Curing table**

| <b>Substrate temperature</b> | <b>Dry to handle</b> | <b>Full cure</b> |
|------------------------------|----------------------|------------------|
| 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)**

| <b>Paint temperature</b> | <b>Pot life</b> |
|--------------------------|-----------------|
| 20 °C                    | 8 hours         |
| 30 °C                    | 6 hours         |
| 40 °C                    | 4 hours         |

**REFERENCES**

explanation to product data sheets on information sheet 1411

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