

# SIGMACOVER 410 - SG

3 pages

Jan 2010

<b>DESCRIPTION</b>	two component high solids, high build, polyamide cured epoxy coating
<b>PRINCIPAL CHARACTERISTICS</b>	<ul style="list-style-type: none"> <li>- general purpose epoxy build coat for protective coating atmospheric systems</li> <li>- can be specified as a single coat system in ISO12944 C1 and C2 environments, meets C4 system specification</li> <li>- corrosion prevention based on inhibitive anticorrosive pigments</li> <li>- good adhesion to (shop-primed) steel</li> <li>- good recoatability with epoxy and polyurethane topcoats</li> <li>- can be applied by airless spray, brushed or rolled</li> </ul>
<b>COLOURS AND GLOSS</b>	Selected color range and MIO - Semigloss
<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	approx. 1.5 - 1.9 g/cm <sup>3</sup>
Volume solids	approx. 80% by volume
Recommended dry film thickness	75 - 150 µm
Theoretical spreading rate	10.6 m <sup>2</sup> /ltr for 75 µm*
Touch dry after	approx. 3 hours min. at 20°C
Overcoating interval	min. 10 hours*
	max. up to 6 months*
Shelf life (cool and dry place)	at least 12 months
	*see additional data
<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 SPSS-Pt3</li> <li>- substrate temperature should be above 5°C and at least 3°C above dew point</li> </ul>
<b>INSTRUCTIONS FOR USE</b>	<p>Mixing ratio by volume: base to hardener 80 : 20</p> <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>- thinner should be added after mixing the components</li> <li>- 2.5 hours @ 20°C</li> </ul>
Pot Life	
<b>AIRLESS SPRAY</b>	
Recommended thinner	Sigma thinner 91-92
Volume of thinner	5-10% (more thinner may be required for minimal DFT)
Nozzle orifice	approx. 0.45 - 0.53 mm (0.018 - 0.021 inch)
Nozzle pressure	200-250 bar (approx. 2800 - 3500 p.s.i.)
<b>AIR SPRAY</b>	
Recommended thinner	Sigma thinner 91-92
Volume of thinner	5 - 15%
Nozzle orifice approx.	1.5 - 3 mm
Nozzle pressure	3 - 4 bar (approx. 43 - 57 p.s.i.)

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## BRUSH/ROLLER

Recommended thinner Sigma thinner 91-92  
Volume of thinner 0- 5 %

## CLEANING SOLVENT

Sigma 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 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

theoretical spreading rate m <sup>2</sup> /l	10.6	6.4	5.3
dft in µm	75	125	150

### Overcoating table

paint type:

for two pack epoxy coatings and two pack polyurethanes

substrate temperature	20°C	30°C	40°C
minimum interval	8 hours	6 hours	4 hours
maximum interval	--	--	--

- when using an alkyd finish coat an undercoat is required
- when not exposed to direct sunshine a maximum recoating time of up to 6 months can be allowed
- surface should be free from any contaminations

### Curing table

substrate temperature	dry to touch	full cure
20 °C	3 hours	7 days
30 °C	2 hours	5 days
40 °C	1.5 hour	3 days

- adequate ventilation must be maintained during application and curing (please refer to sheet 1433 and 1434)

### Pot life (at application viscosity)

paint temperature	pot life
20 °C	2.5 hours
30 °C	1.5 hours
40 °C	less than 1 hour

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## 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.

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Sigma Paints Saudi Arabia Ltd