



SIGMATHERM 540

2 pages

April 2010
Revision of October 2009

DESCRIPTION	one component heat resistant moisture curing silicone aluminium
PRINCIPAL CHARACTERISTICS	<ul style="list-style-type: none"> - heat resistant up to 540°C on steel, grit blasted to ISO-Sa2½ - heat resistant up to 400°C on rusted steel, power tool cleaned to ISO-St3 - to be used for the internal and external protection of steel surfaces - no heat cure necessary between coats - excellent resistance against weathering - also suitable on top of zinc silicate primer - a minimum drying time of 3 days at 20°C should be allowed before exposure to heat
COLOURS AND GLOSS	aluminium - 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)
Mass density	1.1 g/cm ³
Volume solids	45 ± 2%
VOC (supplied)	max. 427 g/kg (Directive 1999/13/EC, SED) max. 478 g/l (approx. 4.0 lb/gal)
Recommended dry film thickness	25 µm
Theoretical spreading rate	18 m ² /l for 25 µm
Touch dry after	45 min.
Overcoating interval	min. 16 hours
Shelf life (cool and dry place)	at least 6 months
RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES	<ul style="list-style-type: none"> - steel; blast cleaned to ISO-Sa2½, blasting profile 40 - 70 µm - steel; pretreated according to ISO-St3 - suitable zinc silicate primer (e.g. SigmaZinc 158); dry and free from any contamination and zinc salts - substrate temperature should be at least 3°C above dew point
INSTRUCTIONS FOR USE	<ul style="list-style-type: none"> - power agitate to uniform consistency
AIR SPRAY	
Recommended thinner	no thinner should be added
Nozzle orifice	1.5 - 2 mm
Nozzle pressure	0.3 - 0.4 MPa (= approx. 3 - 4 bar; 43 - 57 p.s.i.)
BRUSH/ROLLER	for roller application the best results will be obtained by using fine foam type rollers

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CLEANING SOLVENT	Thinner 21-06										
SAFETY PRECAUTIONS	<p>for paint and recommended thinners see safety sheets 1430, 1431 and relevant material safety data sheets</p> <p>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</p>										
Worldwide availability	<p>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.</p>										
REFERENCES	<table border="0"> <tr> <td>Explanation to product data sheets</td> <td>see information sheet 1411</td> </tr> <tr> <td>Safety indications</td> <td>see information sheet 1430</td> </tr> <tr> <td>Safety in confined spaces and health safety</td> <td></td> </tr> <tr> <td>Explosion hazard - toxic hazard</td> <td>see information sheet 1431</td> </tr> <tr> <td>Cleaning of steel and removal of rust</td> <td>see information sheet 1490</td> </tr> </table>	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	Cleaning of steel and removal of rust	see information sheet 1490
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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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218773	aluminium	9000002200
218772	aluminium	9000001500