



SIGMATHERM 350

3 pages

October 2009
Revision of September 2005

DESCRIPTION	heat resistant silicone/acrylic finish
PRINCIPAL CHARACTERISTICS	<ul style="list-style-type: none"> – heat resistant up to 350°C – to be used for the internal and external protection of steel surfaces – widely compatible with inorganic zinc primers – excellent resistance against weathering – a minimum drying time of 3 days at 20°C should be allowed before exposure to heat
COLOURS AND GLOSS	white, aluminium (other colours on request) - semigloss
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	1.2 g/cm ³ (white)
Volume solids	1.1 g/cm ³ (aluminium) 39 ± 2% (white) 42 ± 2% (aluminium)
VOC (supplied)	max. 492 g/kg (Directive 1999/13/EC, SED) (white) max. 491 g/kg (Directive 1999/13/EC, SED) (aluminium) max. 590 g/l (approx. 4.9 lb/gal) (white) max. 540 g/l (approx. 4.5 lb/gal) (aluminium)
Recommended dry film thickness	25 - 30 µm
Theoretical spreading rate	15.6 m ² /l for 25 µm (white) 16.8 m ² /l for 25 µm (aluminium)
Touch dry after	1 - 2 hours
Overcoating interval	min. 18 hours max. unlimited
Shelf life (cool and dry place)	at least 12 months
RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES	<ul style="list-style-type: none"> – thermal aluminium sprayed steel or thermal zinc sprayed steel; dry and free from any contamination – suitable zinc silicate primer (e.g. SigmaZinc 158); dry and free from any contamination and zinc salts – steel; blast cleaned to ISO-Sa2½ or ISO-Sa3, blasting profile 40 - 70 µm – 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 – by using a mistcoat technique it is possible to apply SigmaTherm 350 on top of a zinc silicate primer

SIGMATHERM 350

October 2009

AIRLESS SPRAY

Recommended thinner no thinner should be added
 Nozzle orifice approx. 0.38 - 0.48 mm (= 0.015 - 0.019 in)
 Nozzle pressure 12 - 15 MPa (= approx. 120 - 150 bar; 1700 - 2130 p.s.i.)

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 touch up and spot repair only

CLEANING SOLVENT

Thinner 21-06

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

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.

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

SIGMATHERM 350

October 2009

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.

	PDS	7565
186132	white	7000002200
168790	aluminium	9000002200