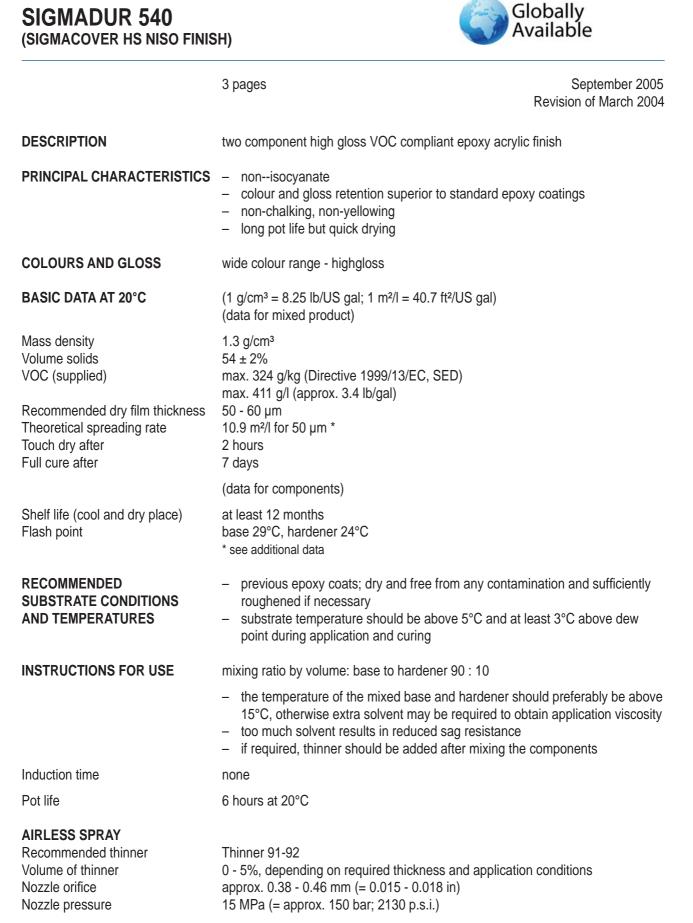
SIGMADUR 540

DATA







SIGMADUR 540 (SIGMACOVER HS NISO FINISH)



DATA

AIR SPRAY Recommended thinner Volume of thinner Nozzle orifice Nozzle pressure	Thinner 91-92 5 - 10%, depending on required thickness and application conditions 1 - 1.5 mm 0.3 - 0.4 MPa (= approx. 3 - 4 bar; 43 - 57 p.s.i.)		
BRUSH/ROLLER Recommended thinner Volume of thinner	Thinner 91-92 0 - 5%		
CLEANING SOLVENT	Thinner 91-92		
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		
	 avoid at all times inhalation of aerosol spraymist 		
ADDITIONAL DATA	Film thickness and spreading rate		
	theoretical spreading rate m ² /l 10.9 9.1		

Overcoating table

dft in µm

substrate temperature	5°C	10°C	20°C	30°C
minimum interval	24 hours	16 hours	8 hours	6 hours
maximum interval	no limitation, provided that the surface is free from any contamination			

50

60

Curing table at 50 µm for SigmaDur 540

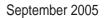
substrate temperature	dry to handle	full cure
5°C	22 hours	14 days
10°C	16 hours	12 days
20°C	10 hours	7 days
30°C	6 hours	4 days

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





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DATA

	Pot life (at application viscosity)		
	10°C	10 hours	
	20°C	6 hours	
	30°C	3 hours	
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 Safety indications Safety in confined spaces a Explosion hazard - toxic ha	see information sheet 1430 nd health safety	

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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