

SIGMACAP PRICOAT 230

3 pages

Jan 2010

DESCRIPTION	two component high build zinc phosphate aliphatic polyurethane finish
PRINCIPAL CHARACTERISTICS	<ul style="list-style-type: none"> - developed as a direct to metal finish coat with anti-corrosive properties on steel and galvanised steel substrate - unlimited recoatability - good U.V. resistance - good colour retention - good impact and abrasion resistance - relatively long potlife at elevated temperatures - resistant to splash and spillage of mild chemicals and solvents - easy to apply
COLOURS AND GLOSS	See Sigmadur colour card - Gloss
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	Approx. 1.2g/cm ³
Volume solids	Approx. 55 % by volume
Recommended dry film thickness	80µm to 120 µm
Theoretical spreading rate	6.9 m ² /ltr for 80 µm
Touch dry after	Approx. 1½ hours
Overcoating interval	Min. 4 hours*
	Max. no limitations
Shelf life (cool and dry place)	At least 12 months
	* see additional information
RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES	<ul style="list-style-type: none"> - previous suitable coat; epoxy primer or build coat, within overcoating interval and free from any contamination. - substrate temperature should be above 5°C and at least 3°C above dew point.
INSTRUCTIONS FOR USE	<ul style="list-style-type: none"> - mixing ratio by volume: base to hardener 88 : 12 - stir well before use - the temperature of the paint should preferably be above 15°C, otherwise extra thinner may be required to obtain application viscosity. - too much solvent results in reduced sag resistance - thinner should be added after mixing the components
AIRLESS SPRAY	
Recommended thinner	Sigma thinner 21-06
Volume of thinner	5-10%
Nozzle orifice	Approx. 0.26 mm (0.015 inch)
Nozzle pressure	150 bar (approx.2100 p.s.i.)

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AIR SPRAY

Recommended thinner Sigma thinner 21-06
 Volume of thinner 0 – 5%
 Nozzle orifice approx. 1.0–1.5 mm
 Nozzle pressure 3-4 bar (approx.43-57 p.s.i.)

BRUSH/ROLLER

Recommended thinner Sigma thinner 21-22
 Volume of thinner 0-5%

CLEANING SOLVENT

Sigma thinner 90-53 (preferred) or 21-06

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 ² /l)	6.3	4.2
Dry film thickness in microns (µm)	80	120

Overcoating table for Sigma polyurethane finishes

substrate temperature	20°C	30°C	40°C
minimum interval	4 hours	2 hours	1 hour
maximum interval	no limitation providing the surface is free from contamination		

Curing table

substrate temperature	dry to handle	full cure
20 °C	90 minutes	10 days
30 °C	60 minutes	7 days
40 °C	45 minutes	5 days

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

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Pot life (at application viscosity)

paint temperature	pot life
20 °C	5 hours
30 °C	3 hours
40 °C	2 hours

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