

SIGMASHIELD 905

4 pages

October 2009
Revision of July 2007

DESCRIPTION	two component glassflake reinforced solvent free amine cured epoxy coating
PRINCIPAL CHARACTERISTICS	<ul style="list-style-type: none"> - one coat protection for cargo holds with excellent corrosion resistance - excellent abrasion and impact resistance, especially to hard angular cargoes - good resistance to various chemicals - good visibility due to light colour - reduced explosion risk and fire hazard - can be applied by heavy duty single feed airless spray equipment (60:1)
COLOURS AND GLOSS	green - 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) (data for mixed product)
Mass density	1.3 g/cm ³
Volume solids	100%
VOC (supplied)	max. 107 g/kg (Directive 1999/13/EC, SED) max. 141 g/l (approx. 1.2 lb/gal) see information sheet 1411
Recommended dry film thickness	400 - 500 µm
Theoretical spreading rate	2.5 m ² /l for 400 µm *
Touch dry after	8 hours
Overcoating interval	min. 24 hours * max. 20 days *
Full cure after	5 days * (data for components)
Shelf life (cool and dry place)	at least 12 months * see additional data
RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES	<ul style="list-style-type: none"> - for cargo holds: <ul style="list-style-type: none"> • steel; blast cleaned to ISO-Sa2½, blasting profile 50 - 100 µm - for immersed areas: <ul style="list-style-type: none"> • steel; blast cleaned to ISO-Sa2½, blasting profile 50 - 100 µm, followed by SigmaShield 220 (dft of 100 µm) or SigmaCover 280 (dft of 50 µm), dry and free from any contamination - substrate temperature must be above 10°C and at least 3°C above dew point during application and curing
SYSTEM SPECIFICATION	cargo holds system sheet: 3107

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INSTRUCTIONS FOR USE

mixing ratio by volume: base to hardener 80 : 20

- when mixing the temperature of the base and hardener should be at least 20°C
- at lower temperature the viscosity will be too high for spray application
- no thinner should be added

Induction time

none

Pot life

1 hour at 20°C *

* see additional data

AIRLESS SPRAY

- heavy duty single feed airless spray equipment preferably 60:1 pump ratio and suitable high pressure hoses
- in-line heating or insulated hoses may be necessary to avoid cooling down of paint in hoses at low air temperature
- application with 45:1 airless spray equipment is possible provided in-line heated high pressure hoses are used
- in case of using 45:1 airless spray equipment the paint must be heated to approx. 30°C in order to obtain the right application viscosity
- length of hoses should be as short as possible

Recommended thinner

no thinner should be added

Nozzle orifice

approx. 0.53 mm (= 0.021 in)

Nozzle pressure

at 20°C (paint temperature) min. 28 MPa (= approx. 280 bar; 4000 p.s.i.)
at 30°C (paint temperature) min. 22 MPa (= approx. 220 bar; 3000 p.s.i.)

BRUSH/ROLLER

for stripe coating and spot repair only

Recommended thinner

no thinner should be added

CLEANING SOLVENT

Thinner 90-83 (preferred) or Thinner 90-53

- all application equipment must be cleaned immediately after use
- paint inside the spraying equipment must be removed before the pot life time has been expired

SAFETY PRECAUTIONS

for paint and recommended thinners see safety sheets 1430, 1431 and relevant material safety data sheets

although this is a solvent free paint, care should be taken to avoid inhalation of spray mist as well as contact between the wet paint and exposed skin or eyes

- ventilation should be provided in confined spaces to maintain good visibility

ADDITIONAL DATA

Film thickness and spreading rate

theoretical spreading rate m ² /l	2.5	2.0
dft in µm	400	500

max. dft when brushing:

150 - 200 µm

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measuring wet film thickness

- a deviation is often obtained between the measured apparent wft and the real applied wft
- this is due to the thixotropy and the surface tension of the paint which retards the release of air trapped in the paint film for some time
- recommendation is to apply a wft which is equal to the specified dft plus 60 µm

maximum dry film thickness

- because of low initial hardness the dft cannot be measured for some days (depending on ambient temperature) after application due to the penetration of the measuring device into the paint film
- the dft should be measured using a calibration foil of known thickness placed in between the coating and the measuring device

Overcoating table for SigmaShield 905 for dft up to 500 µm

substrate temperature	10°C	20°C	30°C	40°C
minimum interval	36 hours	24 hours	16 hours	12 hours
maximum interval	20 days	20 days	14 days	7 days

- surface should be dry and free from any contamination

Curing table

substrate temperature	dry to handle	full cure
5°C	60 hours	15 days
10°C	30 hours	7 days
20°C	16 hours	5 days
30°C	10 hours	3 days
40°C	8 hours	2 days

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

Pot life (at application viscosity)

20°C	60 min.
30°C	45 min.
40°C	25 min.

- due to exothermic reaction, temperature during and after mixing may increase

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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
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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