SIGMAZINC 19

3 pages

October 2009
Revision of September 2005

DESCRIPTION	one component zinc rich epoxy primer

PRINCIPAL CHARACTERISTICS
– good anticorrosive properties, the dry film contains 90% zinc by weight
– designed for repair of two component zinc epoxy primers and zinc silicate primers
– can be used as a reconditioner for aged derusted galvanised steel
– dries at temperatures down to -10°C
– dry heat resistance 125°C with peaks up to 175°C
– the superimposed system must be unsaponifiable
– quick drying, can be overcoated after a short interval

COLOURS AND GLOSS grey - flat

BASIC DATA AT 20°C (1 g/cm³ = 8.25 lb/US gal; 1 m²/l = 40.7 ft²/US gal)

Mass density	2.4 g/cm³
Volume solids	38 ± 2%
VOC (supplied)	max. 246 g/kg (Directive 1999/13/EC, SED)
	max. 584 g/l (approx. 4.9 lb/gal)
Recommended dry film thickness	35 µm
Theoretical spreading rate	10.9 m²/l for 35 µm
Touch dry after	30 min. at 10°C, 5 min. at 15°C, 4 min. at 20°C
Overcoating interval	min. 2 hours at 20°C *
	max. several months
Shelf life (cool and dry place)	at least 12 months
	* see additional data

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES
– steel; blast cleaned to ISO-Sa2½, blasting profile 40 - 70 µm
– aged hot-dip galvanised steel with rusty spots; thoroughly derusted to ISO-St3 or ISO-Sa2½, blasting profile 40 - 70 µm
– zinc rich epoxies and zinc silicates; dry and free from any contamination
– substrate temperature should be at least 3°C above dew point
– can be applied down to -10°C provided the surface is free from moisture and ice

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

AIRLESS SPRAY

Recommended thinner	Thinner 91-79
Volume of thinner	20 - 25%, depending on required thickness and application conditions
Nozzle orifice	approx. 0.43 mm (= 0.017 in)
Nozzle pressure	10 - 15 MPa (= approx. 100 - 150 bar; 1420 - 2130 p.s.i.)

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AIR SPRAY

Recommended thinner	Thinner 91-79
Volume of thinner	20 - 25%, depending on required thickness and application conditions
Nozzle orifice	1.5 - 3 mm
Nozzle pressure	0.2 - 0.3 MPa (= approx. 2 - 3 bar; 28 - 43 p.s.i.)

BRUSH/ROLLER

Recommended thinner	Thinner 91-79
Volume of thinner	0 - 3%

CLEANING SOLVENT   Thinner 90-53

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

ADDITIONAL DATA

with SigmaCover 522, SigmaCover 435, SigmaCover 456

Overcoating table for SigmaZinc 19 for dft up to 35 μm

substrate temperature	-10°C	5°C	10°C	20°C
minimum interval	6 hours	4 hours	3 hours	2 hours
maximum interval	several months when free from zinc salts and contamination			

– zinc rich primers can form zinc salts on the surface; preferably they should not be weathered for long periods before overcoating
– an interval of several months can be allowed under clean interior exposure conditions
– in clean exterior conditions, a maximum interval of 14 days can be tolerated, but in industrial or marine conditions this interval should be reduced to the practical minimum
– before overcoating visible surface contamination must be removed by high pressure water cleaning, sweep blasting or mechanical cleaning
– when a long overcoating interval is required, it is recommended to overcoat SigmaZinc 19 as soon as possible with a suitable sealer coat

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

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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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