

# SIGMAFAST™ 205

## DESCRIPTION

Two-component, high-build, polyamide-cured zinc phosphate epoxy primer/coating

## PRINCIPAL CHARACTERISTICS

- General-purpose epoxy primer/coating for atmospheric conditions
- Fast-curing
- Suitable for the protection of steel and concrete
- Easy application by airless spray
- Recoatable with most two-component epoxy and polyurethane coatings
- Tough, with long-term flexibility

## COLOR AND GLOSS LEVEL

- A wide range of colors and MIO light available
- Semi-gloss

Notes:

- Epoxy coatings will chalk and fade upon exposure to sunlight, elevated temperatures, or chemical exposure. Discoloration and normal chalking do not impact performance. Light colors will darken over time. Some batch-to-batch variation in color is to be expected. Color matches are approximate.
- The addition of a UV stable topcoat should be considered when using epoxy coatings in cosmetic areas

## BASIC DATA AT 20°C (68°F)

Data for mixed product	
<b>Number of components</b>	Two
<b>Mass density</b>	1.4 kg/l (11.7 lb/US gal)
<b>Volume solids</b>	70 ± 2%
<b>VOC (Supplied)</b>	Directive 2010/75/EU, SED: max. 224.0 g/kg UK PG 6/23(92) Appendix 3: max. 322.0 g/l (approx. 2.7 lb/US gal) EUR Directive: 2004/42/IIA(j)(500) 411 g/l
<b>Recommended dry film thickness</b>	75 - 150 µm (3.0 - 6.0 mils) depending on system
<b>Theoretical spreading rate</b>	9.3 m <sup>2</sup> /l for 75 µm (374 ft <sup>2</sup> /US gal for 3.0 mils) 4.7 m <sup>2</sup> /l for 150 µm (187 ft <sup>2</sup> /US gal for 6.0 mils)
<b>Dry to touch</b>	3 hours
<b>Overcoating Interval</b>	Minimum: 4 hours Maximum: 6 months
<b>Full cure after</b>	3 days
<b>Shelf life</b>	Base: at least 24 months when stored cool and dry Hardener: at least 24 months when stored cool and dry

Notes:

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- See ADDITIONAL DATA – Spreading rate and film thickness
- See ADDITIONAL DATA – Overcoating intervals
- See ADDITIONAL DATA – Curing time

## RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

### Substrate conditions

- Steel; blast cleaned to ISO-Sa2½, blasting profile 40 – 70 µm (1.6 – 2.8 mils)

### Concrete

- Dried for at least 28 days in good ventilation conditions
- Moisture content should not exceed 4.5%
- Concrete must be free from laitance and any contamination
- Rough surface; eventually abraded by power tool or diamond abrading tool

### Substrate temperature and application conditions

- Substrate temperature during application and curing should be above 5°C (41°F)
- Substrate temperature during application and curing should be at least 3°C (5°F) above dew point

## INSTRUCTIONS FOR USE

### Mixing ratio by volume: base to hardener 3:1

- The temperature of the mixed base and hardener should preferably be above 15°C (59°F), otherwise extra thinner may be required to obtain application viscosity
- Adding too much thinner results in reduced sag resistance and slower cure
- Thinner should be added after mixing the components

### Table of Induction time

Mixed product induction time	
Mixed product temperature	Induction time
Above 10°C (50°F)	None
Below 10°C (50°F)	10 minutes

### Pot life

6 hours at 20°C (68°F)

Note:

- See ADDITIONAL DATA – Pot life

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## **Air spray**

### **Recommended thinner**

THINNER 91-92

### **Volume of thinner**

5 - 15%, depending on required thickness and application conditions

### **Nozzle orifice**

1.5 - 3.0 mm (approx. 0.060 - 0.110 in)

### **Nozzle pressure**

0.3 - 0.4 MPa (approx. 3 - 4 bar; 44 - 58 p.s.i.)

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## **Airless spray**

### **Recommended thinner**

THINNER 91-92

### **Nozzle orifice**

Approx. 0.48 mm (0.019 in)

### **Nozzle pressure**

15.0 MPa (approx. 150 bar; 2176 p.s.i.)

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## **Brush/roller**

### **Recommended thinner**

THINNER 91-92

### **Volume of thinner**

0 - 5%

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## **Cleaning solvent**

- THINNER 90-53
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## ADDITIONAL DATA

Spreading rate and film thickness	
DFT	Theoretical spreading rate
75 µm (3.0 mils)	9.3 m <sup>2</sup> /l (374 ft <sup>2</sup> /US gal)
100 µm (4.0 mils)	7.0 m <sup>2</sup> /l (281 ft <sup>2</sup> /US gal)
150 µm (6.0 mils)	4.7 m <sup>2</sup> /l (187 ft <sup>2</sup> /US gal)

Overcoating interval for DFT up to 75 µm (3.0 mils)						
Overcoating with...	Interval	5°C (41°F)	10°C (50°F)	20°C (68°F)	30°C (86°F)	40°C (104°F)
various two-pack epoxy and polyurethane coatings	Minimum	12 hours	6 hours	3 hours	2 hours	1 hour
	Maximum	6 months	6 months	6 months	6 months	6 months

Overcoating interval for DFT up to 150 µm (6.0 mils)						
Overcoating with...	Interval	5°C (41°F)	10°C (50°F)	20°C (68°F)	30°C (86°F)	40°C (104°F)
various two-pack epoxy and polyurethane coatings	Minimum	12 hours	6 hours	4 hours	3 hours	2 hours
	Maximum	6 months	6 months	6 months	6 months	6 months

Note:

- The surface must be dry and free from all contaminations (oil, grease, chalking, etc...) which would require cleaning and/or abrading

Curing time for DFT up to 75 µm (3.0 mils)			
Substrate temperature	Dry to touch	Dry to handle	Full cure
5°C (41°F)	12 hours	16 hours	7 days
10°C (50°F)	7 hours	10 hours	5 days
20°C (68°F)	3 hours	5 hours	3 days
30°C (86°F)	1.5 hours	3 hours	60 hours
40°C (104°F)	1 hour	2 hours	36 hours



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Curing time for DFT up to 150 µm (6.0 mils)			
Substrate temperature	Dry to touch	Dry to handle	Full cure
5°C (41°F)	14 hours	18 hours	8 days
10°C (50°F)	8 hours	12 hours	6 days
20°C (68°F)	4 hours	6 hours	4 days
30°C (86°F)	2 hours	4 hours	3 days
40°C (104°F)	1 hour	3 hours	48 hours

Note:

- Adequate ventilation must be maintained during application and curing

Pot life (at application viscosity)	
Mixed product temperature	Pot life
10°C (50°F)	10 hours
20°C (68°F)	6 hours
30°C (86°F)	3 hours

## SAFETY PRECAUTIONS

- See Safety Data Sheet and product label for complete safety and precaution requirements
- This is a solvent-borne paint and care should be taken to avoid inhalation of spray mist or vapor, as well as contact between the wet paint and exposed skin or eyes

## WORLDWIDE AVAILABILITY

It is always the aim of PPG Protective & Marine Coatings to supply the same product on a worldwide basis. However, 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

- Information sheet | Explanation of product data sheets

## WARRANTY

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