

PPG SIGMACOVER™ 350 LT

DESCRIPTION

Two-component, high-build polyamide cured epoxy primer/coating based upon pure epoxy technology

PRINCIPAL CHARACTERISTICS

- Surface tolerant primer/coating for wide use in Marine and Protective Coatings
- Marine use: suitable on topsides, decks, superstructures and cargo holds
- Excellent corrosion resistance
- Compatible with various aged coatings
- Suitable as floor coating for pedestrian traffic with dry to walk on time of 8 hours at 10°C (50°F)
- Good impact and abrasion resistance
- Smooth film, easy to clean
- Cures at temperatures down to -5°C (23°F)

COLOR AND GLOSS LEVEL

- Standard and custom colors, including aluminum
- For Cargo holds gray (5177) and redbrown (6179) only
- Semi-gloss

Note:

- 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.

BASIC DATA AT 10°C (50°F)

| Data for mixed product | |
|---------------------------------------|--|
| Number of components | Two |
| Mass density | 1.4 kg/l (11.7 lb/US gal) |
| Volume solids | 72 ± 2% |
| VOC (Supplied) | Directive 2010/75/EU, SED: max. 264.0 g/kg max. 361.0 g/l (approx. 3.0 lb/US gal) |
| Recommended dry film thickness | 100 - 150 µm (4.0 - 6.0 mils) for airless spray |
| Theoretical spreading rate | 5.8 m²/l for 125 µm (231 ft²/US gal for 5.0 mils) 4.8 m²/l for 150 µm (192 ft²/US gal for 6.0 mils) |
| Dry to touch | 4 hours |
| Overcoating Interval | Minimum: 8 hours Maximum: 14 days |
| Full cure after | 7 days |
| Shelf life | Base: at least 24 months when stored cool and dry Hardener: at least 24 months when stored cool and dry |

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Notes:

- 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 for excellent corrosion protection, blasting profile 40 – 70 µm (1.6 – 2.8 mils)
- Steel; blast cleaned to ISO Sa2, blasting profile 40 – 70 µm (1.6 – 2.8 mils) or power tool cleaned to ISO St2 for good corrosion protection
- Previous coat must be dry and free from any contamination
- Previous coat: surface should be sufficiently roughened if necessary
- At freezing temperatures surface must be free from ice

Substrate conditions of concrete for thinned version

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

Coated concrete

- Existing sound coating systems; sufficiently roughened, dry and cleaned
- To ensure compatibility, rub the existing coating with a cloth with Xylene or MEK for 10 seconds, and remove existing coatings if dissolving occurs
- Rough surface; eventually abraded by power tool or diamond abrading tool

Substrate temperature and application conditions

- Substrate temperature during application and curing should be between -5°C (23°F) and 15°C (59°F)
- Substrate temperature during application and curing should be at least 3°C (37°F) above dew point

SYSTEM SPECIFICATION

- SIGMACOVER 350 LT: 2 x 125 µm (5.0 mils) DFT

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INSTRUCTIONS FOR USE

Mixing ratio by volume: base to hardener 4:1

- The temperature of the mixed base and hardener should preferably be above 5°C (41°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

Pot life

3 hours at 10°C (50°F)

Note:

- See ADDITIONAL DATA – Pot life

Air spray

Recommended thinner

THINNER 91-92

Volume of thinner

5 - 10%, depending on required thickness and application conditions

Nozzle orifice

1.8 – 2.0 mm (approx. 0.070 – 0.079 in)

Nozzle pressure

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

Airless spray

Recommended thinner

THINNER 91-92

Volume of thinner

0 - 10%, depending on required thickness and application conditions

Nozzle orifice

Approx. 0.48 – 0.53 mm (0.019 – 0.021 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%

Cleaning solvent

- THINNER 90-53

ADDITIONAL DATA

| Spreading rate and film thickness | |
|-----------------------------------|---|
| DFT | Theoretical spreading rate |
| 100 µm (4.0 mils) | 7.2 m ² /l (289 ft ² /US gal) |
| 125 µm (5.0 mils) | 5.8 m ² /l (231 ft ² /US gal) |
| 150 µm (6.0 mils) | 4.8 m ² /l (192 ft ² /US gal) |

Note:

- Maximum DFT when brushing: 100 µm (4.0 mils)

| Overcoating interval for DFT up to 150 µm (6.0 mils) | | | | | | |
|--|----------|-------------|------------|------------|-------------|-------------|
| Overcoating with... | Interval | -5°C (23°F) | 0°C (32°F) | 5°C (41°F) | 10°C (50°F) | 15°C (59°F) |
| itself and various two-pack epoxy coatings | Minimum | 36 hours | 24 hours | 12 hours | 8 hours | 6 hours |
| | Maximum | Extended | Extended | Extended | Extended | Extended |
| polyurethanes | Minimum | 3 days | 48 hours | 24 hours | 16 hours | 12 hours |
| | Maximum | 28 days | 28 days | 21 days | 10 days | 7 days |

Notes:

- Actual maximum overcoating times will be influenced by local conditions
- To ensure optimal adhesion of the next coat, the surface must be dry and free from all contaminations (oil, grease, chalking, etc...) which would require cleaning and/or abrading

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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 (23°F) | 24 hours | 32 hours | 16 days |
| 0°C (32°F) | 16 hours | 20 hours | 12 days |
| 5°C (41°F) | 8 hours | 10 hours | 9 days |
| 10°C (50°F) | 4 hours | 6 hours | 7 days |
| 15°C (59°F) | 2 hours | 4 hours | 4 days |

Notes:

- Adequate ventilation must be maintained during application and curing
- Should SIGMACOVER 350 LT or the total coating system (2 x 125 µm/2 x 5.0 mils) be applied in excess of the specified dry film thickness, then the time necessary to reach full cure will be increased
- For cargo hold application: for full cure for hard angular cargoes, please contact your nearest PPG Protective & Marine Coatings sales office

Pot life (at application viscosity)

| Mixed product temperature | Pot life |
|---------------------------|----------|
| 10°C (50°F) | 3 hours |
| 15°C (59°F) | 2 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

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