

# SIGMALINE™ 855 REPAIR

## DESCRIPTION

Two-component, solvent-borne brushable polyurethane repair coating

## PRINCIPAL CHARACTERISTICS

- Repair coating for SIGMALINE 855
- Fast-curing
- Easy field weld repair
- Excellent corrosion resistance
- Good abrasion and impact resistance
- Good water resistance

## COLOR AND GLOSS LEVEL

- Blue, gray, redbrown
- Gloss

## BASIC DATA AT 20°C (68°F)

Data for mixed product	
Number of components	Two
Mass density	1.7 kg/l (14.2 lb/US gal)
Volume solids	93 ± 2%
VOC (Supplied)	Directive 2010/75/EU, SED: max. 38.0 g/kg max. 53.0 g/l (approx. 0.4 lb/US gal)
Recommended dry film thickness	500 µm (20.0 mils) per coat
Theoretical spreading rate	1.9 m <sup>2</sup> /l for 500 µm (75 ft <sup>2</sup> /US gal for 20.0 mils)
Dry to touch	3 hours
Full cure after	5 days
Shelf life	Base: at least 12 months when stored cool and dry Hardener: at least 6 months when stored cool and dry

Note: See ADDITIONAL DATA – Curing time

## RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

### Substrate conditions

- Steel; blast cleaned to ISO-Sa2½,
- SIGMALINE 855; after 16 hours curing proper pretreatment is required



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## **Substrate temperature**

- Substrate temperature during application and curing should be above 15°C (59°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 73:27**

- Application by brush
- No thinner should be added

## **Induction time**

None

## **Pot life**

50 minutes at 20°C (68°F)

Note: See ADDITIONAL DATA – Pot life

## **Cleaning solvent**

THINNER 90-53

## **ADDITIONAL DATA**

<b>Curing time for DFT up to 500 µm (20 mils)</b>		
<b>Substrate temperature</b>	<b>Dry to touch</b>	<b>Full cure</b>
20°C (68°F)	2 hours - 3 hours	5 days
30°C (86°F)	1 hour - 2 hours	3 days
40°C (104°F)	40 minutes	24 hours

<b>Pot life (at application viscosity)</b>	
<b>Mixed product temperature</b>	<b>Pot life</b>
20°C (68°F)	50 minutes
30°C (86°F)	40 minutes
40°C (104°F)	30 minutes



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## SAFETY PRECAUTIONS

- For paint and recommended thinners see INFORMATION 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
- Protective clothing and spray masks should be provided to avoid any dermatitic or toxic hazard
- If any symptoms arise immediately seek medical advice

## WORLDWIDE AVAILABILITY

It is always the aim of PPG Protective and 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

• EXPLANATION TO PRODUCT DATA SHEETS	INFORMATION SHEET	1411
• SAFETY INDICATIONS	INFORMATION SHEET	1430
• SAFETY IN CONFINED SPACES AND HEALTH SAFETY, EXPLOSION HAZARD – TOXIC HAZARD	INFORMATION SHEET	1431
• CLEANING OF STEEL AND REMOVAL OF RUST	INFORMATION SHEET	1490

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