PPG SIGMACOVER™ 410 MIO 80

DESCRIPTION

Two-component, high-build, micaceous iron oxide-pigmented polyamide-cured epoxy coating

PRINCIPAL CHARACTERISTICS

- General-purpose epoxy buildcoat in protective coating systems, for steel and concrete structures exposed to atmospheric land or marine conditions
- Easy application by airless spray

COLOR AND GLOSS LEVEL

- Gray, redbrown (low metallic sheen)

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	
Number of components	Two
Mass density	1.9 kg/l (15.9 lb/US gal)
Volume solids	80 ± 2%
VOC (Supplied)	Directive 2010/75/EU, SED: max. 126.0 g/kg UK PG 6/23(92) Appendix 3: max. 240.0 g/l (approx. 2.0 lb/US gal)
Recommended dry film thickness	40 - 150 µm (1.6 - 6.0 mils) depending on system
Theoretical spreading rate	8.0 m^2/l for 100 µm (321 ft^2/US gal for 4.0 mils)
Dry to touch	3 hours
Full cure after	7 days
Shelf life	Base: at least 12 months when stored cool and dry Hardener: at least 12 months when stored cool and dry

Notes:

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

PPG SIGMACOVER™ 410 MIO 80

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

Substrate conditions

- Suitable primer must be dry and free from any contamination
- Surface of previous coat should be sufficiently roughened if necessary
- When applied to zinc silicate, a mist coat and full coat technique is required

Substrate temperature

- 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 (37°F) above dew point
- Relative humidity during application and curing should not exceed 85%

INSTRUCTIONS FOR USE

Mixing ratio by volume: base to hardener 4:1

- The temperature of the paint 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

Pot life

6 hours at 20°C (68°F)

Note:

- See ADDITIONAL DATA – Pot life

Air spray

Recommended thinner

THINNER 91-92

Volume of thinner

5 - 10%

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.)

PPG SIGMACOVER™ 410 MIO 80

Airless spray

Recommended thinner

THINNER 91-92

Volume of thinner

5 - 10%

Nozzle orifice

Approx. 0.48 – 0.53 mm (0.019 – 0.021 in)

Nozzle pressure

14.5 - 15.0 MPa (approx. 145 - 150 bar; 2100 - 2176 p.s.i.)

Brush/roller

- Application by roller will leave roller marking and is suitable for minimum DFT requirements only
- A roller suitable for epoxy application must be used

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**
75 µm (3.0 mils)	10.7 m^2/l (428 ft^2/US gal)
100 µm (4.0 mils	8.0 m^2/l (321 ft^2/US gal)
150 µm (6.0 mils)	5.3 m^2/l (214 ft^2/US gal

PPG SIGMACOVER™ 410 MIO 80

Overcoating interval for DFT up to 150 µm (6.0 mils)				
Overcoating with...	**Interval**	**20°C (68°F)**	**30°C (86°F)**	**40°C (104°F)**
various two-pack epoxy and polyurethane coatings	Minimum Maximum	10 hours 3 months	8 hours 2 months	6 hours 1 month
polyurethane topcoat	Minimum Maximum	24 hours 3 months	16 hours 2 months	12 hours 1 month

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

Curing time for DFT up to 150 µm (6.0 mils)		
Substrate temperature	**Dry to handle**	**Full cure**
20°C (68°F)	10 hours	4 days
30°C (86°F)	7 hours	3 days
40°C (104°F)	5 hours	48 hours

Pot life (at application viscosity)	
Mixed product temperature	**Pot life**
20°C (68°F)	6 hours
30°C (86°F)	3 hours
40°C (104°F)	2 hours

SAFETY PRECAUTIONS

- 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
- See Safety Data Sheet and product label for complete safety and precaution requirements

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.

PPG SIGMACOVER™ 410 MIO 80

REFERENCES

- Information sheet | Explanation of product data sheets

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