

# SIGMARINE™ ONE 648

## DESCRIPTION

General purpose gloss paint based on an alkyd-modified resin

## PRINCIPAL CHARACTERISTICS

- Particularly suitable as a finish for boottop, topside, deck and deck equipment
- A quick-drying, hard, tough, water- and weather-resistant coating with good gloss retention
- Can be applied over most intact alkyd paints
- This coating is particularly suitable for areas intermittently exposed to water-immersion and atmospheric conditions
- Also available with non-skid material (supplied separately) for use on deck surfaces
- Meets VOC regulations

## COLOR AND GLOSS LEVEL

- White and various other colors (see also SIGMACARE shade card)
- Gloss

## BASIC DATA AT 20°C (68°F)

Data for product	
<b>Number of components</b>	One
<b>Mass density</b>	1.0 kg/l (8.3 lb/US gal)
<b>Volume solids</b>	48 ± 2%
<b>VOC (Supplied)</b>	max. 427 g/l (approx. 3.6 lb/US gal)
<b>Recommended dry film thickness</b>	35 µm (1.4 mils) per coat
<b>Theoretical spreading rate</b>	13.7 m <sup>2</sup> /l for 35 µm (550 ft <sup>2</sup> /US gal for 1.4 mils)
<b>Dry to touch</b>	3 hours
<b>Overcoating Interval</b>	Minimum: 24 hours Maximum: Unlimited
<b>Shelf life</b>	At least 24 months when stored cool and dry

Notes:

- See ADDITIONAL DATA – Overcoating intervals
- See ADDITIONAL DATA – Curing time

## RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

### Substrate conditions

- Previous suitable coat must be dry and free from any contamination
- Previous coat: surface should be sufficiently roughened if necessary

# SIGMARINE™ ONE 648

## **Substrate temperature and application conditions**

- Substrate temperature during application should not exceed 50°C (122°F)
- Substrate temperature during application should be at least 3°C (5°F) above dew point

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## **INSTRUCTIONS FOR USE**

- Stir well before use
- 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
- Adequate ventilation must be maintained during application and curing

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## **Airless spray**

### **Recommended thinner**

THINNER 20-05

### **Volume of thinner**

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

### **Nozzle orifice**

Approx. 0.48 mm (0.019 in)

### **Nozzle pressure**

8.0 - 12.0 MPa (approx. 80 - 120 bar; 1161 - 1741 p.s.i.)

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## **Brush/roller**

### **Recommended thinner**

THINNER 20-05

### **Volume of thinner**

0 - 10%

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## **Cleaning solvent**

- THINNER 20-05

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## ADDITIONAL DATA

Overcoating interval for DFT up to 35 µm (1.4 mils)			
Overcoating with...	Interval	5°C (41°F)	20°C (68°F)
itself	Minimum	32 hours	24 hours
	Maximum	Unlimited	Unlimited

Curing time for DFT up to 35 µm (1.4 mils)	
Substrate temperature	Dry to touch
5°C (41°F)	5 hours
20°C (68°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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