

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



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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.)

Brush/roller

Recommended thinner

THINNER 20-05

Volume of thinner

0 - 10%

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

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