

PPG 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 ² /l for 500 µm (75 ft ² /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 2.70:1

- Application by brush
- No thinner should be added

Induction time

0 minute

Note:

- No induction time required

Pot life

50 minutes at 20°C (68°F)

Note:

- See ADDITIONAL DATA – Pot life

Cleaning solvent

- THINNER 90-53

ADDITIONAL DATA

Curing time for DFT up to 500 µm (20.0 mils)		
Substrate temperature	Dry to touch	Full cure
20°C (68°F)	2 - 3 hours	5 days
30°C (86°F)	1 - 2 hours	3 days
40°C (104°F)	40 minutes	24 hours

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

SAFETY PRECAUTIONS

- Protective clothing and spray masks should be provided to avoid any dermatitic or toxic hazard
- If any symptoms arise immediately seek medical advice
- See Safety Data Sheet and product label for complete safety and precaution requirements
- Ventilation should be provided in confined spaces to maintain good visibility
- 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

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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