

# SIGMACOVER™ 410/SIGMACOVER™ 410 LT

## DESCRIPTION

Two-component, high solids, high-build, 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
- Excellent durability
- Can be recoated with various two-component and conventional coatings, even after long weathering periods
- Easy application by airless spray
- Good drying- and curing properties at low substrate temperature (down to -5°C (23°F))

## COLOR AND GLOSS LEVEL

- MIO and a selected range of colors
- Flat

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	
<b>Number of components</b>	Two
<b>Mass density</b>	1.5 kg/l (12.5 lb/US gal), depending on color MIO: 1.8 kg/l (15.0 lb/US gal)
<b>Volume solids</b>	80 ± 2%
<b>VOC (Supplied)</b>	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)
<b>Recommended dry film thickness</b>	75 - 225 µm (3.0 - 9.0 mils) depending on system
<b>Theoretical spreading rate</b>	10.7 m <sup>2</sup> /l for 75 µm (428 ft <sup>2</sup> /US gal for 3.0 mils)
<b>Overcoating Interval</b>	See overcoating tables
<b>Full cure after</b>	7 days
<b>Shelf life</b>	Base: at least 24 months when stored cool and dry Hardener: at least 24 months when stored cool and dry

Notes:



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

- Substrate temperature during application and curing down to -5°C (23°F) is acceptable; provided the substrate is free from ice and dry
  - Substrate temperature during application and curing should be at least 3°C (5°F) above dew point
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## 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
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### Pot life

6 hours at 20°C (68°F)

Note:

- See ADDITIONAL DATA – Pot life
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**Airless spray**

**Recommended thinner**

THINNER 91-92

**Volume of thinner**

0 - 10%

**Nozzle orifice**

Approx. 0.46 – 0.53 mm (0.018 – 0.021 in)

**Nozzle pressure**

20.0 - 25.0 MPa (approx. 200 - 250 bar; 2901 - 3626 p.s.i.)

**Brush/roller**

- Application by brush may show brush marking, due to the thixotropic nature of the paint and is most suitable to small areas, tight angle areas or for stripe coating or touch-up
- 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 <sup>2</sup> /l (428 ft <sup>2</sup> /US gal)
150 µm (6.0 mils)	5.3 m <sup>2</sup> /l (214 ft <sup>2</sup> /US gal)
200 µm (8.0 mils)	4.0 m <sup>2</sup> /l (160 ft <sup>2</sup> /US gal)



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Overcoating interval for DFT up to 200 µm (8.0 mils) - SIGMACOVER 410						
Overcoating with...	Interval	5°C (41°F)	10°C (50°F)	20°C (68°F)	30°C (86°F)	40°C (104°F)
various two-pack epoxy and polyurethane coatings	Minimum	36 hours	24 hours	8 hours	6 hours	4 hours
	Maximum	Extended	Extended	Extended	Extended	Extended

Overcoating interval for DFT up to 200 µm (8.0 mils) - SIGMACOVER 410 LT						
Overcoating with...	Interval	-5°C (23°F)	0°C (32°F)	5°C (41°F)	10°C (50°F)	15°C (59°F)
various two-pack epoxy and polyurethane coatings	Minimum	48 hours	24 hours	16 hours	12 hours	8 hours
	Maximum	Extended	Extended	Extended	Extended	Extended

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
- The LT hardener is not available in all regions, please check this with your PPG representative

Curing time for DFT up to 200 µm (8.0 mils) - SIGMACOVER 410			
Substrate temperature	Dry to touch	Dry to handle	Full cure
5°C (41°F)	12 hours	30 hours	20 days
10°C (50°F)	6 hours	24 hours	14 days
15°C (59°F)	4 hours	10 hours	10 days
20°C (68°F)	3 hours	8 hours	7 days
30°C (86°F)	2 hours	6 hours	5 days
40°C (104°F)	1.5 hours	4 hours	3 days



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Curing time for DFT up to 200 µm (8.0 mils) - SIGMACOVER 410 LT			
Substrate temperature	Dry to touch	Dry to handle	Full cure
-5°C (23°F)	16 hours	24 hours	20 days
0°C (32°F)	11 hours	16 hours	14 days
5°C (41°F)	6 hours	10 hours	10 days
10°C (50°F)	4 hours	8 hours	7 days
15°C (59°F)	3 hours	5 hours	5 days

Notes:

- Adequate ventilation must be maintained during application and curing
- Ambient temperature during application at -5°C (23°F) is acceptable; however curing to hardness takes longer and complete cure will be reached when the temperature increases
- The LT hardener is not available in all regions, please check this with your PPG representative

Pot life (at application viscosity)	
Mixed product temperature	Pot life
10°C (50°F)	12 hours
15°C (59°F)	8 hours
20°C (68°F)	6 hours
25°C (77°F)	4 hours
30°C (86°F)	3 hours
40°C (104°F)	2 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



# SIGMACOVER™ 410/SIGMACOVER™ 410 LT

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