

# SIGMACOVER™ 620

## DESCRIPTION

Two-component, surface tolerant high-build epoxy primer/coating

## PRINCIPAL CHARACTERISTICS

- Excellent corrosion resistance
- Good flexibility
- Surface tolerant coating for lower grade of surface preparation for atmospheric exposure
- Easy application by different application methods such as airless spray, brush etc.
- Good drying and curing property at low temperatures down to -5°C (23°F)

## COLOR AND GLOSS LEVEL

- Gray, Light Gray (RAL 7035), White (RAL 9001, RAL 9003, RAL 9010, RAL 9018)
- Flat

## BASIC DATA AT 10°C (50°F)

Data for mixed product	
Number of components	Two
Mass density	1.5 kg/l (12.9 lb/US gal)
Volume solids	80 ± 2%
VOC (Supplied)	Directive 2010/75/EU, SED: max. 133.0 g/kg max. 205.0 g/l (approx. 1.7 lb/US gal)
Recommended dry film thickness	75 - 200 µm (3.0 - 8.0 mils) depending on system
Theoretical spreading rate	6.4 m²/l for 125 µm (257 ft²/US gal for 5.0 mils)
Dry to touch	2.5 hours
Overcoating Interval	Minimum: 5 hours Maximum: Extended
Full cure after	4 days
Shelf life	Base: at least 24 months when stored cool and dry Hardener: at least 24 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

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## RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

### Atmospheric exposure conditions

- Steel; blast cleaned to ISO-Sa2½ for excellent corrosion protection
- Steel; blast cleaned to ISO-Sa2 or power tool cleaned to ISO-St2 for good corrosion protection
- Shop primed steel; pretreated to SPSS-Pt2
- Galvanized steel; sweep blasted to roughen the surface and to remove any zinc salts which might be present

### Substrate temperature and application conditions

- Substrate temperature during application and curing should be at least 3°C (5°F) above dew point
- Relative humidity during application should not exceed 85%

## INSTRUCTIONS FOR USE

### Mixing ratio by volume: base to hardener 80:20 (4:1)

- The temperature of the mixed base and hardener should be above 10°C (50°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

### Induction time

None

### Pot life

3 hours

Note: See ADDITIONAL DATA – Pot life

### Airless spray

#### **Recommended thinner**

THINNER 91-92

#### **Volume of thinner**

0 - 15%, depending on required thickness and application conditions

#### **Nozzle orifice**

Approx. 0.43 – 0.53 mm (0.017 – 0.021 in)

#### **Nozzle pressure**

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



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**Brush/roller****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)
100 µm (4.0 mils)	8.0 m <sup>2</sup> /l (321 ft <sup>2</sup> /US gal)
125 µm (5.0 mils)	6.4 m <sup>2</sup> /l (257 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)

**Overcoating interval for DFT up to 125 µm (5.0 mils): Atmospheric exposure**

Overcoating with...	Interval	-5°C (23°F)	0°C (32°F)	5°C (41°F)	10°C (50°F)	20°C (68°F)	30°C (86°F)	40°C (104°F)
itself	Minimum	60 hours	36 hours	20 hours	12 hours	5 hours	2.5 hours	1.5 hours
	Maximum	Extended	Extended	Extended	Extended	Extended	Extended	Extended

Note: Surface should be dry and free from any contamination and sufficiently roughened after long exposure

**Curing time for DFT up to 125 µm (5.0 mils)**

Substrate temperature	Dry to touch	Dry to handle	Full cure
-5°C (23°F)	24 hours	48 hours	20 days
0°C (32°F)	12 hours	24 hours	14 days
5°C (41°F)	8 hours	16 hours	7 days
10°C (50°F)	6 hours	12 hours	5 days
20°C (68°F)	3 hours	5 hours	4 days
30°C (86°F)	1.5 hours	2.5 hours	3 days
40°C (104°F)	1 hour	1.5 hours	48 hours

Note: Adequate ventilation must be maintained during application and curing (please refer to INFORMATION SHEETS 1433 and 1434)

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Pot life (at application viscosity)	
Mixed product temperature	Pot life
10°C (50°F)	5 hours
20°C (68°F)	3 hours
30°C (86°F)	1.5 hours
40°C (104°F)	40 minutes

## SAFETY PRECAUTIONS

- For paint and recommended thinners see INFORMATION SHEETS 1430, 1431 and relevant Material Safety Data Sheets
- 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 and 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

EXPLANATION TO PRODUCT DATA SHEETS	INFORMATION SHEET	1411
SAFETY INDICATIONS	INFORMATION SHEET	1430
SAFETY IN CONFINED SPACES AND HEALTH SAFETY, EXPLOSION HAZARD – TOXIC HAZARD	INFORMATION SHEET	1431
SAFE WORKING IN CONFINED SPACES	INFORMATION SHEET	1433
DIRECTIVES FOR VENTILATION PRACTICE	INFORMATION SHEET	1434

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