SIGMADUR™ 2800

DESCRIPTION

Two-component, air drying, high solids fluorocarbon finish

PRINCIPAL CHARACTERISTICS

- Excellent resistance to atmospheric exposure conditions
- Excellent color and gloss retention
- Resistant to splash of mineral and vegetable oils, paraffins, aliphatic petroleum products and mild chemicals
- Unlimited recoatable
- Good application properties
- Low surface energy, good decontamination and easy-clean properties
- Cures at temperatures down to -10°C (14°F)
- 25% fluorine content

COLOR AND GLOSS LEVEL

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

BASIC DATA AT 20°C (68°F)

Data for mixed product	
Number of components	Two
Mass density	1.3 kg/l (10.8 lb/US gal)
Volume solids	56 ± 2%
VOC (Supplied)	Directive 2010/75/EU, SED: max. 321.0 g/kg max. 418.0 g/l (approx. 3.5 lb/US gal) China GB 30981-2020 (tested) 410.0 g/l (approx. 3.4 lb/gal)
Recommended dry film thickness	25 - 40 µm (1.0 - 1.6 mils) depending on system
Theoretical spreading rate	16.0 m^2/l for 35 µm (642 ft^2/US gal for 1.4 mils)
Dry to touch	3 hours
Overcoating Interval	Minimum: 20 hours Maximum: Unlimited
Shelf life	Base: at least 36 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

Substrate conditions

- Previous coat must be dry and free from any contamination
- Old existing sound coating; sufficiently roughened, dry and cleaned

Substrate temperature and application conditions

- Substrate temperature during application and curing down to -5°C (23°F) is acceptable
- Substrate temperature during application and curing should be at least 3°C (5°F) above dew point
- Relative humidity during application and curing should not exceed 85%
- Premature exposure to early condensation and rain may cause color and gloss change

INSTRUCTIONS FOR USE

Mixing ratio by volume: base to hardener 91:9

- Do not thin more than is required by appropriate application property
- Adding too much thinner results in reduced sag resistance and slower cure
- Thinner should be added after mixing the components

Pot life

5 hours at 20°C (68°F)

Note:

- See ADDITIONAL DATA – Pot life

Air spray

Recommended thinner

THINNER 91-88

Volume of thinner

10 - 15%, depending on required thickness and application conditions

Nozzle orifice

1.0 - 1.5 mm (approx. 0.040 - 0.060 in)

Nozzle pressure

0.3 - 0.4 MPa (approx. 3 - 4 bar; 44 - 58 p.s.i.)

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Airless spray

Recommended thinner

THINNER 91-88

Volume of thinner

0 - 5%, depending on required thickness and application conditions

Nozzle orifice

Approx. 0.28 – 0.38 mm (0.011 – 0.015 in)

Nozzle pressure

20.0 MPa (approx. 200 bar; 2901 p.s.i.)

Brush/roller

Recommended thinner

THINNER 91-88

Volume of thinner

0 - 5%

ADDITIONAL DATA

Spreading rate and film thickness	
DFT	**Theoretical spreading rate**
25 µm (1.0 mils)	22.4 m^2/l (898 ft^2/US gal)
30 µm (1.2 mils)	18.7 m^2/l (749 ft^2/US gal
35 µm (1.4 mils)	16.0 m^2/l (642 ft^2/US gal)
40 µm (1.6 mils)	14.0 m^2/l (561 ft^2/US gal)

Overcoating interval for DFT up to 35 µm (1.4 mils)					
Overcoating with...	**Interval**	**5°C (41°F)**	**20°C (68°F)**	**30°C (86°F)**	**40°C (104°F)**
itself	Minimum	36 hours	20 hours	10 hours	3 hours
	Maximum	Unlimited	Unlimited	Unlimited	Unlimited

Note:

- Surface should be dry and free from any contamination

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Curing time for DFT up to 35 µm (1.4 mils)		
Substrate temperature	**Dry to touch**	**Dry to handle**
5°C (41°F)	24 hours	36 hours
20°C (68°F)	3 hours	20 hours
30°C (86°F)	1 hour	10 hours
40°C (104°F)	30 minutes	3 hours

Note:

- Adequate ventilation must be maintained during application and curing

Pot life (at application viscosity)	
Mixed product temperature	**Pot life**
5°C (41°F)	8 hours
20°C (68°F)	5 hours
30°C (86°F)	2 hours
40°C (104°F)	1 hour

SAFETY PRECAUTIONS

- Contains a toxic polyisocyanate curing agent
- Avoid at all times inhalation of aerosol spray mist
- 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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LIMITATIONS OF LIABILITY

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