SIGMACOVER 280

7417

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DESCRIPTION	two component polyamide cured corrosion inhibiting epoxy primer
PRINCIPAL CHARACTERISTICS	- general purpose primer used in protective coating systems for immersion and atmospheric exposure conditions - good adhesion to steel and galvanized steel - good adhesion to non ferrous metals - good flow and wetting properties - good water and corrosion resistance - cures at temperatures as low as 5 °C - suitable for touching up of weld seams and damaged epoxy primers during construction - long recoating intervals are possible when overcoating with epoxy and polyurethane coatings - can be overcoated with alkyd, chlorinated rubber, vinyl, epoxy and polyurethane coatings - suitable for application to wet or dry abrasive cleaned substrates - tolerant to a damp steel surface - compatible with cathodic protection systems - can be used in conjunction with Sigma Wet Blast Inhibitor
COLOUR AND GLOSS	red-brown and green – eggshell
BASIC DATA AT 20 °C	(for mixed product)
Mass density	approx. 1.4g/cm^3
Solids content	approx. 57% by volume
Recommended dry film thickness	50 - 125 µm
Theoretical spreading rate	11.4 m^2/ltr for 50 µm* depending on the nature and condition of the substrate and the application method employed
Touch dry after	approx. 30 minutes
Overcoating interval	min. 8 hours* max. 3 - 6 months*
Full cure after	7 days*
Shelf life (cool,dry place)	12 months
Flashpoint	base and hardener - 26 °C
Available pack size	1 ltr, 5 ltr, 20 ltr

*see additional data

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RECOMMENDED SUBSTRATE CONDITIONS

for immersion exposure
- steel; blast cleaned (dry or wet) to ISO Sa2½
- steel with approved zinc silicate shop primer; pretreated according to SPSS-Ss

for atmospheric exposure
- steel; pretreated to ISO-Sa2½ or ISO-St3
- shop primed steel; pretreated according to SPSS-Pt3
- galvanized steel; free from grease, salts and other contamination, preferably blast cleaned to (Rz) 30 µm
- substrate temperature should be above 5 °C and at least 3 °C above the dew point during application and curing

INSTRUCTIONS FOR USE

- mixing ratio: by volume; base to hardener 80 : 20
- the temperature of the mixed base and hardener should be above 15 °C, otherwise extra solvent may be required to obtain the correct application viscosity
- too much solvent will result in lower sag resistance and slower cure
- thinner should only be added after proper mixing of the base and hardener

Induction time at 20 °C	none
Potlife at 20 °C	8 hours*

AIRLESS SPRAY

Recommended thinner	91-92 (flashpoint 20 °C)
Volume of thinner	0 - 5% for 75 - 125 µm - 10 - 25% for 50 - 75 µm
Nozzle orifice	approx. 0.46 mm (0.018 inch)
Nozzle pressure	150 bar (approx. 2100 p.s.i.)

AIR SPRAY

Recommended thinner	91-92 (flashpoint 20 °C)
Volume of thinner	5 - 10%
Nozzle orifice	1.5 - 2.0 mm
Nozzle pressure	3 - 4 bar (approx. 43 - 57 p.s.i.)

BRUSH AND ROLLER

Recommended thinner	91-92 (flashpoint 20 °C)
Volume of thinner	0 - 5%

CLEANING SOLVENT 90-53 (flashpoint 30 °C)

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SAFETY PRECAUTIONS

see safety sheets 1570 and 1571 for information on LEL and TLV values

ADDITIONAL DATA

Film thickness and spreading rate

Dry film thickness in microns (µm)	75	100
Theoretical spreading rate (m^2/l)	7.6	5.7

Maximum dft without sagging with airless spray: 250 µm

Minimum dft for closed film with airless spray: 30 µm

Maximum dft for brush application: 50 µm

Note: maximum dft is for overlap areas only

overcoating table for Sigmacover TCP coating, Sigma TCN 300, epoxy and polyurethane paints used for immersion service

Substrate temperature	5 °C	10 °C	15 °C	20 °C	30 °C	40 °C
Minimum interval	36 hours	16 hours	10 hours	8 hours	6 hours	4 hours
Maximum interval when <u>not</u> exposed to daylight	6 months	6 months	6 months	6 months	4 months	3 months
Maximum interval when exposed to daylight	3 months	3 months	3 months	3 months	2 months	2 months

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Overcoating table for Sigmacover CM Coating, chlorinated rubber, vinyl and alkyd paints used for atmospheric exposure

substrate temperature	5 °C	10 °C	15 °C	20 °C	30 °C	40 °C
minimum interval	16 hours	10 hours	6 hours	5 hours	3 hours	2 hours
maximum interval	21 days	21 days	14 days	10 days	7 days	7 days

Figures contained in above are valid for a dft of approx. 50 µm
Substrate should be free from chalking and contamination

Curing table

Substrate temperature	Touch Dry	Dry to handle	Full cure
5 °C	120 min.	6 hours	18 days
10 °C	60 min.	4 hours	12 hours
15 °C	45 min.	3 hours	7 days
20 °C	30 min.	2 hours	5 days
30 °C	20 min.	1 hour	4 days

Potlife at application Viscosity

Paint temperature	Pot life
15 °C	12 hours
20 °C	8 hours
25 °C	6 hours
30 °C	5 hours
35 °C	4 hours

REFERENCES explanation to product data sheets on information sheet 1551

June 2008 update.
The current TDS supersede all previous issues.