

# SIGMACOVER™ 350

## DESCRIPTION

Two-component, high-build polyamide cured anticorrosive epoxy primer/coating

## PRINCIPAL CHARACTERISTICS

- Surface tolerant primer/coating for wide use in Marine and Protective Coatings
- Marine use: suitable on topsides, decks, superstructures and cargo holds
- Good impact and abrasion resistance
- Fast-curing
- Smooth film, easy to clean
- Compatible with various aged coatings
- Excellent corrosion resistance
- Resistant to splash and spillage of a wide range of chemicals

## COLOR AND GLOSS LEVEL

- Standard and custom colors, including aluminum
- For Cargo holds gray ( 5177 ) and redbrown ( 6179 ) only
- Semi-gloss

## BASIC DATA AT 20°C (68°F)

Data for mixed product	
Number of components	Two
Mass density	1.4 kg/l (11.7 lb/US gal)
Volume solids	72 ± 2%
VOC (Supplied)	Directive 1999/13/EC, SED: max. 263.0 g/kg max. 361.0 g/l (approx. 3.0 lb/US gal)
Recommended dry film thickness	100 - 150 µm (4.0 - 6.0 mils) for airless spray
Theoretical spreading rate	5.8 m <sup>2</sup> /l for 125 µm (231 ft <sup>2</sup> /US gal for 5.0 mils) 4.8 m <sup>2</sup> /l for 150 µm (192 ft <sup>2</sup> /US gal for 6.0 mils)
Dry to touch	2 hours
Overcoating Interval	Minimum: 6 hours Maximum: 21 days
Full cure after	7 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

### Substrate conditions

- Steel; blast cleaned to ISO-Sa2½ for excellent corrosion protection, blasting profile 40 – 70 µm (1.6 – 2.8 mils)
  - Steel; blast cleaned to ISO-Sa2, blasting profile 40 – 70 µm (1.6 – 2.8 mils) or power tool cleaned to minimum ISO-St2 for good corrosion protection
  - Coated steel; hydrojetted to VIS WJ2/3L
  - Surface must be dry and free from any contamination
  - Existing sound epoxy systems and most sound alkyd coating system; sufficiently roughened
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### Substrate temperature and application conditions

- Substrate temperature during application and curing should be above 5°C (41°F)
  - Substrate temperature during application and curing should be at least 3°C (5°F) above dew point
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## SYSTEM SPECIFICATION

- SIGMACOVER 350: 2 x 125 µm (5.0 mils) DFT
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## INSTRUCTIONS FOR USE

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

- The temperature of the mixed base and hardener 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
  - Thinner should be added after mixing the components
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### Induction time

None

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### Pot life

3 hours at 20°C (68°F)

Note: See ADDITIONAL DATA – Pot life

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## Air spray

### **Recommended thinner**

THINNER 91-92

### **Volume of thinner**

5 - 10%, depending on required thickness and application conditions

### **Nozzle orifice**

1.8 – 2.0 mm (approx. 0.070 – 0.079 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 91-92

### **Volume of thinner**

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

### **Nozzle orifice**

Approx. 0.48 – 0.53 mm (0.019 – 0.021 in)

### **Nozzle pressure**

15.0 MPa (approx. 150 bar; 2176 p.s.i.)

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## Brush/roller

### **Recommended thinner**

THINNER 91-92

### **Volume of thinner**

0 – 5%

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## Cleaning solvent

THINNER 90-53

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## ADDITIONAL DATA

Spreading rate and film thickness	
DFT	Theoretical spreading rate
100 µm (4.0 mils)	7.2 m <sup>2</sup> /l (289 ft <sup>2</sup> /US gal)
125 µm (5.0 mils)	5.8 m <sup>2</sup> /l (231 ft <sup>2</sup> /US gal)
150 µm (6.0 mils)	4.8 m <sup>2</sup> /l (192 ft <sup>2</sup> /US gal)

Note: Maximum DFT when brushing: 100 µm (4.0 mils)

Overcoating interval for DFT up to 150 µm (6.0 mils)						
For application in Marine cargo holds and areas exposed to water immersion						
Overcoating with...	Interval	5°C (41°F)	10°C (50°F)	20°C (68°F)	30°C (86°F)	40°C (104°F)
itself	Minimum	16 hours	9 hours	6 hours	4 hours	3 hours
	Maximum	1 month	1 month	21 days	14 days	7 days

Overcoating interval for DFT up to 150 µm (6.0 mils)						
For application in Marine areas subject to non-permanent exposure to splash water, seawater, spillage to chemicals etc.						
Overcoating with...	Interval	5°C (41°F)	10°C (50°F)	20°C (68°F)	30°C (86°F)	40°C (104°F)
itself and various two-pack epoxy coatings	Minimum	16 hours	9 hours	6 hours	4 hours	3 hours
	Maximum	1 month	1 month	21 days	14 days	7 days
polyurethanes	Minimum	48 hours	30 hours	18 hours	9 hours	5 hours
	Maximum	1 month	21 days	14 days	7 days	3 days

Overcoating interval for DFT up to 150 µm (6.0 mils)						
For application in atmospheric exposure and industrial PC						
Overcoating with...	Interval	5°C (41°F)	10°C (50°F)	20°C (68°F)	30°C (86°F)	40°C (104°F)
itself and various two-pack epoxy coatings	Minimum	16 hours	9 hours	6 hours	4 hours	3 hours
	Maximum	Unlimited	Unlimited	Unlimited	Unlimited	Unlimited
polyurethanes	Minimum	48 hours	30 hours	18 hours	9 hours	5 hours
	Maximum	6 months	6 months	3 months	1 month	1 month
various single pack coatings (such as alkyds and acrylics)	Minimum	24 hours	24 hours	16 hours	8 hours	5 hours
	Maximum	14 days	14 days	7 days	4 days	48 hours

Note: In cases of exposure to direct sunlight or when the surface is contaminated it is recommended that the surface be cleaned and roughened to ensure good adhesion of the subsequent coating.

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## Curing time for DFT up to 150 µm (6.0 mils)

Substrate temperature	Dry to touch	Dry to handle	Full cure
5°C (41°F)	12 hours	16 hours	25 days
10°C (50°F)	6 hours	9 hours	15 days
20°C (68°F)	2 hours	6 hours	7 days
30°C (86°F)	1 hour	4 hours	4 days
40°C (104°F)	1 hour	3 hours	48 hours

### Notes:

- For cargo hold application: for full cure for hard angular cargoes, please contact your nearest PPG Protective & Marine Coatings sales office
- Adequate ventilation must be maintained during application and curing (please refer to INFORMATION SHEETS 1433 and 1434)
- Should SIGMACOVER 350 or the total coating system (2 x 125 µm/2 x 5.0 mils) be applied in excess of the specified dry film thickness, then the time necessary to reach full cure will be increased

## Pot life (at application viscosity)

Mixed product temperature	Pot life
15°C (59°F)	4 hours
20°C (68°F)	3 hours
30°C (86°F)	2 hours
40°C (104°F)	1 hour

## 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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