

SIGMACOVER™ 410 / AMERCOAT® 410

OVERVIEW

- Place of origin: Indonesia
- Gloss level: Flat
- Dry to touch: 3 hours
- Number of components: 2
- Color: MIO and a selected range of colors

PRODUCT DETAIL

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
- Available in MIO or conventional pigmented grade

COLOR AND GLOSS LEVEL

- MIO and a selected range of colors
- Flat

BASIC DATA AT 20°C (68°F)

| Data for mixed product | |
|--------------------------------|---|
| Number of components | Two |
| Mass density | 1.5 kg/l (12.5 lb/US gal), depending on color MIO: 1.9 kg/l (15.9 lb/US gal) |
| Volume solids | 80 ± 2% |
| VOC (Supplied) | Directive 1999/13/EC, SED: max. 126.0 g/kg UK PG 6/23(92) Appendix 3: max. 240.0 g/l (approx. 2.0 lb/US gal) |
| Recommended dry film thickness | 75 - 200 µm (3.0 - 8.0 mils) depending on system |
| Theoretical spreading rate | 10.7 m ² /l for 75 µm (428 ft ² /US gal for 3.0 mils) |
| Dry to touch | 3 hours |
| Overcoating Interval | Minimum: 8 hours Maximum: Extended |
| 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 |
|-------------------|--|

Notes:

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

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

Substrate conditions

- Suitable primer must be dry and free from any contamination
- When applied to zinc silicate, a mist coat and full coat technique is required

Substrate temperature

- 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

INSTRUCTIONS FOR USE

Mixing ratio by volume: base to hardener 80:20 (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

Induction time: None

Pot life: 6 hours at 20°C (68°F)

Note: See ADDITIONAL DATA – Pot life

Airless spray

Recommended thinner: THINNER 91-92

Volume of thinner: 0 - 10%, 30 - 40% when mist coat applied

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 ² /l (428 ft ² /US gal) |
| 150 µm (6.0 mils) | 5.3 m ² /l (214 ft ² /US gal) |
| 200 µm (8.0 mils) | 4.0 m ² /l (160 ft ² /US gal) |

| Overcoating interval for DFT up to 200 µm (8.0 mils) | | | | | | |
|--|----------|------------|-------------|-------------|-------------|--------------|
| 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 | Minimum | 36 hours | 24 hours | 8 hours | 6 hours | 4 hours |
| | Maximum | Extended | Extended | Extended | Extended | Extended |

Notes:

- This product has an unlimited overcoating interval provided the surface is free from chalking and other contaminations
- The optimum intercoat adhesion is obtained when the subsequent coating is applied before the full cure time of the previous coating has elapsed
- 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.

| Curing time for DFT up to 200 µm (8.0 mils) | | | |
|---|--------------|---------------|-----------|
| 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 |

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

| Pot life (at application viscosity) | |
|-------------------------------------|----------|
| Mixed product temperature | Pot life |
| 10°C (50°F) | 12 hours |
| 15°C (59°F) | 10 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

- 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.