SIGMACOVER™ 430

OVERVIEW

- Place of origin: Indonesia
- Gloss level: Eggshell
- Dry to touch: 2 hours
- Number of components: 2
- Color: Light and dark gray

PRODUCT DETAIL

DESCRIPTION

Two-component, high-build, micaceous iron oxide-pigmented, polyamide-cured recoatable epoxy coating

PRINCIPAL CHARACTERISTICS

- General-purpose epoxy buildcoat or finish in protective coating systems, for steel and concrete structures exposed to atmospheric land or marine conditions
- Good durability
- Good flow and wetting properties
- Easy application by airless spray
- Good cure at temperatures down to -5°C

COLOR AND GLOSS LEVEL

- Light and dark gray
- Eggshell

BASIC DATA AT 20°C (68°F)

Data for mixed product	
Number of components	Two
Mass density	1.4 g/cm3
Volume solids	64 ± 2%
VOC (Supplied)	2.87 lb/us gal - 345g/L
Recommended dry film thickness	75 - 150 µm (3.0 - 6.0 mils) depending on system
Theoretical spreading rate	8.5m2
Dry to touch	2 hours
Overcoating Interval	Minimum: 3 hours Maximum: Unlimited
Full cure after	5 days

Shelf life	Base: at least 12 months when stored cool and dry Hardener: at least 12 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

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

Substrate conditions

- Steel; blast cleaned to ISO-Sa2½, blasting profile 40 – 70 µm (1.6 – 2.8 mils)
- Steel with approved zinc silicate shop primer; pretreated according to SPSS or power tool cleaned to SSPC SP3 (SPSS-Pt3)
- Previous coat must be sound, dry and free from any contamination

Substrate temperature

- Substrate temperature during application and curing down to -10°C (14°F) is acceptable; provided the substrate is free from ice and dry
- Substrate temperature during application and curing should be at least 3°C (5°F) above dew point

SYSTEM SPECIFICATION

- SYSTEMS FOR BOOTTOP AND TOPSIDE – SYSTEM SHEET 3102
- SYSTEMS FOR DECKS – SYSTEM SHEET 3103

INSTRUCTIONS FOR USE

Mixing ratio by volume: base to hardener 82:18

- 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
- Thinner should be added after mixing the components
- Adding too much thinner results in reduced sag resistance

Induction time: 30min. when substrate temperature lower than 10℃

Pot life: 8 hours at 20°C (68°F)
Note: See ADDITIONAL DATA – Pot life

Air spray:

Recommended thinner: THINNER 91-92
Volume of thinner: 0 - 5%, depending on required thickness and application conditions
Nozzle orifice: 2.0 – 3.0 mm (approx. 0.079 – 0.110 in)
Nozzle pressure: 0.3 - 0.4 MPa (approx. 3 - 4 bar; 44 - 58 p.s.i.)

Airless spray

Recommended thinner: Thinner 91-92

Volume of thinner: 0-10%, depending on required thickness and application conditions

Nozzle orifice: 0,45-0.53mm (approx. 0,018-0.021inch)

Nozzle pressure: 15-25Mpa (approx. 150-250bar, 2130~3500psi)

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)	8.5 m^2/l (337 ft^2/US gal)
100 µm (4.0 mils)	6.4 m^2/l (253 ft^2/US gal)
150 µm (6.0 mils)	4.2 m^2/l (168 ft^2/US gal)
200 µm (6.0 mils)	3.2 m^2/l (168 ft^2/US gal)

- Max. interval is 6 months when not exposure to direct sunlight;
- 2 months when exposure to direct sunlight at high temperature.Surface should be slightly abraded

Curing time for DFT up to 100 µm			
Substrate temperature	**Touch dry**	**Dry to handle**	**Full cure**
-10°C (14°F)	22 hours	36 hours	24 days
-5°C (23°F)	16 hours	18 hours	16 days
5°C (41°F)	6 hours	9 hours	10 days
10°C (50°F)	3.5 hours	4.5 hours	8 days
15°C (59°F)	2 hours	2.5 hours	5 days

Notes:
- If the application temperature is over 15oC, it should be changed to normal version
- Adequate ventilation must be maintained during application and curing

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.