

SIGMARINE™ 24

OVERVIEW

- Place of origin: Indonesia
- Gloss level: Flat
- Dry to touch: 2 hours
- Number of components: 1
- Color: Yellow, brown, red, gray, dark gray (offwhite only on request)

PRODUCT DETAIL

DESCRIPTION

Modified zinc phosphate alkyd primer

PRINCIPAL CHARACTERISTICS

- Economical, general-purpose maintenance and new-building primer
- Suitable for use on superstructures and on steel surfaces not normally exposed to water immersion
- The adhesion of subsequent coats is not affected by long weathering periods of the primer
- Should not be used over zinc primers, except when exposed to dry interior conditions
- To be recoated with conventional paint systems
- A thickness of 75 µm (3.0 mils) can be obtained by spray application in one operation by means of the cross-coat technique

COLOR AND GLOSS LEVEL

- Yellow, brown, red, gray, dark gray (offwhite only on request)
- Flat

BASIC DATA AT 20°C (68°F)

Data for product	
Number of components	One
Mass density	1.4 kg/l (11.7 lb/US gal)
Volume solids	56 ± 2%
VOC (Supplied)	Directive 1999/13/EC, SED: max. 245.0 g/kg max. 343.0 g/l (approx. 2.9 lb/US gal)
Recommended dry film thickness	35 - 75 µm (1.4 - 3.0 mils) per coat
Theoretical spreading rate	16.0 m ² /l for 35 µm (642 ft ² /US gal for 1.4 mils) 7.5 m ² /l for 75 µm (299 ft ² /US gal for 3.0 mils)
Dry to touch	2 hours
Overcoating Interval	Minimum: 24 hours Maximum: Unlimited
Shelf life	At least 24 months when stored cool and dry

Notes:

- See ADDITIONAL DATA – Spreading rate and film thickness
- 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; power tool cleaned to min. ISO-St2
- Shop primed steel; sweep blasted or power tool cleaned to SPSS-Ss or SPSS-Pt2
- Previous coat must be dry and free from any contamination

Substrate temperature and application conditions

- Substrate temperature during application should not exceed 50°C (122°F)
- Substrate temperature during application 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
- SYSTEMS FOR SUPERSTRUCTURE AND DECK FITTINGS – SYSTEM SHEET 3104
- SYSTEMS FOR INTERIOR(S) – SYSTEM SHEET 3105

INSTRUCTIONS FOR USE

- Stir well before use
- 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
- Adequate ventilation must be maintained during application and curing (please refer to INFORMATION SHEETS 1433 and 1434)

Airless spray

Recommended thinner: THINNER 20-05

Volume of thinner: 0 - 3%, depending on required thickness and application conditions

Nozzle orifice: Approx. 0.43 – 0.48 mm (0.017 – 0.019 in)

Nozzle pressure: 12.0 - 15.0 MPa (approx. 120 - 150 bar; 1741 - 2176 p.s.i.)

Brush/roller

Recommended thinner: THINNER 20-05

Volume of thinner: 0 – 2%

Cleaning solvent: THINNER 20-05

ADDITIONAL DATA

Spreading rate and film thickness	
DFT	Theoretical spreading rate
35 µm (1.4 mils)	16.0 m ² /l (642 ft ² /US gal)
75 µm (3.0 mils)	7.5 m ² /l (299 ft ² /US gal)

Curing time for DFT up to 75 µm (3.0 mils)	
Substrate temperature	Dry to touch
5°C (41°F)	3 hours
20°C (68°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.