

# SIGMATHERM™ 350

## OVERVIEW

- Place of origin: Indonesia
- Gloss level: Semi-gloss
- Dry to touch: 1 hours
- Number of components: 1
- Color: White, aluminum (other colors available on request)

## PRODUCT DETAIL

### DESCRIPTION

Heat-resistant silicone/acrylic finish

### PRINCIPAL CHARACTERISTICS

- Excellent resistance against weathering
- A minimum drying time of 3 days at 20°C (68°F) should be allowed before exposure to heat
- Heat-resistant up to 350°C (660°F)
- To be used for the internal and external protection of steel surfaces
- Widely compatible with inorganic zinc primers

### COLOR AND GLOSS LEVEL

- White, aluminum (other colors available on request)
- Semi-gloss

### BASIC DATA AT 20°C (68°F)

Data for product	
Number of components	One
Mass density	White: 1.2 kg/l (10.0 lb/US gal) Aluminum: 1.1 kg/l (9.2 lb/US gal)
Volume solids	White: 39 ± 2% Aluminum: 42 ± 2%
VOC (Supplied)	Directive 1999/13/EC, SED: max. 492 g/kg (white) Directive 1999/13/EC, SED: max. 491 g/kg (aluminum) max. 590.0 g/l (approx. 4.9 lb/gal) (white) max. 540.0 g/l (approx. 4.5 lb/gal) (aluminum)
Recommended dry film thickness	25 - 30 µm (1.0 - 1.2 mils)
Theoretical spreading rate	White: 15.6 m <sup>2</sup> /l for 25 µm (626 ft <sup>2</sup> /US gal for 1.0 mils) Aluminum: 16.8 m <sup>2</sup> /l for 25 µm (674 ft <sup>2</sup> /US gal for 1.0 mils)
Dry to touch	1 hour
Overcoating Interval	Minimum: 18 hours Maximum: Unlimited
Shelf life	At least 24 months when stored cool and dry

## RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

### Substrate conditions

- Thermal aluminum sprayed steel or thermal zinc sprayed steel must be dry and free from any contamination
- Suitable coating (zinc silicate primer) must be dry, free from any contamination and zinc salts
- Steel; blast cleaned to a minimum of ISO-Sa2½, blasting profile 40 – 70 µm (1.6 – 2.8 mils)

### Substrate temperature and application conditions

- Substrate temperature during application should be at least 3°C (5°F) above dew point

## INSTRUCTIONS FOR USE

- By using a mist coat technique, it is possible to apply SIGMATHERM 350 on top of a zinc silicate primer
- Power agitate to uniform consistency

### Air spray

**Recommended thinner:** No thinner should be added

**Nozzle orifice:** 1.5 – 2.0 mm (approx. 0.060 – 0.079 in)

**Nozzle pressure:** 0.3 - 0.4 MPa (approx. 3 - 4 bar; 44 - 58 p.s.i.)

### Airless spray

**Recommended thinner:** No thinner should be added

**Nozzle orifice:** Approx. 0.38 – 0.48 mm (0.015 – 0.019 in)

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

### Brush/roller

- Only for touch-up and spot repair

**Cleaning solvent:** THINNER 21-06

## ADDITIONAL DATA

Spreading rate and film thickness – White	
DFT	Theoretical spreading rate
25 µm (1.0 mils)	15.6 m <sup>2</sup> /l (626 ft <sup>2</sup> /US gal)
30 µm (1.2 mils)	13.0 m <sup>2</sup> /l (521 ft <sup>2</sup> /US gal)

Spreading rate and film thickness – Aluminum	
DFT	Theoretical spreading rate
25 µm (1.0 mils)	16.8 m <sup>2</sup> /l (674 ft <sup>2</sup> /US gal)
30 µm (1.2 mils)	14.0 m <sup>2</sup> /l (561 ft <sup>2</sup> /US gal)

Overcoating interval for DFT up to 30 µm (1.2 mils)					
Overcoating with...	Interval	10°C (50°F)	20°C (68°F)	30°C (86°F)	40°C (104°F)
itself	Minimum	24 hours	18 hours	15 hours	10 hours
	Maximum	Unlimited	Unlimited	Unlimited	Unlimited

Note: Surface should be dry and free from any contamination

Curing time for DFT up to 30 µm (1.2 mils)		
Substrate temperature	Dry to touch	Dry to handle
10°C (50°F)	1.5 hours	3 hours
20°C (68°F)	1 hour	2 hours
30°C (86°F)	45 minutes	1.5 hours
40°C (104°F)	30 minutes	1 hour

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

#### 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.

