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SIGMASHIELD™ 460 LT

DESCRIPTION

Two-component, high solids glass flake reinforced polyamine adduct epoxy coating

PRINCIPAL CHARACTERISTICS

- Excellent abrasion and impact resistance
- Cures at temperatures down to -10°C (14°F)
- Long-term protection at areas subject to heavy wear and tear
- Excellent resistance to corrosion
- Suitable for use on ice-going vessels
- Very low water permeability, due to glass flake barrier
- Resistant to splash and spillage of a wide range of chemicals

COLOR AND GLOSS LEVEL

- Black (other (light) colors on request)
- Gloss

BASIC DATA AT 10°C (50°F)

Data for mixed product	
Number of components	Two
Mass density	1.5 kg/l (12.5 lb/US gal)
Volume solids	81 ± 2%
VOC (Supplied)	Directive 1999/13/EC, SED: max. 150.0 g/kg max. 224.0 g/l (approx. 1.9 lb/US gal)
Recommended dry film thickness	250 - 400 µm (10.0 - 16.0 mils) depending on system
Theoretical spreading rate	3.2 m ² /l for 250 µm (130 ft ² /US gal for 10.0 mils) 2.0 m ² /l for 400 µm (81 ft ² /US gal for 16.0 mils)
Overcoating Interval	Minimum: 16 hours Maximum: 14 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, blasting profile 40 – 70 µm (1.6 – 2.8 mils)
- Suitable primer must be dry and free from any contamination
- At freezing temperatures surface must be free from ice

Substrate temperature and application conditions

- Substrate temperature during application and curing should be between -10°C (14°F) and 15°C (59°F)
- Ambient temperature during application at -10°C (14°F) is acceptable; however curing to hardness takes longer and complete cure will be reached when the temperature increases
- Substrate temperature during application and curing should be at least 3°C (5°F) above dew point
- Relative humidity during application and curing should not exceed 85%

INSTRUCTIONS FOR USE

Mixing ratio by volume: base to hardener 75:25 (3:1)

- The temperature of the mixed base and hardener should preferably be above 5°C (41°F), otherwise extra thinner may be required to obtain application viscosity
- Adding too much thinner results in reduced sag resistance and slower cure
- Very good mechanical mixing of base and hardener is essential
- Thinner should be added after mixing the components
- Filters should be removed from spray equipment

Induction time

None

Pot life

1 hour at 10°C (50°F)

Note: See ADDITIONAL DATA – Pot life

Air spray

Recommended thinner

THINNER 91-92

Volume of thinner

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

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.)



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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. 0.53 - 0.79 mm (0.021 - 0.031 in)

Nozzle pressure

19.0 - 22.5 MPa (approx. 190 - 225 bar; 2756 - 3264 p.s.i.)

Brush/roller

- Brush application only
- Only for touch-up and repair
- Due to thixotropy, it is difficult to obtain a smooth film by brush, although this does not affect performance

Cleaning solvent

THINNER 90-53

ADDITIONAL DATA

Spreading rate and film thickness	
DFT	Theoretical spreading rate
250 µm (10.0 mils)	3.2 m ² /l (130 ft ² /US gal)
400 µm (16.0 mils)	2.0 m ² /l (81 ft ² /US gal)

Note: Maximum DFT when brushing: 80 µm (3.1 mils)

Overcoating interval for DFT up to 400 µm (16.0 mils)						
Overcoating with...	Interval	-10°C (14°F)	0°C (32°F)	5°C (41°F)	10°C (50°F)	15°C (59°F)
itself	Minimum	3 days	36 hours	28 hours	16 hours	12 hours
	Maximum	28 days	28 days	28 days	14 days	7 days

Note: Surface should be dry and free from chalking and contamination

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Curing time for DFT up to 400 µm (16.0 mils)		
Substrate temperature	Dry to handle	Service- water immersion
-10°C (14°F)	3 days	N/A
0°C (32°F)	36 hours	18 days
5°C (41°F)	28 hours	10 days
10°C (50°F)	16 hours	7 days
15°C (59°F)	12 hours	5 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
5°C (41°F)	2 hours
10°C (50°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

• CONVERSION TABLES	INFORMATION SHEET	1410
• 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
• CLEANING OF STEEL AND REMOVAL OF RUST	INFORMATION SHEET	1490
• SPECIFICATION FOR MINERAL ABRASIVES	INFORMATION SHEET	1491
• RELATIVE HUMIDITY – SUBSTRATE TEMPERATURE – AIR TEMPERATURE	INFORMATION SHEET	1650



SIGMASHIELD™ 460 LT

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