



# New Guard Coatings Group

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This information is not exhaustive and it is the user's responsibility to ensure that this data sheet is the most current by contacting their local New Guard Coatings Group branch prior to using the coating/product.

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# SIGMACOVER™ 410 LT

## 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
- Good drying- and curing properties at low substrate temperature (down to -5°C (23°F))

## COLOR AND GLOSS LEVEL

- MIO and a selected range of colors
- Flat

## BASIC DATA AT 10°C (50°F)

Data for mixed product	
<b>Number of components</b>	Two
<b>Mass density</b>	1.5 kg/l (12.5 lb/US gal), depending on color MIO: 1.8 kg/l (15.0 lb/US gal)
<b>Volume solids</b>	80 ± 2%
<b>VOC (Supplied)</b>	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)
<b>Recommended dry film thickness</b>	75 - 200 µm (3.0 - 8.0 mils) depending on system
<b>Theoretical spreading rate</b>	10.7 m <sup>2</sup> /l for 75 µm (428 ft <sup>2</sup> /US gal for 3.0 mils)
<b>Dry to touch</b>	4 hours
<b>Overcoating Interval</b>	Minimum: 12 hours Maximum: Extended
<b>Full cure after</b>	7 days
<b>Shelf life</b>	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

- Suitable primer must be dry and free from any contamination
- Surface of previous coat should be sufficiently roughened if necessary
- When applied to zinc silicate, a mist coat and full coat technique is required

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### Substrate temperature

- Substrate temperature during application and curing should be above -5°C (23°F)
- Substrate temperature during application and curing should be at least 3°C (5°F) above dew point
- Ambient temperature during application at -5°C (23°F) is acceptable; however curing to hardness takes longer and complete cure will be reached when the temperature increases

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## INSTRUCTIONS FOR USE

### Mixing ratio by volume: base to hardener 80:20 (4:1)

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

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### Induction time

None

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### Pot life

10 hours at 10°C (50°F)

Note: See ADDITIONAL DATA – Pot life

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### 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.)

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

Overcoating interval for DFT up to 200 µm (8.0 mils)						
Overcoating with...	Interval	-5°C (23°F)	0°C (32°F)	5°C (41°F)	10°C (50°F)	15°C (59°F)
For various two-pack epoxy or polyurethane paint	Minimum	48 hours	24 hours	16 hours	12 hours	8 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
- 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.
- The optimum intercoat adhesion is obtained when the subsequent coating is applied before the full cure time of the previous coating has elapsed

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Curing time for DFT up to 150 µm (6.0 mils)			
Substrate temperature	Dry to touch	Dry to handle	Full cure
-5°C (23°F)	16 hours	24 hours	20 days
0°C (32°F)	11 hours	16 hours	14 days
5°C (41°F)	6 hours	10 hours	10 days
10°C (50°F)	4 hours	8 hours	7 days
15°C (59°F)	3 hours	5 hours	5 days

Note: Adequate ventilation must be maintained during application and curing (please refer to INFORMATION SHEETS 1422 and 1434)

Pot life (at application viscosity)	
Mixed product temperature	Pot life
10°C (50°F)	10 hours
15°C (59°F)	6 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.

## REFERENCES

• 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



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## WARRANTY

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