



New Guard Coatings Group

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NORTH • SOUTH EAST • MIDLANDS • NORTH WEST • HULL • SCOTLAND

SIGMAFAST™ 302

DESCRIPTION

Two-component, silicate zinc epoxy primer

PRINCIPAL CHARACTERISTICS

- Good anticorrosive properties
- Fast-curing
- Fast-handling
- Cures at temperatures down to -5°C (23°F)
- Reduced risk of mud cracking
- Topcoats must be unsaponifiable

COLOR AND GLOSS LEVEL

- Bluegreen, gray
- Flat

BASIC DATA AT 20°C (68°F)

Data for mixed product	
Number of components	Two
Mass density	2.1 kg/l (17.5 lb/US gal)
Volume solids	63 ± 2%
VOC (Supplied)	Directive 1999/13/EC, SED: max. 204.0 g/kg max. 419.0 g/l (approx. 3.5 lb/US gal)
Recommended dry film thickness	50 - 80 µm (2.0 - 3.1 mils) depending on system
Theoretical spreading rate	12.6 m ² /l for 50 µm (505 ft ² /US gal for 2.0 mils)
Dry to touch	10 minutes
Overcoating Interval	Minimum: 25 minutes Maximum: 12 months
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

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

Substrate conditions

- Steel; blast cleaned to ISO-Sa2½, blasting profile 40 - 70 µm (1.6 - 2.8 mils)



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Substrate temperature and application conditions

- Substrate temperature during application at -5°C (23°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
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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 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 and slower cure
 - Thinner should be added after mixing the components
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Pot life

4 hours at 20°C (68°F)

Air spray

Recommended thinner

THINNER 21-06

Volume of thinner

15 - 20%, depending on required thickness and application conditions

Nozzle orifice

1.6 mm (approx. 0.063 in)

Nozzle pressure

0.3 - 0.6 MPa (approx. 3 - 6 bar; 44 - 87 p.s.i.)

Airless spray

Recommended thinner

THINNER 21-06

Volume of thinner

5 - 15%, depending on required thickness and application conditions

Nozzle orifice

Approx. 0.38 - 0.53 mm (0.015 - 0.021 in)

Nozzle pressure

15.0 MPa (approx. 150 bar; 2176 p.s.i.)

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Brush/roller

Recommended thinner

THINNER 21-06

Volume of thinner

0 – 5%

Cleaning solvent

THINNER 90-53

ADDITIONAL DATA

Spreading rate and film thickness	
DFT	Theoretical spreading rate
50 µm (2.0 mils)	12.6 m ² /l (505 ft ² /US gal)
80 µm (3.1 mils)	7.9 m ² /l (326 ft ² /US gal)

Overcoating interval for DFT up to 50 µm (2.0 mils)						
Overcoating with...	Interval	-5°C (23°F)	0°C (32°F)	10°C (50°F)	20°C (68°F)	30°C (86°F)
various two-component epoxy coatings	Minimum	1 hour	45 minutes	30 minutes	25 minutes	20 minutes
	Maximum	12 months	12 months	12 months	12 months	12 months

Overcoating interval for DFT up to 80 µm (3.1 mils)						
Overcoating with...	Interval	-5°C (23°F)	0°C (32°F)	10°C (50°F)	20°C (68°F)	30°C (86°F)
various two-pack epoxy coatings	Minimum	1.5 hours	1 hour	50 minutes	40 minutes	35 minutes
	Maximum	12 months	12 months	12 months	12 months	12 months

Notes:

- Surface should be dry and free from any contamination
- An interval of several months can be allowed under clean interior exposure conditions
- Before overcoating any visible surface contamination must be removed by sandwashing, sweep blasting or mechanical cleaning



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Curing time for DFT up to 80 µm (3.1 mils)		
Substrate temperature	Dry to touch	Dry to handle
-5°C (23°F)	1 hour	1.5 hours
0°C (32°F)	40 minutes	1 hour
10°C (50°F)	25 minutes	50 minutes
20°C (68°F)	10 minutes	40 minutes
30°C (86°F)	less than 10 minutes	35 minutes

Note: 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.

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

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