

SIGMACOVER™ 480

DESCRIPTION

Two-component, chemical-resistant finish, based on polyamide cured epoxy resins

PRINCIPAL CHARACTERISTICS

- General-purpose epoxy finish
- Easy application by brush/roller and (airless) spray
- Good water resistance
- Good chemical resistance to spillage and splash
- Resistant to impact and abrasion
- Easy to clean

COLOR AND GLOSS LEVEL

- Selected range of colors available
- Semi-gloss

BASIC DATA AT 20°C (68°F)

Data for mixed product	
Number of components	Two
Mass density	1.4 kg/l (11.7 lb/US gal)
Volume solids	50 ± 2%
VOC (Supplied)	Directive 1999/13/EC, SED: max. 308.0 g/kg max. 418.0 g/l (approx. 3.5 lb/US gal)
Recommended dry film thickness	50 µm (2.0 mils)
Theoretical spreading rate	10.0 m ² /l for 50 µm (401 ft ² /US gal for 2.0 mils)
Dry to touch	30 minutes
Overcoating Interval	Minimum: 8 hours Maximum: 3 months
Full cure after	7 days
Shelf life	Base: at least 12 months when stored cool and dry Hardener: at least 12 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

- Previous coat must be dry and free from any contamination
 - Previous coat: surface should be sufficiently roughened if necessary
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Substrate temperature

- Substrate temperature during application and curing should be above 5°C (41°F)
 - 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 76:24

- 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
 - Thinner should be added after mixing the components
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Pot life

8 hours at 20°C (68°F)

Note: See ADDITIONAL DATA – Pot life

Air spray

Recommended thinner

THINNER 91-92

Volume of thinner

10 - 15%, depending on required thickness and application conditions

Nozzle orifice

2.0 mm (approx. 0.079 in)

Nozzle pressure

0.3 MPa (approx. 3 Bar; 44 p.s.i.)

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Airless spray

Recommended thinner

THINNER 91-92

Volume of thinner

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

Nozzle orifice

Approx. 0.46 mm (0.018 in)

Nozzle pressure

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

Brush/roller

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
40 µm (1.6 mils)	12.5 m ² /l (501 ft ² /US gal)
50 µm (2.0 mils)	10.0 m ² /l (401 ft ² /US gal)
60 µm (2.4 mils)	8.3 m ² /l (334 ft ² /US gal)

Overcoating interval for DFT up to 50 µm (2.0 mils)						
Overcoating with...	Interval	5°C (41°F)	10°C (50°F)	20°C (68°F)	30°C (86°F)	40°C (104°F)
itself	Minimum	36 hours	24 hours	12 hours	8 hours	6 hours
	Maximum	3 months	3 months	3 months	2 months	2 months

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

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Curing time for DFT up to 50 µm (2.0 mils)			
Substrate temperature	Dry to touch	Dry to handle	Full cure
5°C (41°F)	4 hours	12 hours	21 days
10°C (50°F)	2 hours	8 hours	14 days
15°C (59°F)	1 hour	6 hours	10 days
20°C (68°F)	30 minutes	4 hours	7 days
30°C (86°F)	30 minutes	3 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
15°C (59°F)	12 hours
20°C (68°F)	8 hours
30°C (86°F)	5 hours
40°C (104°F)	3 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

• 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
• RELATIVE HUMIDITY – SUBSTRATE TEMPERATURE – AIR TEMPERATURE	INFORMATION SHEET	1650

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