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.

April 30, 2018 (Revision of February 5, 2015)

SIGMACOVER™ 350 LT

DESCRIPTION

Two-component, high-build polyamide cured epoxy primer/coating

PRINCIPAL CHARACTERISTICS

- Surface tolerant primer/coating for topsides, decks, superstructures and cargo holds
- Good impact and abrasion resistance
- Compatible with various aged coatings
- Excellent corrosion resistance
- Resistant to splash and spillage of a wide range of chemicals
- Cures at temperatures down to -5°C (23°F)
- Smooth film, easy to clean

COLOR AND GLOSS LEVEL

- Standard and custom colors, including aluminum
- For Cargo holds gray (5177) and redbrown (6179) only
- Semi-gloss

BASIC DATA AT 10°C (50°F)

Data for mixed product	
Number of components	Two
Mass density	1.4 kg/l (11.7 lb/US gal)
Volume solids	74 ± 2%
VOC (Supplied)	Directive 1999/13/EC, SED: max. 264.0 g/kg max. 361.0 g/l (approx. 3.0 lb/US gal)
Recommended dry film thickness	100 - 150 µm (4.0 - 6.0 mils) for airless spray
Theoretical spreading rate	5.9 m^2/l for 125 µm (237 ft^2/US gal for 5.0 mils) 4.9 m^2/l for 150 µm (198 ft^2/US gal for 6.0 mils)
Dry to touch	4 hours
Overcoating Interval	Minimum: 8 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 for excellent corrosion protection, blasting profile 40 – 70 µm (1.6 – 2.8 mils)
- Steel; blast cleaned to ISO-Sa2, blasting profile 40 – 70 µm (1.6 – 2.8 mils) or power tool cleaned to ISO-St2 for good corrosion protection
- Previous coat must be dry and free from any contamination
- Previous coat: surface should be sufficiently roughened if necessary
- At freezing temperatures surface must be free from ice

Substrate temperature and application conditions

- Substrate temperature during application and curing should be between -5°C (23°F) and 15°C (59°F)
- Substrate temperature during application and curing should be at least 3°C (5°F) above dew point

SYSTEM SPECIFICATION

- SIGMACOVER 350 LT: 2 x 125 µm (5.0 mils) DFT

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 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
- Thinner should be added after mixing the components

Pot life

3 hours 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

1.8 – 2.0 mm (approx. 0.070 – 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 - 10%, depending on required thickness and application conditions

Nozzle orifice
Approx. 0.48 – 0.53 mm (0.019 – 0.021 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 91-92

ADDITIONAL DATA

Spreading rate and film thickness	
DFT	**Theoretical spreading rate**
100 µm (4.0 mils)	7.4 m^2/l (297 ft^2/US gal)
125 µm (5.0 mils)	5.9 m^2/l (237 ft^2/US gal)
150 µm (6.0 mils)	4.9 m^2/l (198 ft^2/US gal)

Note: Maximum DFT when brushing: 100 µm (4.0 mils)

Overcoating interval for DFT up to 150 µm (6.0 mils)						
Overcoating with...	**Interval**	**-5°C (23°F)**	**0°C (32°F)**	**5°C (41°F)**	**10°C (50°F)**	**15°C (59°F)**
epoxy coatings	Minimum	36 hours	24 hours	12 hours	8 hours	6 hours
	Maximum	28 days	28 days	28 days	14 days	10 days
polyurethanes	Minimum	3 days	48 hours	24 hours	16 hours	12 hours
	Maximum	28 days	28 days	21 days	10 days	7 days

Note: Surface should be dry and free from any contamination and ice

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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)	24 hours	32 hours	16 days
0°C (32°F)	16 hours	20 hours	12 days
5°C (41°F)	8 hours	10 hours	9 days
10°C (50°F)	4 hours	6 hours	7 days
15°C (59°F)	2 hours	4 hours	4 days

Notes:

- For cargo hold application: for full cure for hard angular cargoes, please contact your nearest PPG Protective & Marine Coatings sales office
- Adequate ventilation must be maintained during application and curing (please refer to INFORMATION SHEETS 1433 and 1434)
- Should SIGMACOVER 350 LT or the total coating system (2 x 125 µm/2 x 5.0 mils) be applied in excess of the specified dry film thickness, then the time necessary to reach full cure will be increased

Pot life (at application viscosity)	
Mixed product temperature	**Pot life**
10°C (50°F)	3 hours
15°C (59°F)	2 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

SIGMACOVER™ 350 LT

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