



# 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.

[www.newguardcoatings.com](http://www.newguardcoatings.com)

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# SIGMACOVER 400 SEALER

## (SigmaCover 640 Sealer)

4 pages

January 2014  
Revision of October 2012

<b>Description</b>	two component surface tolerant solvent free rust penetrating epoxy sealer
<b>PRINCIPAL CHARACTERISTICS</b>	<ul style="list-style-type: none"> <li>– penetrates rust and adheres to aged coatings</li> <li>– surface tolerant coating for lower grade of steel preparation</li> <li>– primer for concrete surfaces</li> <li>– compatible with prepared damp surfaces</li> <li>– low dry film thickness</li> </ul>
<b>COLOURS AND GLOSS</b>	green, cream, clear – gloss
<b>BASIC DATA AT 20°C</b>	(1 g/cm <sup>3</sup> = 8.35 lb/US gal; 1 m <sup>2</sup> /l = 40.7 ft <sup>2</sup> /US gal) (data for mixed product)
Mass density	1.1 g/cm <sup>3</sup>
Volume solids	100%
VOC (Supplied)	max. 0 g/kg (Directive 1999/13/EC, SED) max. 0 g/l (0.0 lb/gal)
Recommended dry film thickness	40 µm
Theoretical spreading rate	25 m <sup>2</sup> /l for 40 µm
Touch dry after	6 hours* at 20°C * see additional data
Overcoating interval	max. 1 month * min. 24 hours
Full cure after	5 days at 20°C *
Shelf life (cool and dry place)	(data for components) at least 12 months * see additional data
<b>RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES</b>	<ul style="list-style-type: none"> <li>– steel; blast cleaned to ISO-Sa2 or power tool cleaned to ISO-St2</li> <li>– shop primed steel; pretreated to SPSS-Pt3 / SSPC-SP3</li> <li>– coated steel; hydrojetted to VIS WJ2/3L</li> <li>– substrate temperature should be above 5°C and at least 3°C above dew point during application and curing</li> </ul>
<b>INSTRUCTIONS FOR USE</b>	mixing ratio by volume: base to hardener 1 : 1
Induction time	<ul style="list-style-type: none"> <li>– the temperature of the mixed base and hardener should preferably be at least 20°C</li> <li>– no thinner should be added</li> </ul>
Pot life	none approx. 1 hour at 20°C * see additional data

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## AIRLESS SPRAY

Recommended thinner no thinner should be added  
 Nozzle orifice approx. 0.48 mm (= 0.019 in)  
 Nozzle pressure at 20°C (paint temperature) min. 15 MPa (= approx. 150 bar; 2176 p.s.i.)

## BRUSH/ROLLER

Recommended thinner no thinner should be added

## CLEANING SOLVENT

Thinner 90-83 (preferred) or Thinner 90-53  
 – all equipment used for application must be cleaned immediately after use  
 – paint inside the spraying equipment must be removed before the pot life time has been expired

### Film thickness and spreading rate

theoretical spreading rate m <sup>2</sup> /l	25 m <sup>2</sup> /l	16.7 m <sup>2</sup> /l
dft in µm	40 µm	60 µm

### Overcoating table for dft up to 40 µm

substrate temperature	5°C	10°C	20°C	30°C
minimum interval	24 hours	18 hours	12 hours	8 hours
maximum interval	1 month	1 month	1 month	1 month

for e.g. SigmaCover 456,  
SigmaCover 385, SigmaCover 400

- surface should be dry and free from any contamination
- best intercoat adhesion occurs when the subsequent coat is applied before the fully cured stage is reached
- if this time is exceeded the surface has to be roughened

## Curing

### Curing table for dft up to 40 µm

substrate temperature	dry to handle	full cure
5°C	48 hours	15 days
10°C	36 hours	7 days
20°C	28 hours	5 days
30°C	22 hours	3 days

- adequate ventilation must be maintained during application and curing (please refer to sheets 1433 and 1434)

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### Pot life (at application viscosity)

10°C	100 min.
20°C	60 min.

due to exothermic reaction, temperature during pot life may increase up to 60°C at gel point

### 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	see information sheet 1410
Explanation to product data sheets	see information sheet 1411
Safety indications	see information sheet 1430
explosion hazard- toxic hazard	see information sheet 1431
Safe working in confined spaces	see information sheet 1433
Directives for ventilation practice	see information sheet 1434
Cleaning of steel and removal of rust	see information sheet 1490
Specification for mineral abrasives	see information sheet 1491
Relative humidity - substrate temperature - air temperature	see information sheet 1650

### SAFETY PRECAUTIONS

- for paint and recommended thinners see safety sheets 1430, 1431 and relevant material safety data sheets
- although this is a solvent free paint, care should be taken to avoid inhalation of spray mist as well as contact between the wet paint and exposed skin or eyes
  - no solvent present ; however, spray mist is not harmless, a fresh air mask and gloves should be used during spraying
  - ventilation should be provided in confined spaces to maintain good visibility

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### WARRANTY

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