



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

SIGMACOVER™ 805

DESCRIPTION

Two-component, high solids polyamine adduct cured epoxy coating

PRINCIPAL CHARACTERISTICS

- Can be used directly to metal
- Very good surface wetting
- Excellent corrosion resistance
- Outstanding (sea)water resistance
- Resistant to well designed/controlled cathodic protection
- Good resistance against chemically-polluted water
- Good abrasion resistance
- Tar free

COLOR AND GLOSS LEVEL

- Limited color range available
- Gloss

BASIC DATA AT 20°C (68°F)

Data for mixed product	
Number of components	Two
Mass density	1.6 kg/l (13.4 lb/US gal)
Volume solids	82 ± 2%
VOC (Supplied)	Directive 1999/13/EC, SED: max. 158.0 g/kg max. 221.0 g/l (approx. 1.8 lb/US gal)
Recommended dry film thickness	150 - 250 µm (6.0 - 10.0 mils) depending on requirements
Theoretical spreading rate	5.5 m ² /l for 150 µm (219 ft ² /US gal for 6.0 mils)
Dry to touch	3 hours
Overcoating Interval	Minimum: 16 hours Maximum: 28 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

Immersion exposure

- Steel; blast cleaned to ISO-Sa2½, blasting profile 40 – 70 µm (1.6 – 2.8 mils)
- Steel with approved zinc silicate shop primer; pretreated according to SPSS-Ss

Atmospheric exposure conditions

- Steel; pretreated preferably to ISO-Sa2½, , blasting profile 40 – 70 µm (1.6 – 2.8 mils) or according to ISO-St3
- Shop primed steel; pretreated to SPSS-Pt3

Substrate conditions

- Previous coat (specific epoxy) must be dry and free from any contamination and within overcoating time

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

INSTRUCTIONS FOR USE

Mixing ratio by volume: base to hardener 75:25 (3:1)

- 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

Pot life

2 hours at 20°C (68°F)

Note: See ADDITIONAL DATA – Pot life

Airless spray

Recommended thinner

THINNER 91-92

Volume of thinner

0 - 5%, 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.)



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Cleaning solvent

THINNER 90-53

ADDITIONAL DATA

Spreading rate and film thickness

DFT	Theoretical spreading rate
150 µm (6.0 mils)	5.5 m ² /l (219 ft ² /US gal)
250 µm (10.0 mils)	3.3 m ² /l (132 ft ² /US gal)

Overcoating interval for DFT up to 150 µm (6.0 mils)

Overcoating with...	Interval	5°C (41°F)	10°C (50°F)	20°C (68°F)	30°C (86°F)
itself	Minimum	36 hours	24 hours	16 hours	8 hours
	Maximum	28 days	28 days	28 days	14 days

Notes:

- Surface should be dry and free from any contamination
- For polyurethane paints like SIGMADUR 550 and SIGMADUR 520 the minimum overcoating time should be raised with 50%
- Adequate ventilation must be maintained during application and curing (please refer to INFORMATION SHEETS 1433 and 1434)

Curing time for DFT up to 150 µm (6.0 mils)

Substrate temperature	Service- water immersion
5°C (41°F)	10 days
10°C (50°F)	7 days
15°C (59°F)	5 days
20°C (68°F)	3 days
30°C (86°F)	60 hours
40°C (104°F)	36 hours

Pot life (at application viscosity)

Mixed product temperature	Pot life
15°C (59°F)	3 hours
20°C (68°F)	2 hours
30°C (86°F)	1 hour
40°C (104°F)	30 minutes

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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
• SPECIFICATION FOR MINERAL ABRASIVES	INFORMATION SHEET	1491
• RELATIVE HUMIDITY – SUBSTRATE TEMPERATURE – AIR TEMPERATURE	INFORMATION SHEET	1650

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