

# New Guard Coatings Group

A global reputation to protect.

You have acquired this data sheet from the New Guard Coatings Group.

All information listed is correct at the time of print.



[uksales@newguardcoatings.com](mailto:uksales@newguardcoatings.com)



+44 1937 586311

Global Head Office: New Guard Coatings Ltd, Sandbeck Way, Wetherby, Leeds, LS22 7DN



# 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 <sup>2</sup> /l for 50 µm (505 ft <sup>2</sup> /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)



# SIGMAFAST™ 302

## **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
- 

## **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
- 

### **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.)

---

# SIGMAFAST™ 302

**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 <sup>2</sup> /l (505 ft <sup>2</sup> /US gal)
80 µm (3.1 mils)	7.9 m <sup>2</sup> /l (326 ft <sup>2</sup> /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



# SIGMAFAST™ 302

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

## WARRANTY

PPG warrants (i) its title to the product, (ii) that the quality of the product conforms to PPG's specifications for such product in effect at the time of manufacture and (iii) that the product shall be delivered free of the rightful claim of any third person for infringement of any U.S. patent covering the product. THESE ARE THE ONLY WARRANTIES THAT PPG MAKES AND ALL OTHER EXPRESS OR IMPLIED WARRANTIES, UNDER STATUTE OR ARISING OTHERWISE IN LAW, FROM A COURSE OF DEALING OR USAGE OF TRADE, INCLUDING WITHOUT LIMITATION, ANY OTHER WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE OR USE, ARE DISCLAIMED BY PPG. Any claim under this warranty must be made by Buyer to PPG in writing within five (5) days of Buyer's discovery of the claimed defect, but in no event later than the expiration of the applicable shelf life of the product, or one year from the date of the delivery of the product to the Buyer, whichever is earlier. Buyer's failure to notify PPG of such non-conformance as required herein shall bar Buyer from recovery under this warranty.

# SIGMAFAST™ 302

## LIMITATIONS OF LIABILITY

IN NO EVENT WILL PPG BE LIABLE UNDER ANY THEORY OF RECOVERY (WHETHER BASED ON NEGLIGENCE OF ANY KIND, STRICT LIABILITY OR TORT) FOR ANY INDIRECT, SPECIAL, INCIDENTAL, OR CONSEQUENTIAL DAMAGES IN ANY WAY RELATED TO, ARISING FROM, OR RESULTING FROM ANY USE MADE OF THE PRODUCT. The information in this sheet is intended for guidance only and is based upon laboratory tests that PPG believes to be reliable. PPG may modify the information contained herein at any time as a result of practical experience and continuous product development. All recommendations or suggestions relating to the use of the PPG product, whether in technical documentation, or in response to a specific inquiry, or otherwise, are based on data, which to the best of PPG's knowledge, is reliable. The product and related information is designed for users having the requisite knowledge and industrial skills in the industry and it is the end-user's responsibility to determine the suitability of the product for its own particular use and it shall be deemed that Buyer has done so, as its sole discretion and risk. PPG has no control over either the quality or condition of the substrate, or the many factors affecting the use and application of the product. Therefore, PPG does not accept any liability arising from any loss, injury or damage resulting from such use or the contents of this information (unless there are written agreements stating otherwise). Variations in the application environment, changes in procedures of use, or extrapolation of data may cause unsatisfactory results. This sheet supersedes all previous versions and it is the Buyer's responsibility to ensure that this information is current prior to using the product. Current sheets for all PPG Protective & Marine Coatings Products are maintained at [www.ppgpmc.com](http://www.ppgpmc.com). The English text of this sheet shall prevail over any translation thereof.

The PPG logo, and all other PPG marks are property of the PPG group of companies. All other third-party marks are property of their respective owners.

