



# New Guard Coatings Group

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

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# SIGMAFAST HS ENAMEL

4 pages

August 2012  
Revision of November 2004

**Description** one component, modified acrylic based, air drying industrial enamel

**PRINCIPAL CHARACTERISTICS**

- fast drying
- good exterior durability
- excellent gloss and colour retention
- VOC compliant as a finish

**COLOURS AND GLOSS** Wide range of colours, lead free: BS 4800, BS381C, RAL – gloss

**BASIC DATA AT 20 °C** (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)

Mass density 1.1 - 1.3 g/cm<sup>3</sup> ( depending on colour)

Volume solids 53% ± 2%

VOC (UK PG 6/23(92) appendix 3) max. 420 g/l (approx. 3.5 lb/gal)  
(UK PG 6/23(92) Appendix 3)

Recommended dry film thickness 25 - 40 µm ( can be achieved by a single coat application or using a "wet on wet" technique)

Theoretical spreading rate 21.2 m<sup>2</sup>/l for 25 µm  
13.3 m<sup>2</sup>/l for 40 µm \*

Touch dry after 40 min. at 20 °C

Overcoating interval see overcoating table \*

Shelf life (cool and dry place) at least 12 months

**RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES**

- can be applied on most sound clean paint systems or onto clean bare metal which has been primed with a suitable primer
- application temperature range 5 - 30 °C
- substrate temperature should be at least 3°C above dew point
- maximum relative humidity during application and curing is 85%

**INSTRUCTIONS FOR USE**

- stir well before use
- the temperature of the paint should preferably be above 15°C, otherwise extra thinner may be required to obtain application viscosity
- too much solvent results in reduced sag resistance
- adequate ventilation must be maintained during application and curing (please refer to sheets 1433 and 1434)
- addition of thinner may increase the VOC value of the product to greater than 420 g/litre

## AIR SPRAY

Recommended thinner no extra thinner should be required but if necessary Thinner 21-06 can be added to the mixed components

Volume of thinner 0 - 5%, depending on required thickness and application conditions

Nozzle orifice 1.5 - 2 mm

Nozzle pressure 0.3 - 0.4 MPa (= approx. 3 - 4 bar; 44 - 58 p.s.i.)

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## AIRLESS SPRAY

Recommended thinner no extra thinner should be required but if necessary Thinner 21-06 can be added to the mixed components

Volume of thinner 0 - 5%, depending on required thickness and application conditions

Nozzle orifice approx. 0.33 - 0.43 mm (= 0.013 - 0.017 in)

Nozzle pressure 15 - 28 MPa (= approx. 2176 - 4061 p.s.i.)

## BRUSH/ROLLER

Recommended thinner no extra thinner is required but if necessary Thinner 21-06 can be added if desired to mixed components

Volume of thinner 0 - 5% if required

### Overcoating table for SigmaFast HS Enamel for dft up to 25 µm

with itself	substrate temperature	5°C	20°C	30°C
	minimum interval	8 hours	5 hours	2 hours
	maximum interval	30 hours	24 hours	16 hours

– wrinkling of the topcoat may occur if overcoating takes place between the times stated

## Curing

### Drying table

substrate temperature	touch dry	full cure	dry to handle
5°C	75 min.	24 hours	120 min.
20°C	40 min.	24 hours	60 min.
30°C	30 min.	12 hours	50 min.

## Worldwide availability

Whilst it is always the aim of Sigma Coatings to supply the same product on a worldwide basis, 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

Safety in confined spaces and health safety

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

Relative humidity - substrate temperature - air temperature see information sheet 1650



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The English text of this data sheet shall prevail over any translation thereof.

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