



# New Guard Coatings Group

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# SIGMAGUARD™ 260

## DESCRIPTION

Two-component, high-build, amine adduct-cured novolac phenolic epoxy holding primer

## PRINCIPAL CHARACTERISTICS

- Holding primer for SIGMAGUARD CSF 650, NOVAGUARD 840 and NOVAGUARD 890
- Can be applied and cures at temperatures down to 5°C (41°F)
- Good application properties, resulting in a smooth surface
- Good abrasion resistance

## COLOR AND GLOSS LEVEL

- Pink
- Eggshell

## BASIC DATA AT 20°C (68°F)

Data for mixed product	
Number of components	Two
Mass density	1.7 kg/l (14.2 lb/US gal)
Volume solids	68 ± 2%
VOC (Supplied)	Directive 1999/13/EC, SED: max. 194.0 g/kg max. 328.0 g/l (approx. 2.7 lb/US gal)
Recommended dry film thickness	50 - 75 µm (2.0 - 3.0 mils)
Theoretical spreading rate	9.1 m <sup>2</sup> /l for 75 µm (364 ft <sup>2</sup> /US gal for 3.0 mils) 13.7 m <sup>2</sup> /l for 50 µm (545 ft <sup>2</sup> /US gal for 2.0 mils)
Dry to touch	3 hours
Overcoating Interval	Minimum: 8 hours Maximum: 1 month
Full cure after	See curing table
Shelf life	Base: at least 12 months when stored cool and dry Hardener: at least 12 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 a minimum of ISO-Sa2½
- Blasting profile 50 – 100 µm (2.0 – 4.0 mils)
- The substrate must be perfectly dry before and during application of SIGMAGUARD 260

### Substrate temperature and application conditions

- Substrate temperature during application and curing should be above 5°C (41°F)
- Substrate temperature during application should be at least 3°C (5°F) above dew point

## INSTRUCTIONS FOR USE

### Mixing ratio by volume: base to hardener 87:13

- 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

### Induction time

Allow induction time before use

Mixed product induction time	
Mixed product temperature	Induction time
5°C (41°F)	20 minutes
10°C (50°F)	15 minutes
15°C (59°F)	10 minutes

### Pot life

2 hours at 20°C (68°F)

Note: See ADDITIONAL DATA – Pot life

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## Air spray

### **Recommended thinner**

THINNER 91-92

### **Volume of thinner**

5 - 10%, depending on required thickness and application conditions

### **Nozzle orifice**

2.0 mm (approx. 0.079 in)

### **Nozzle pressure**

0.3 MPa (approx. 3 Bar; 44 p.s.i.)

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## Airless spray

### **Recommended thinner**

THINNER 91-92

### **Volume of thinner**

5 - 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.)

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## Brush/roller

- Only for touch-up and spot repair

### **Recommended thinner**

THINNER 91-92

### **Volume of thinner**

0 – 5%

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## Cleaning solvent

THINNER 90-53

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# SIGMAGUARD™ 260

## ADDITIONAL DATA

Spreading rate and film thickness	
DFT	Theoretical spreading rate
50 µm (2.0 mils)	13.6 m <sup>2</sup> /l (545 ft <sup>2</sup> /US gal)
75 µm (3.0 mils)	9.1 m <sup>2</sup> /l (364 ft <sup>2</sup> /US gal)
100 µm (4.0 mils)	6.8 m <sup>2</sup> /l (273 ft <sup>2</sup> /US gal)

Note: Maximum DFT when brushing: 60 µm (2.4 mils)

Overcoating interval for DFT up to 75 µm (3.0 mils)							
Overcoating with...	Interval	5°C (41°F)	10°C (50°F)	15°C (59°F)	20°C (68°F)	30°C (86°F)	40°C (104°F)
SIGMAGUARD CSF 650, NOVAGUARD 840 or NOVAGUARD 890	Minimum	24 hours	20 hours	14 hours	8 hours	5 hours	3 hours
	Maximum	2 months	2 months	2 months	1 month	1 month	1 month

Note: Surface should be dry and free from any contamination

Curing time for DFT up to 75 µm (3.0 mils)		
Substrate temperature	Dry to handle	Full cure
5°C (41°F)	20 hours	10 days
10°C (50°F)	10 hours	7 days
20°C (68°F)	3 hours	5 days
40°C (104°F)	1 hour	3 days

Notes:

- Adequate ventilation must be maintained during application and curing (please refer to INFORMATION SHEETS 1433 and 1434)
- When used as a primer under solvent-free tank-linings the DFT must be limited to a maximum of 100 µm (4.0 mils)

Pot life (at application viscosity)	
Mixed product temperature	Pot life
5°C (41°F)	8 hours
10°C (50°F)	6 hours
15°C (59°F)	4 hours
20°C (68°F)	2 hours
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

## WARRANTY

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