

# SIGMAFAST™ 205 LT

## DESCRIPTION

Two-component, high-build, polyamide-cured zinc phosphate epoxy primer/coating

## PRINCIPAL CHARACTERISTICS

- General-purpose epoxy primer/coating for atmospheric conditions
- Good drying and curing property at low temperatures down to -5°C (23°F)
- Easy application by airless spray
- Recoatable with most two-component epoxy and polyurethane coatings
- Tough, with long-term flexibility

## COLOR AND GLOSS LEVEL

- A wide range of colors
- Semi-gloss

## BASIC DATA AT 10°C (50°F)

Data for mixed product	
<b>Number of components</b>	Two
<b>Mass density</b>	1.4 kg/l (11.7 lb/US gal)
<b>Volume solids</b>	70 ± 2%
<b>VOC (Supplied)</b>	Directive 1999/13/EC, SED: max. 213.0 g/kg UK PG 6/23(92) Appendix 3: max. 310.0 g/l (approx. 2.6 lb/US gal)
<b>Recommended dry film thickness</b>	75 - 150 µm (3.0 - 6.0 mils) depending on system
<b>Theoretical spreading rate</b>	9.3 m <sup>2</sup> /l for 75 µm (374 ft <sup>2</sup> /US gal for 3.0 mils) 4.7 m <sup>2</sup> /l for 150 µm (187 ft <sup>2</sup> /US gal for 6.0 mils)
<b>Dry to touch</b>	3 hours
<b>Overcoating Interval</b>	Minimum: 3 hours Maximum: 6 months
<b>Full cure after</b>	5 days
<b>Shelf life</b>	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™ 205 LT

## **Concrete**

- Dried for at least 28 days in good ventilation conditions
  - Moisture content should not exceed 4.5%
  - Concrete must be free from laitance and any contamination
  - Rough surface; eventually abraded by power tool or diamond abrading tool
- 

## **Substrate temperature**

- Substrate temperature during application and curing down to -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 75:25 (3:1)**

- 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
  - Thinner should be added after mixing the components
- 

## **Pot life**

6 hours at 10°C (50°F)

Note: See ADDITIONAL DATA – Pot life

---

## **Air spray**

### **Recommended thinner**

THINNER 91-92

### **Volume of thinner**

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

### **Nozzle orifice**

1.5 – 3.0 mm (approx. 0.060 – 0.110 in)

### **Nozzle pressure**

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

---

# SIGMAFAST™ 205 LT

## Airless spray

### Recommended thinner

THINNER 91-92

### Volume of thinner

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

### Nozzle orifice

Approx. 0.48 mm (0.019 in)

### Nozzle pressure

15.0 MPa (approx. 150 bar; 2176 p.s.i.)

## Brush/roller

### Recommended thinner

THINNER 91-92

### Volume of thinner

0 - 5%

## Cleaning solvent

THINNER 90-53

## ADDITIONAL DATA

Spreading rate and film thickness	
DFT	Theoretical spreading rate
75 µm (3.0 mils)	9.3 m <sup>2</sup> /l (374 ft <sup>2</sup> /US gal)
100 µm (4.0 mils)	7.0 m <sup>2</sup> /l (281 ft <sup>2</sup> /US gal)
150 µm (6.0 mils)	4.7 m <sup>2</sup> /l (187 ft <sup>2</sup> /US gal)

Overcoating interval for DFT up to 75 µm (3.0 mils)						
Overcoating with...	Interval	-5°C (23°F)	0°C (32°F)	5°C (41°F)	10°C (50°F)	20°C (68°F)
various two-pack epoxy and polyurethane coatings	Minimum	22 hours	16 hours	5 hours	3 hours	2 hours
	Maximum	6 months	6 months	6 months	6 months	6 months

Note: Surface should be dry and free from any contamination

# SIGMAFAST™ 205 LT

Overcoating interval for DFT up to 150 µm (6.0 mils)						
Overcoating with...	Interval	-5°C (23°F)	0°C (32°F)	5°C (41°F)	10°C (50°F)	20°C (68°F)
various two-pack epoxy and polyurethane coatings	Minimum	24 hours	18 hours	6 hours	4 hours	3 hours
	Maximum	6 months	6 months	6 months	6 months	6 months

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 touch	Dry to handle	Full cure
-5°C (23°F)	18 hours	21 hours	20 days
0°C (32°F)	15 hours	18 hours	12 days
5°C (41°F)	4 hours	7 hours	6 days
10°C (50°F)	3 hours	5 hours	5 days
20°C (68°F)	2 hours	3 hours	48 hours

Curing time for DFT up to 150 µm (6.0 mils)			
Substrate temperature	Dry to touch	Dry to handle	Full cure
-5°C (23°F)	20 hours	24 hours	21 days
0°C (32°F)	16 hours	20 hours	14 days
5°C (41°F)	5 hours	8 hours	7 days
10°C (50°F)	4 hours	6 hours	6 days
20°C (68°F)	3 hours	4 hours	3 days

Note: Adequate ventilation must be maintained during application and curing

Pot life (at application viscosity)	
Mixed product temperature	Pot life
10°C (50°F)	6 hours
20°C (68°F)	4 hours
30°C (86°F)	1.5 hours

## 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

# SIGMAFAST™ 205 LT

## 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
• RELATIVE HUMIDITY – SUBSTRATE TEMPERATURE – AIR TEMPERATURE	INFORMATION SHEET	1650

## 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.

## 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.ppgmc.com](http://www.ppgmc.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.

