

# SIGMATHERM™ 350

## DESCRIPTION

Heat-resistant silicone/acrylic finish

## PRINCIPAL CHARACTERISTICS

- Excellent resistance against weathering
- A minimum drying time of 3 days at 20°C (68°F) should be allowed before exposure to heat
- Heat-resistant up to 350°C (660°F)
- To be used for the internal and external protection of steel surfaces
- Widely compatible with inorganic zinc primers

## COLOR AND GLOSS LEVEL

- White, aluminum (other colors available on request)
- Semi-gloss

## BASIC DATA AT 20°C (68°F)

Data for product	
<b>Number of components</b>	One
<b>Mass density</b>	White: 1.2 kg/l (10.0 lb/US gal) Aluminum: 1.1 kg/l (9.2 lb/US gal)
<b>Volume solids</b>	White: 39 ± 2% Aluminum: 42 ± 2%
<b>VOC (Supplied)</b>	Directive 2010/75/EU, SED: max. 492 g/kg (white) Directive 2010/75/EU, SED: max. 491 g/kg (aluminum) max. 590.0 g/l (approx. 4.9 lb/gal) (white) China GB 30981-2020 (tested) 598.0 g/l (approx. 5.0 lb/gal)
<b>Recommended dry film thickness</b>	25 - 30 µm (1.0 - 1.2 mils)
<b>Theoretical spreading rate</b>	White: 15.6 m <sup>2</sup> /l for 25 µm (626 ft <sup>2</sup> /US gal for 1.0 mils) Aluminum: 16.8 m <sup>2</sup> /l for 25 µm (674 ft <sup>2</sup> /US gal for 1.0 mils)
<b>Dry to touch</b>	1 hour
<b>Overcoating Interval</b>	Minimum: 18 hours Maximum: Unlimited
<b>Shelf life</b>	At least 24 months when stored cool and dry

## RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

### Substrate conditions

- Thermal aluminum sprayed steel or thermal zinc sprayed steel must be dry and free from any contamination
- Suitable coating (zinc silicate primer) must be dry, free from any contamination and zinc salts
- Steel; blast cleaned to a minimum of ISO-Sa2½, blasting profile 40 – 70 µm (1.6 – 2.8 mils)



# SIGMATHERM™ 350

## **Substrate temperature and application conditions**

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

## **INSTRUCTIONS FOR USE**

- By using a mist coat technique, it is possible to apply SIGMATHERM 350 on top of a zinc silicate primer
- Power agitate to uniform consistency

### **Air spray**

#### **Recommended thinner**

No thinner should be added

#### **Nozzle orifice**

1.5 – 2.0 mm (approx. 0.060 – 0.079 in)

#### **Nozzle pressure**

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

### **Airless spray**

#### **Recommended thinner**

No thinner should be added

#### **Nozzle orifice**

Approx. 0.38 – 0.48 mm (0.015 – 0.019 in)

#### **Nozzle pressure**

12.0 - 15.0 MPa (approx. 120 - 150 bar; 1741 - 2176 p.s.i.)

### **Brush/roller**

- Only for touch-up and spot repair

## **Cleaning solvent**

THINNER 21-06

## **ADDITIONAL DATA**

<b>Spreading rate and film thickness – White</b>	
<b>DFT</b>	<b>Theoretical spreading rate</b>
25 µm (1.0 mils)	15.6 m <sup>2</sup> /l (626 ft <sup>2</sup> /US gal)
30 µm (1.2 mils)	13.0 m <sup>2</sup> /l (521 ft <sup>2</sup> /US gal)

# SIGMATHERM™ 350

## Spreading rate and film thickness – Aluminum

DFT	Theoretical spreading rate
25 µm (1.0 mils)	16.8 m <sup>2</sup> /l (674 ft <sup>2</sup> /US gal)
30 µm (1.2 mils)	14.0 m <sup>2</sup> /l (561 ft <sup>2</sup> /US gal)

## Overcoating interval for DFT up to 30 µm (1.2 mils)

Overcoating with...	Interval	10°C (50°F)	20°C (68°F)	30°C (86°F)	40°C (104°F)
itself	Minimum	24 hours	18 hours	15 hours	10 hours
	Maximum	Unlimited	Unlimited	Unlimited	Unlimited

Note: Surface should be dry and free from any contamination

## Curing time for DFT up to 30 µm (1.2 mils)

Substrate temperature	Dry to touch	Dry to handle
10°C (50°F)	1.5 hours	3 hours
20°C (68°F)	1 hour	2 hours
30°C (86°F)	45 minutes	1.5 hours
40°C (104°F)	30 minutes	1 hour

Note: Adequate ventilation must be maintained during application and curing

## SAFETY PRECAUTIONS

- See Safety Data Sheet and product label for complete safety and precaution requirements
- 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

- EXPLANATION TO PRODUCT DATA SHEETS

INFORMATION SHEET

1411

# SIGMATHERM™ 350

## 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.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.

