

# SIGMACOVER™ 350 LT

## DESCRIPTION

Two-component, high-build polyamide cured epoxy primer/coating based upon pure epoxy technology

## PRINCIPAL CHARACTERISTICS

- Surface tolerant primer/coating for wide use in Marine and Protective Coatings
- Marine use: suitable on topsides, decks, superstructures and cargo holds
- Excellent corrosion resistance
- Compatible with various aged coatings
- Suitable as floor coating for pedestrian traffic with dry to walk on time of 8 hours at 10°C (50°F)
- Good impact and abrasion resistance
- Smooth film, easy to clean
- Cures at temperatures down to -5°C (23°F)

## COLOR AND GLOSS LEVEL

- Standard and custom colors, including aluminum
- For Cargo holds gray ( 5177 ) and redbrown ( 6179 ) only
- Semi-gloss

Note: Epoxy coatings will chalk and fade upon exposure to sunlight, elevated temperatures, or chemical exposure. Discoloration and normal chalking does not impact performance. Light colors will darken over time. Some batch-to-batch variation in color is to be expected. Color matches are approximate.

## BASIC DATA AT 10°C (50°F)

Data for mixed product	
Number of components	Two
Mass density	1.4 kg/l (11.7 lb/US gal)
Volume solids	72 ± 2%
VOC (Supplied)	Directive 2010/75/EU, SED: max. 264.0 g/kg max. 361.0 g/l (approx. 3.0 lb/US gal)
Recommended dry film thickness	100 - 150 µm (4.0 - 6.0 mils) for airless spray
Theoretical spreading rate	5.8 m²/l for 125 µm (231 ft²/US gal for 5.0 mils) 4.8 m²/l for 150 µm (192 ft²/US gal for 6.0 mils)
Dry to touch	4 hours
Overcoating Interval	Minimum: 8 hours Maximum: 14 days
Full cure after	7 days

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**Data for mixed product****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

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**RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES****Substrate conditions**

- Steel; blast cleaned to ISO-Sa2½ for excellent corrosion protection, blasting profile 40 – 70 µm (1.6 – 2.8 mils)
- Steel; blast cleaned to ISO-Sa2, blasting profile 40 – 70 µm (1.6 – 2.8 mils) or power tool cleaned to ISO-St2 for good corrosion protection
- Previous coat must be dry and free from any contamination
- Previous coat: surface should be sufficiently roughened if necessary
- At freezing temperatures surface must be free from ice

**Substrate conditions of concrete for thinned version**

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

**Coated concrete**

- Existing sound coating systems; sufficiently roughened, dry and cleaned
- To ensure compatibility, rub the existing coating with a cloth with Xylene or MEK for 10 seconds, and remove existing coatings if dissolving occurs
- Rough surface; eventually abraded by power tool or diamond abrading tool

**Substrate temperature and application conditions**

- Substrate temperature during application and curing should be between -5°C (23°F) and 15°C (59°F)
- Substrate temperature during application and curing should be at least 3°C (5°F) above dew point

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**SYSTEM SPECIFICATION**

- SIGMACOVER 350 LT: 2 x 125 µm (5.0 mils) DFT
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## 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 5°C (41°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
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### **Pot life**

3 hours at 10°C (50°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**

1.8 - 2.0 mm (approx. 0.070 - 0.079 in)

#### **Nozzle pressure**

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

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### **Airless spray**

#### **Recommended thinner**

THINNER 91-92

#### **Volume of thinner**

0 - 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****Recommended thinner**

THINNER 91-92

**Volume of thinner**

0 – 5%

**Cleaning solvent**

THINNER 91-92

**ADDITIONAL DATA****Spreading rate and film thickness**

DFT	Theoretical spreading rate
100 µm (4.0 mils)	7.2 m <sup>2</sup> /l (289 ft <sup>2</sup> /US gal)
125 µm (5.0 mils)	5.8 m <sup>2</sup> /l (231 ft <sup>2</sup> /US gal)
150 µm (6.0 mils)	4.8 m <sup>2</sup> /l (192 ft <sup>2</sup> /US gal)

Note: Maximum DFT when brushing: 100 µm (4.0 mils)

**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)	15°C (59°F)
epoxy coatings	Minimum	36 hours	24 hours	12 hours	8 hours	6 hours
	Maximum	28 days	28 days	28 days	14 days	10 days
polyurethanes	Minimum	3 days	48 hours	24 hours	16 hours	12 hours
	Maximum	28 days	28 days	21 days	10 days	7 days

Note: Surface should be dry and free from any contamination and ice

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**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)	24 hours	32 hours	16 days
0°C (32°F)	16 hours	20 hours	12 days
5°C (41°F)	8 hours	10 hours	9 days
10°C (50°F)	4 hours	6 hours	7 days
15°C (59°F)	2 hours	4 hours	4 days

**Notes:**

- For cargo hold application: for full cure for hard angular cargoes, please contact your nearest PPG Protective & Marine Coatings sales office
- Adequate ventilation must be maintained during application and curing
- Should SIGMACOVER 350 LT or the total coating system (2 x 125 µm/2 x 5.0 mils) be applied in excess of the specified dry film thickness, then the time necessary to reach full cure will be increased

**Pot life (at application viscosity)**

Mixed product temperature	Pot life
10°C (50°F)	3 hours
15°C (59°F)	2 hours

**SAFETY PRECAUTIONS**

- See Material 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

**WARRANTY**

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