

SIGMAFAST™ 20

DESCRIPTION

High-build zinc phosphate primer, based on modified alkyd resin

PRINCIPAL CHARACTERISTICS

- Good anticorrosive properties under atmospheric conditions
- Fast-drying
- Fast-handling
- Recoatable with most one- and two-component coatings
- Suitable for atmospheric exposure conditions
- Lead- and chromate free
- Can be specified as a single coat, direct-to-metal system for ISO 12944 C1 and C2 environments

COLOR AND GLOSS LEVEL

- Redbrown, gray (other (RAL) colors available on request)
- Flat

BASIC DATA AT 20°C (68°F)

Data for mixed product	
Number of components	One
Mass density	1.5 kg/l (12.5 lb/US gal)
Volume solids	55 ± 2%
VOC (Supplied)	Directive 2010/75/EU, SED: max. 258.0 g/kg UK PG 6/23(92) Appendix 3: max. 382.0 g/l (approx. 3.2 lb/US gal)
Recommended dry film thickness	50 - 75 µm (2.0 - 3.0 mils) per coat
Theoretical spreading rate	7.3 m ² /l for 75 µm (294 ft ² /US gal for 3.0 mils)
Dry to touch	15 minutes
Overcoating Interval	Minimum: 45 minutes
Shelf life	At least 24 months when stored cool and dry

Note: See ADDITIONAL DATA – Overcoating intervals

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

Substrate conditions

- Steel; blast cleaned to ISO-Sa2½
- Steel; power tool cleaned to min. ISO-St2
- Shop primed steel; sweep blasted or power tool cleaned to SPSS-Ss or SPSS-Pt2



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Substrate temperature

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

- Stir well before use
 - The temperature of the paint 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
 - Adequate ventilation must be maintained during application and curing (please refer to INFORMATION SHEETS 1433 and 1434)
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Air spray

Recommended thinner

THINNER 21-06

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

0.4 MPa (approx. 4 Bar; 51 p.s.i.)

Airless spray

Recommended thinner

THINNER 21-06

Volume of thinner

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

Nozzle orifice

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

Nozzle pressure

12.0 - 16.0 MPa (approx. 120 - 160 bar; 1741 - 2321 p.s.i.)

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Brush/roller

Recommended thinner

THINNER 20-05

Volume of thinner

0 – 2%

Cleaning solvent

THINNER 21-06

ADDITIONAL DATA

Overcoating interval for DFT up to 75 µm (3.0 mils)				
Overcoating with...	Interval	10°C (50°F)	15°C (59°F)	20°C (68°F)
two-component products: SIGMACOVER 456, SIGMACOVER 435 or SIGMADUR 520	Minimum	12 hours	10 hours	8 hours
	Maximum	Unlimited	Unlimited	Unlimited
alkyd-based products (e.g. SIGMAFAST 20 and SIGMAFAST 40)	Minimum	1.5 hours	1 hour	45 minutes
	Maximum	Unlimited	Unlimited	Unlimited

Note: Surface should be dry and free from any contamination

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.

SIGMAFAST™ 20

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

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