

**(SPECIFICATION FOR HIGHWAYS WORKS)
FORM HA/P2 PAINT DATA SHEET**
**Item 110
Sigma EP 110 Primer**

July 2014

BBA HAPAS Road & Bridges Certificate Reference & Date :	07/H124 Sheet 9, 19 th May 2014	
Manufacturer :	PPG Protective & Marine Coatings	
Item No. :	Item 110	
Registered Description :	Two pack zinc phosphate, epoxy blast primer / sealer.	
Brand Name & Reference No. :	Sigma EP 110 Primer – 0660 UK	
Consistency & Method of Application :	Airless Spray or Brush / Roller (for small areas)	
Weight per 20 Litres (kg) :	28 kg	
Specific Gravity (g/cm³) For Two Pack Paints :	Colour: Approximate BS4800 : 08C35	
Base : 1.45 – 1.50	Activator : 0.88 – 0.94	Mixed Components : 1.32 – 1.38
Volume Solids % For two pack paints volume solids % for mixed paint :	43%	
VOC Content g/l (mixed) :	544 g/l	
Manufacturers Minimum Dry Film Thickness Range		
Recommended lower mdft :	25 µm	
Recommended upper mdft :	35 µm	
Full Application Instructions :	Mix base and activator together 3:1 by volume, pot-life 8 hours. Apply by Airless spray. Tip size 0.43-0.58mm (0.017-0.023 in), pressure 120-150 Bar.	
Mix Ratio :	3: 1 base to activator by volume	
Flash Point :	Base 23°C Activator 23°C	

		10°C	20°C	30°C
Drying Times (hours)	Surface Dry	40 mins	20 mins	15 mins
	Hard Dry	2 hours	1 hour	30 mins
Overcoating Times (hours)	Minimum	8 hours	4 hours	3 hours
	Maximum	3 months	3 months	2 months
Pot Life (hours)		10 hours	8 hours	4 hours

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Cleaning Solvent	:	Thinner 90-53
State effects on Drying Times of Temperatures below 20°C	:	Drying times below 20°C will be extended in line with the table on page 1
Manufacturers Application Restrictions, e.g. for Temperatures or Humidity	:	Substrate temperature should be above 5°C during application and curing and at least 3°C above the dew point. Maximum relative humidity is 85%.
Manufacturers General Recommendations	:	Approved for use in SHW Series 1900 as detailed on HAPAS Certificate 07/H124 Product Sheet 99 - 19 th May 2014

LIMITATION OF LIABILITY

The information in this data sheet is based upon laboratory tests we believe to be accurate and is intended for guidance only. All recommendations or suggestions relating to the use of the products made by PPG Protective & Marine Coatings, whether in technical documentation, or in response documentation, or in response to a specific enquiry, or otherwise, are based on data which to the best of our knowledge are reliable. The products and information are designed for users having the requisite knowledge and industrial skills and it is the end-user's responsibility to determine the suitability of the product for its intended use.

PPG Protective & Marine Coatings has no control over either the quality or condition of the substrate, or the many factors affecting the use and application of the product. PPG Protective & Marine Coatings does therefore not accept any liability arising from loss, injury or damage resulting from such use or the contents of this data sheet (unless there are written agreements stating otherwise).

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The English text of this document shall prevail over any translation thereof.

