

# SIGMACOVER™ 480

## DESCRIPTION

Two-component, chemical-resistant finish, based on polyamide cured epoxy resins

## PRINCIPAL CHARACTERISTICS

- General-purpose epoxy finish
- Easy application by brush/roller and (airless) spray
- Good water resistance
- Good chemical resistance to spillage and splash
- Resistant to impact and abrasion
- Easy to clean

## COLOR AND GLOSS LEVEL

- Selected range of colors available
- Semi-gloss

## BASIC DATA AT 20°C (68°F)

Data for mixed product	
Number of components	Two
Mass density	1.4 kg/l (11.7 lb/US gal)
Volume solids	50 ± 2%
VOC (Supplied)	Directive 1999/13/EC, SED: max. 308.0 g/kg max. 418.0 g/l (approx. 3.5 lb/US gal)
Recommended dry film thickness	50 µm (2.0 mils)
Theoretical spreading rate	10.0 m <sup>2</sup> /l for 50 µm (401 ft <sup>2</sup> /US gal for 2.0 mils)
Dry to touch	30 minutes
Overcoating Interval	Minimum: 8 hours Maximum: 3 months
Full cure after	7 days
Shelf life	Base: at least 12 months when stored cool and dry Hardener: at least 12 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

- Previous coat must be dry and free from any contamination
  - Previous coat: surface should be sufficiently roughened if necessary
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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

### Mixing ratio by volume: base to hardener 76:24

- The temperature of the mixed base and hardener should be above 10°C (50°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
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### Pot life

8 hours at 20°C (68°F)

Note: See ADDITIONAL DATA – Pot life

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### Air spray

#### **Recommended thinner**

THINNER 91-92

#### **Volume of thinner**

10 - 15%, depending on required thickness and application conditions

#### **Nozzle orifice**

2.0 mm (approx. 0.079 in)

#### **Nozzle pressure**

0.3 MPa (approx. 3 Bar; 44 p.s.i.)

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## Airless spray

### Recommended thinner

THINNER 91-92

### Volume of thinner

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

### Nozzle orifice

Approx. 0.46 mm (0.018 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
40 µm (1.6 mils)	12.5 m <sup>2</sup> /l (501 ft <sup>2</sup> /US gal)
50 µm (2.0 mils)	10.0 m <sup>2</sup> /l (401 ft <sup>2</sup> /US gal)
60 µm (2.4 mils)	8.3 m <sup>2</sup> /l (334 ft <sup>2</sup> /US gal)

Overcoating interval for DFT up to 50 µm (2.0 mils)						
Overcoating with...	Interval	5°C (41°F)	10°C (50°F)	20°C (68°F)	30°C (86°F)	40°C (104°F)
itself	Minimum	36 hours	24 hours	12 hours	8 hours	6 hours
	Maximum	3 months	3 months	3 months	2 months	2 months

Note: Surface should be dry and free from chalking and contamination

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## Curing time for DFT up to 50 µm (2.0 mils)

Substrate temperature	Dry to touch	Dry to handle	Full cure
5°C (41°F)	4 hours	12 hours	21 days
10°C (50°F)	2 hours	8 hours	14 days
15°C (59°F)	1 hour	6 hours	10 days
20°C (68°F)	30 minutes	4 hours	7 days
30°C (86°F)	30 minutes	3 hours	5 days

Note: Adequate ventilation must be maintained during application and curing (please refer to INFORMATION SHEETS 1433 and 1434)

## Pot life (at application viscosity)

Mixed product temperature	Pot life
15°C (59°F)	12 hours
20°C (68°F)	8 hours
30°C (86°F)	5 hours
40°C (104°F)	3 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

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

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