

# SIGMA AQUACOVER 20

3 pages

September 2009  
Revision of April 2007

<b>DESCRIPTION</b>	one component water borne high build zinc phosphate primer/coating based on acrylic dispersion
<b>PRINCIPAL CHARACTERISTICS</b>	<ul style="list-style-type: none"> <li>- particularly suitable when solvents are not permitted because of health and safety reasons</li> <li>- excellent adhesion to well pretreated steel</li> <li>- good anticorrosive properties</li> <li>- fast drying</li> <li>- can be overcoated with most water borne acrylics, water borne epoxy coatings and alkyd paints as well as certain solvent borne two component products</li> </ul>
<b>COLOURS AND GLOSS</b>	RAL colours (other colours available on request) - flat
<b>BASIC DATA AT 20°C</b>	(1 g/cm <sup>3</sup> = 8.25 lb/US gal; 1 m <sup>2</sup> /l = 40.7 ft <sup>2</sup> /US gal)
Mass density	1.3 g/cm <sup>3</sup>
Volume solids	43 ± 2%
VOC (supplied)	max. 19 g/kg (Directive 1999/13/EC, SED) max. 25 g/l (approx. 0.2 lb/gal)
Recommended dry film thickness	75 µm per coat
Theoretical spreading rate	5.7 m <sup>2</sup> /l for 75 µm
Touch dry after	30 minutes
Overcoating interval	min. 4 hours max. unlimited
Shelf life (cool and dry place)	at least 12 months
<b>RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES</b>	<ul style="list-style-type: none"> <li>- steel; blast cleaned to ISO-Sa2½, blasting profile 40 - 70 µm</li> <li>- steel; pretreated according to ISO-St3</li> <li>- shop primed steel; sweep blasted or power tool cleaned to SPSS-Ss or SPSS-Pt2</li> <li>- substrate temperature should be at least 5°C and at least 3°C above dew point during application and curing</li> <li>- maximum relative humidity during application and curing is 75%</li> </ul>
<b>INSTRUCTIONS FOR USE</b>	<ul style="list-style-type: none"> <li>- stir well before use</li> <li>- the temperature of the paint should preferably be above 15°C, otherwise extra tap water may be required to obtain application viscosity</li> <li>- too much tap water results in reduced sag resistance</li> <li>- must be protected from freezing at all times during storage and/or transport</li> </ul>
<b>AIRLESS SPRAY</b>	
Recommended thinner	tap water
Volume of thinner	0 - 5%, depending on required thickness and application conditions
Nozzle orifice	approx. 0.46 - 0.53 mm (= 0.018 - 0.021 in)
Nozzle pressure	12 - 15 MPa (= approx. 120 - 150 bar; 1700 - 2130 p.s.i.)

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## AIR SPRAY

Recommended thinner tap water  
 Volume of thinner 5 - 10%, depending on required thickness and application conditions  
 Nozzle orifice 1.8 - 2 mm  
 Nozzle pressure 0.3 - 0.4 MPa (= approx. 3 - 4 bar; 43 - 57 p.s.i.)

## BRUSH/ROLLER \*

Recommended thinner long haired brush or polyether roller with rounded edges  
 Volume of thinner tap water  
 0 - 5%  
 \* for localised areas of difficult access only

## CLEANING SOLVENT

tap water and Thinner 70-05

Cleaning Procedures of the spray equipment:  
 pulsator filter and tip filter must be taken out of the equipment and cleaned properly

following tables illustrate the cleaning procedure of the spray equipment when changing spraying from solvent borne paint to water borne paints (table 1) and from water borne paints to solvent borne paints (table 2)

## CLEANING PROCEDURE

**Table 1: from solvent borne- to water borne paints**

1st cleaning	with Thinner 90-53
2nd cleaning	with Thinner 70-05
3rd cleaning	with warm tap water (30 - 35°C) after which water borne paints can be sprayed

**Table 2: from water borne- to solvent borne paints**

1st cleaning	with warm tap water (30 - 35°C)
2nd cleaning	with Thinner 70-05
3rd cleaning	with Thinner 90-53

Thinner 70-05 can be re-used

## SAFETY PRECAUTIONS

for paint and recommended thinners see safety sheets 1430, 1431 and relevant material safety data sheets

although this is a water borne paint, care should be taken to avoid inhalation of spray mist or vapour as well as contact between the wet paint and exposed skin or eyes

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## ADDITIONAL DATA

### Overcoating table for Sigma Aquacover 20 for dft up to 75 µm

with water borne acrylic and alkyd finishes

substrate temperature	5°C	10°C	20°C	30°C
minimum interval	16 hours	6 hours	4 hours	3 hours
maximum interval	unlimited	unlimited	unlimited	unlimited

– surface should be dry and free from any contamination

## Worldwide availability

Whilst it is always the aim of PPG Protective & Marine Coatings to supply the same product on a worldwide basis, 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	see information sheet 1411
Safety indications	see information sheet 1430
Safety in confined spaces and health safety	
Explosion hazard - toxic hazard	see information sheet 1431
Cleaning of steel and removal of rust	see information sheet 1490

## 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 Sigma Coatings products made by PPG Protective & Marine Coatings, whether in technical 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).

The data contained herein are liable to modification as a result of practical experience and continuous product development.

This data sheet replaces and annuls all previous issues and it is therefore the user's responsibility to ensure that this sheet is current prior to using the product.

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

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