

# SIGMAFAST 20

3 pages

 March 2010  
 Revision of September 2009

<b>DESCRIPTION</b>	high build zinc phosphate primer based on modified alkyd resin
<b>PRINCIPAL CHARACTERISTICS</b>	<ul style="list-style-type: none"> <li>- good anticorrosive properties under atmospheric conditions</li> <li>- fast drying</li> <li>- fast handling</li> <li>- recoatable with most one and two component coatings</li> <li>- suitable for atmospheric exposure conditions</li> <li>- lead- and chromate free</li> </ul>
<b>COLOURS AND GLOSS</b>	redbrown, grey (other (RAL) colours 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	1.5 g/cm <sup>3</sup>
Volume solids	55 ± 2%
VOC (supplied)	max. 258 g/kg (Directive 1999/13/EC, SED) max. 382 g/l (approx. 3.2 lb/gal)
Recommended dry film thickness	50 - 75 µm per coat
Theoretical spreading rate	11.0 m <sup>2</sup> /l for 50 µm, 7.3 m <sup>2</sup> /l for 75 µm
Touch dry after	15 minutes
Overcoating interval	min. 4 hours for 75 µm dft * at higher dft's drying time will be longer
Shelf life (cool and dry place)	at least 12 months * see additional data
<b>RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES</b>	<ul style="list-style-type: none"> <li>- steel; blast cleaned to ISO-Sa2½</li> <li>- steel; power tool cleaned to min. ISO-St2</li> <li>- shop primed steel; sweep blasted or power tool cleaned to SPSS-Ss or SPSS-Pt2</li> <li>- substrate temperature should be above 5°C and at least 3°C above dew point</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 thinner may be required to obtain application viscosity</li> <li>- too much solvent results in reduced sag resistance</li> <li>- adequate ventilation must be maintained during application and curing (please refer to sheets 1433 and 1434)</li> </ul>
<b>AIRLESS SPRAY</b>	
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 - 16 MPa (= approx. 120 - 160 bar; 1700 - 2270 p.s.i.)

# SIGMAFAST 20

March 2010

## AIR SPRAY

Recommended thinner Thinner 21-06  
 Volume of thinner 5 - 10%, depending on required thickness and application conditions  
 Nozzle orifice 1.8 - 2 mm  
 Nozzle pressure 0.35 MPa (= approx. 3.5 bar; 50 p.s.i.)

## BRUSH/ROLLER

Recommended thinner Thinner 20-05  
 Volume of thinner 0 - 2%

## CLEANING SOLVENT

Thinner 21-06

## SAFETY PRECAUTIONS

for paint and recommended thinners see safety 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 vapour as well as contact between the wet paint and exposed skin or eyes

## ADDITIONAL DATA

with alkyd based products  
 (e.g. SigmaFast 20 and 40)

### Overcoating table for SigmaFast 20 for dft up to 75 µm

substrate temperature	10°C	15°C	20°C
minimum interval	75 min.	60 min.	45 min.
maximum interval	unlimited	unlimited	unlimited

– surface should be dry and free from any contamination

with two component products:  
 SigmaCover 456, SigmaCover 435, SigmaDur 520

### Overcoating table for SigmaFast 20 for dft up to 75 µm

substrate temperature	10°C	15°C	20°C
minimum interval	12 hours	10 hours	8 hours
maximum interval	unlimited	unlimited	unlimited

– surface should be dry and free from any contamination

## SIGMAFAST 20

March 2010

**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
Safe working in confined spaces	see information sheet 1433
Directives for ventilation practice	see information sheet 1434
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.

	PDS	7155
178249	redbrown	2008002200
181056	grey	7035262200
179897	base L	0710002194
179898	base Z	0070002158